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- (54) Benævnelse: **FAMILIER AF KEDELSTENSHÆMMERE MED FORSKELLIGE ABSORPTIONSPROFILER OG DERES ANVENDELSE I OLIEFELTER**
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DESCRIPTION

[0001] The current invention relates to families of scale-inhibitors having different UV/VIS absorption profiles, which may be used in a method for imparting scale inhibition in an oilfield, especially for providing an enhanced scale inhibition during secondary oil recovery.

[0002] In oil recovery and, more importantly, in secondary oil recovery (where a fluid, preferably a water-based fluid, such as sea water, is injected into an oil well in order to displace the crude oil), inorganic deposits of scale may cause blockage of pipework and the pores in the oil-bearing strata, thus reducing or even preventing the flow of oil. Thus, the scale decreases oil recovery yields.

[0003] Current methods for inhibiting formation of inorganic deposits of scale employ compounds containing phosphorus, usually polymers of the carboxylic acid, sulfonic acid, or phosphonic type.

[0004] For example, organic phosphonic acids are described in US Patent 6,063,289 and US Patent 6,123,869. Acrylic polymers containing a phosphinate or phosphonate group can also be used, for example a copolymer of methacrylic acid with phosphate functionality for treating industrial water (US 4,209,398). US patent 6071434 teaches the use as scale inhibitors of polymers prepared by copolymerisation of Sodium Vinyl Sulphonate (SVS) and Acrylic acid (AA) in the presence of a transfer agent. This polymer has been developed as a scale inhibitor for squeeze treatment of oilfields. Patent WO2003/029153 describes compositions for inhibition of inorganic deposits in the petroleum sector by means of terpolymers having a phosphate monomer, methallyl hydroxy phosphate. EP 0 861 846 describes the reaction of compounds of the formula $X_2O_3PCHYCZ_2$ with hypophosphorous acid in the presence of free radicals to provide compounds $X_2O_3PCHYCZ_2PO_2XH$. These react with monomers to form telomers useful for scale inhibition, especially barium scale in oil wells.

[0005] Treatment levels up to a few hundred parts per million (ppm) are usually effective. The scale-inhibiting polymer is typically added to the fluid to be treated or may be applied to oil bearing formations by means of "squeeze treatment". Squeeze treatment involves pumping scale inhibitor into an oil production well so that the inhibitor enters the formation rock and is retained there. When the well is put back into production, the produced fluids are treated by the scale inhibitor which leaches out of the formation rock. Thus the scale inhibitor is released in a fluid. The scale inhibitor may be applied in an aqueous or non-aqueous medium. The objective is to prevent or control the scale formation in systems wherein the fluid is used.

[0006] Scale formation is only controlled if the scale inhibitor polymer is present at a treatment level within the product's defined effective range, for example of the minimum inhibitor concentration (MIC) of the specific system (water + scale inhibitor). During production, when the inhibitor has been released, for example by consumption, there is a need for re-squeezing. With squeeze treatment, the concentration of the scale inhibitor in the produced fluids will diminish over time till a repeat "re-squeeze" operation is necessary. Also, scale inhibitor may be lost through, e.g. absorption or degradation. Hence, there is a need to replenish the scale inhibitor to replace this loss. Below the effective range of concentration of the polymer, effective scale control will not be maintained resulting in scale build up, the consequences of which is often catastrophic in this application. Overall, it can be seen that the concentration of scale inhibitor in the treated fluids is vitally important and chemical analysis of scale control polymers has always been difficult at ppm levels.

[0007] The problem of analysis has recently become more difficult in sub sea oilfields because of sub sea completions where several individual wells are communed on the seabed and the combined fluids are piped to the nearest production platform which may be several tens of miles away. In that configuration, if the oil yield decreases in the recovered combined fluid, it is not possible to determine the particular well that has too much scale, and/or to determine the well wherein scale inhibitor should be added. Because of that it is sometimes necessary to stop the production for all the wells, or to add too much scale inhibitor (for example by adding too much scale inhibitor in a well wherein less is needed). That decreases the global productivity and/or is not cost effective.

[0008] A solution to that problem of decreasing global productivity is described in EP 1639228 (also published as WO2005/001241) teaching a production method by injecting an inflow stream of a fluid into an oil producing well linked to the oilfield, displacing the oil and recovering an outflow stream of fluid comprising the oil, wherein at least two streams are injected into at least two production zones of an oil well or are injected into at least two different oil producing wells from which at least two outflow streams from the two zones or wells are combined before recovering, with a scale inhibitor having detectable moieties being introduced into the oilfield(s) and/or into the fluids, characterized in that two different scale inhibitors are used, dedicated to the two zones or wells, said different scale inhibitors having different detectable moieties that can be distinguished by analyzing.

These operations are also referred to as a production method, the individual determination of at least 2 returned inhibitor concentrations allows the improved management of scale in multiple zones, opening up the possibility of squeezing the different zones independently when each inhibitor drops to a defined concentration.

[0009] Although the EP 1639228 method constitutes a great improvement *per se*, this method reveals, in practice, difficult to be carried out. Especially, there is a need of inhibitor polymers presenting sufficiently different spectroscopic absorption profiles.

[0010] One aim of the current invention is to provide a method for inhibiting inorganic deposits in a petroleum reservoir allowing to solve the problem of decreasing global productivity in a better way than the method generally disclosed in EP 1639228.

[0011] To this end, the instant invention proposes to make use, in a method of the type disclosed in EP 1639228, of specific scale inhibitor polymers of two distinct families which actually have different absorption profiles in UV/VIS spectroscopy. More precisely, the invention makes use of polymers having different detectable moieties by means of distinct absorption maxima, so that they can be distinguished by analyzing by means of absorption analytical methods such as UV/VIS spectroscopy.

[0012] In this scope, the invention provides two families of polymers having different absorption profiles in UV/VIS spectroscopy and having good antiscale properties. A method for the preparation of such polymers is also described but not claimed.

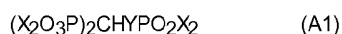
[0013] More precisely, according to a first aspect, the invention as claimed provides a method for imparting scale inhibition in an oilfield, the method comprising the steps of:

1. a) injecting at least two inflow streams of a fluid into at least two production zones of an oil producing well linked to the oilfield, or into at least two different oil producing wells, wherein scale inhibitor is introduced into the oilfield and/or into the fluid, so as to be present in the two zones or wells, and wherein two different scale inhibitors are used, each dedicated to one of the two zones or wells, said different scale inhibitors having different moieties that are detectable, such that these two different scale inhibitors have distinct absorption maxima that can be determined by an absorption analytical method, meaning that the scale inhibitors can be distinguished from one another by means of said absorption analytical method;
2. b) displacing oil from the oil producing well;
3. c) recovering an outflow stream of fluid comprising the oil; and
4. d) measuring the amounts of the different scale inhibitors in the recovered stream of fluid, or in a fluid that has been derived from the recovered stream of fluid, by said absorption analytical method;

wherein at least two outflow streams, one from each of the two zones or one from each of the two wells, are combined before the recovering step c)

wherein :

- one of the two scale inhibitors is a polymer (P1) as obtained by polymerization of:
- an ethylenically unsaturated carboxylic monomer ;
 - an ethylenically unsaturated sulphonic acid monomer or water soluble salts thereof;
 - a styrene monomer, which can optionally be substituted by one to three groups, which may be identical or different, in the presence of a hypophosphorous adduct of the formula (A1):



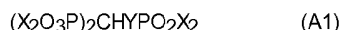
wherein :

X is H, or an alkali metal, or ammonium,

Y is an alkylene group, which is linear or branched, having 1 to 5 carbon atoms;

and

- the other scale inhibitor is a polymer (P2) as obtained by polymerization of :
 - an ethylenically unsaturated carboxylic monomer;
 - an ethylenically unsaturated sulphonic acid monomer or water soluble salts thereof;
 - a vinyl heteroaromatic monomer comprising at least one heteroatom selected from N, P or O, which can be substituted by at least one hydrocarbon group having 1 to 6 carbon atoms, and optionally containing functional groups such as sulphate, carboxylate, phosphonate and/or phosphinate,
- in the presence of an hypophosphorous adduct of the formula (A1):



wherein :

X is H or an alkali metal or ammonium,

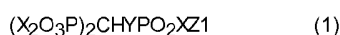
Y is an alkylene group linear or branched having 1 to 5 carbon atoms, wherein the hypophosphorous adducts of the formula (A1) may be identical or may be distinct.

[0014] In the scope of the instant invention, the inventors have now found that polymers (P1) and (P2) as defined herein-above define two distinct families of polymers which are efficient scale inhibitors with distinct spectroscopic absorption profiles.

[0015] More precisely, the family of the polymers (P1) have absorption maxima of less than 240 nm (usually between 215 and 240 nm) without any maxima over 240 nm, whilst the family of polymer (P2) has absorption maxima of more than 240 nm (commonly between 240 and 400nm), with an absorption profile at less than 240 nm which is distinct from the absorption profile of the family of the polymers (P1).

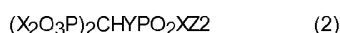
[0016] In step (a) of the process, at least two inflow streams are injected into at least two production zones of an oil producing well linked to the oilfield, or into at least two different oil producing wells from which at least two outflow streams from the two zones or wells are combined, before recovering, with a scale inhibitor having detectable moieties being introduced into the oilfield(s) and/or into the fluid, wherein at least two different scale inhibitors are used, each dedicated to one of the two zones or wells, said different scale inhibitors having different detectable moieties. According to a specific embodiment, at least three inflow streams with at least three different scale inhibitors may be used, each dedicated to one of the zones or wells. For example, three, four or five inflow streams (preferably 3 or 4) with respectively three, four or five different scale inhibitors are used.

[0017] The polymers (P1) have the average general formula : (1)



wherein X, Y have the significations given above and Z1 is the polymer chain resulting from the polymerisation of the ethylenically unsaturated carboxylic monomer; the ethylenically unsaturated sulphonic acid monomer or water soluble salts thereof; and the styrene monomer which can be substituted by one to three groups that may be identical or different, in the presence of the adduct (A1). The presence of the styrene units induces an absorption of less than 240 nm. When the styrene monomer is substituted by one to three groups, those substituent groups are selected so that they do not confer to the polymer (P1) an absorption above 240 nm.

[0018] The polymers (P2) have the average general formula (2) :

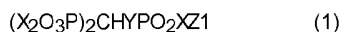


wherein X, Y have the significations given above and Z2 is the polymer chain resulting from the polymerisation of the ethylenically unsaturated carboxylic monomer; the ethylenically unsaturated sulphonic acid monomer or water soluble salts thereof; and the vinyl heteroaromatic monomer comprising at least one heteroatom selected from N, P or O, which can be substituted by at least one hydrocarbon group having 1 to 6 carbon atoms, and optionally containing functional groups such as sulphate, carboxylate, phosphonate and/or phosphinate, in the presence of the adduct (A1).

[0019] The presence of the vinyl heteroaromatic units induces at least an absorption maximum of more than 240 nm. When the vinyl heteroaromatic monomer is substituted by optionally functionalized hydrocarbon groups, these substituent groups are selected so that they do not jeopardize this absorption maximum at more than 240 nm.

[0020] According to another aspect, the instant invention relates to each of the two families of polymers (P1) and (P2) useful in the method described above.

[0021] Thus, on the one hand, the invention as claimed provides a polymer having an absorption maximum between 215 and 240 nm and having the average general formula (1):

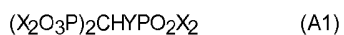


wherein

X is H, or an alkali metal, or ammonium,

Y is an alkylene group, which may be linear or branched, having 1 to 5 carbon atoms, and

Z1 is a polymer chain obtained by polymerization of an ethylenically unsaturated carboxylic monomer with an ethylenically unsaturated sulphonic acid monomer, or water soluble salts thereof, and a styrene monomer, which can be substituted by one to three groups that may be identical or different and which are selected to provide said absorption maximum, in the presence of a hypophosphorous adduct of the formula (A1):

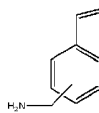
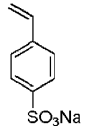
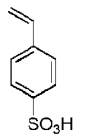
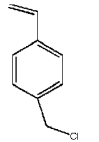
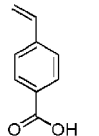


wherein X, Y have the same signification as in formula (1).

[0022] The substituting groups of the styrene monomer are preferably chosen from H, SO₃H, SO₃Na, NH₂, COOH, CH₂Cl and OH.

[0023] Examples of suitable styrenic monomers are gathered in the following table 1:

Table 1

Monomer	Abbreviation	Structure
Amino styrene	AS	
N,N-dimethyl-vinylbenzylamine	DMVBA	
Sodium styrene Sulphonate	NaSS	
Styrene Sulphonic acid	HSS	
4-Vinyl benzylchloride	4-VBC	
Styrene carboxylic acid	SCA	

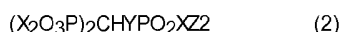
[0024] Examples of ethylenically unsaturated carboxylic monomers are acrylic acid, methacrylic acid, maleic acid, fumaric acid, itaconic acid, aconitic acid, mesaconic acid, citraconic acid, crotonic acid isocrotonic acid, angelic acid and tiglic acid.

[0025] Examples of ethylenically unsaturated sulphonic acid monomer are vinyl sulphonic acid, styrene-p-sulphonic acid, and 2-acrylamido-2-methyl propane sulphonic acid, (meth)allyl sulfonic acid, (meth)allyloxybenzene sulfonic acid, sodium 1-allyloxy 2 hydroxy propyl sulfonic acid, A preferred ethylenically unsaturated sulphonic acid monomer are vinyl sulfonic acids and their watersoluble salts, particularly sodium, ammonium and potassium.

[0026] The polymers of formula (1) can especially be prepared by the following preparation process comprising the steps of:

1. a) preparing the hypophosphorous adduct (A1) which is a tetrasodium alkylidene diphosphonate/hypophosphorous acid adduct prepared by addition of tetra-sodium alkylidene diphosphonate in an aqueous reaction medium at around 100 °C,
2. b) leaving under reflux the aqueous reaction medium and cooling it to room temperature, and
3. c) recovering the solution of the hypophosphorous adduct formed,
4. d) reacting said hypophosphorous adduct with an ethylenically unsaturated carboxylic monomer with an ethylenically unsaturated sulphonic acid monomer or water soluble salts thereof, and with a styrene monomer in the presence of sodium persulphate, and
5. e) recovering the polymer.

[0027] On the other hand, the invention as claimed provides a polymer having an absorption maximum between 240 and 400nm and having the average general formula (2):

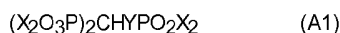


wherein

X is H, or an alkali metal, or ammonium,

Y is an alkylene group, which may be linear or branched, having 1 to 5 carbon atoms, and

Z₂ is a polymer chain obtained by polymerization of an ethylenically unsaturated carboxylic monomer with an ethylenically unsaturated sulphonic acid monomer, or water soluble salts thereof, and a vinyl heteroaromatic monomer, optionally substituted by one to three groups which may be identical or different and which are selected to provide said absorption maximum, in the presence of an hypophosphorous adduct of the formula (A1):



wherein X, Y have the same signification as in formula (2).

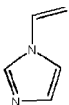
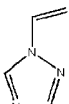
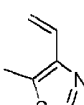
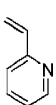
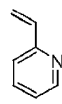
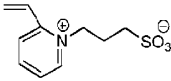
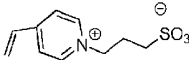
[0028] The polymer chain may be as obtained by polymerization of an ethylenically unsaturated carboxylic monomer with an ethylenically unsaturated sulphonic acid monomer or water soluble salts thereof and an unsaturated vinyl heteroaromatic monomer comprising at least one heteroatom selected from N, P or O which can be substituted by at least one hydrocarbon group having 1 to 6 carbon atoms and optionally containing functional groups such as sulphate, carboxylate, phosphonate and/or phosphinate.

[0029] The ethylenically unsaturated carboxylic monomer and the ethylenically unsaturated sulphonic acid monomers which may be present in polymers of formula (2) may be selected among the same as those useful to prepare the polymers of formula (1).

[0030] The skilled person will appreciate that the vinyl heteroaromatic monomer is an unsaturated heterocycle monomer. Preferred unsaturated heterocycle monomers are: 2-vinyl pyridine (2VP), 4-vinyl pyridine (4VP), 1-(3-Sulfopropyl)-2-vinylpyridinium betaine (2-SPV), 1-(3-Sulfopropyl)-4-vinylpyridinium betaine (4-SPV), 1-vinylimidazole (VI), 1-vinyl-1,2,4-triazole (VT), methyl vinyl triazole (MVT).

[0031] More particularly, the preferred unsaturated heterocycle monomers are those of formula gathered in table 2 below.

Table 2

Monomer	Abbreviation	Structure
1-vinylimidazole	VI	
1-vinyl-1,2,4-triazole	VT	
Methyl Vinyl Thiazole	MVT	
2-Vinyl pyridine	2VP	
4-Vinyl pyridine	4VP	
1-3- sulfopropyl-2-vinylpyridinium betaine	2SPV	
1-3-sulfopropyl-4-vinylpyridinium betaine	4SPV	

[0032] That second family of polymers of formula (2) can be prepared by means of the following preparation process comprising the steps of:

1. a) preparing the hypophosphorous adduct (A1) which is a tetrasodium alkylidene disphosphonate/hypophosphorous acid adduct prepared by addition of tetra-sodium alkylidene diphosphonate in an aqueous reaction medium at around 100°C,
 2. b) leaving under reflux the aqueous reaction medium and cooling it to room temperature, and
 3. c) recovering the solution of the hypophosphorous adduct formed,
 4. d) reacting said hypophosphorous adduct with an ethylenically unsaturated carboxylic monomer, with an ethylenically unsaturated sulphonic acid monomer or water soluble salts thereof, and with an unsaturated vinyl heteroaromatic monomer comprising at least one heteroatom selected from N, P or O which can be substituted by one or more alkyl groups having 1 to 6 carbon atoms, in the presence of hydrosoluble initiators such as persulphate, bromates, peroxides, perborates, perchlorates, and azo initiators. Sodium persulphate is one of the preferred initiators.
- and
5. e) recovering the polymer.

[0033] The polymers (P1) and (P2), (also referenced herein as "scale inhibitors of family (1) and (2)") may, in an embodiment which is disclosed but not claimed, be used alone or in admixture in squeeze treatment of oil wells.

[0034] As noted above, in the claimed method for imparting scale inhibition in an oilfield, two different scale inhibitors are used in the method, with one of the two scale inhibitors being the polymer (P1) and the other scale inhibitor being the polymer (P2).

[0035] The polymers (P1) and (P2) are especially effective in preventing barium sulphate scale and calcium, for example a

carbonate salt. For example in oil wells the hole is typically flushed out with aqueous surfactant to provide a water wettable surface and then impregnated with a solution of the inhibitor. In the case of calcium, the calcium salt may be formed in situ either by calcium in the formation, where the latter comprises limestone, or by prior, or subsequent, treatment of the hole with an aqueous calcium salt, for example carbonate, e.g. where the formation comprises sandstone.

[0036] Effective concentrations may typically range from 0.2 to 50 ppm, preferably 0.5 to 20 ppm depending on the nature of the aqueous system. For relatively soft water 1 to 20 ppm, most preferably 2 to 10 ppm, may give useful scale protection. Scale inhibitors of family (1) and (2) according to the invention may be used in conjunction with other water treatment agents including: surfactants, such as anionic surfactants (e.g. C10-20 alkyl benzene sulphonates, C10-20 olefin sulphonates, C10-20 alkyl sulphates, C10-20 alkyl 1 to 25 mole ether sulphates, C10-20 parafinsulphonates, C10-20 soaps, C10-20 alkyl phenol sulphates, sulphosuccinates, sulphosuccinamates, lignin sulphonates, fatty ester sulphonates, C10-20 alkyl phenyl ether sulphates, C10-20 alkyl ethanolamide sulphates, C10-20 alpha sulphofatty acid salts, C10-20 acyl sarcosinates, isethionates, C10-20 acyl taurides, C10-20 alkyl hydrogen phosphates), non-ionic surfactants (e.g. ethoxylated and/or propoxylated C10-20 alcohols, ethoxylated and/or propoxylated C10-20 carboxylic acids, alkanolamides, amine oxides, and/or C10-20 acyl sorbitan and/or glyceryl ethoxylates) amphoteric surfactants (e.g. betaines, sulphobetaines, and/or quaternised imidazolines), and/or cationic surfactants (e.g. benzalkonium salts, C10-20 alkyl trimethyl ammonium salts, and/or C10-20 alkyl trimethyl or tris(hydroxymethyl) phosphonium salts); sequestrants, chelating agents, corrosion inhibitors and/or other threshold agents (e.g. sodium tripolyphosphate, sodium ethylenediamine tetracetate, sodium nitrilo triacetate, tetra potassium pyrophosphate, acetodiphosphonic acid and its salts, ammonium trimethylene phosphonic acid and its salts, ethylenediamine tetrakis (methylene phosphonic) acid and its salts, diethylenetriamine pentakis (methylene phosphonic) acid and its salts); tolyltriazole and mixtures of nitrate, benzoate HHP and/or PTCB) biocides (e.g. tetrakis (hydroxymethyl) phosphonium salts, formaldehyde, glutaraldehyde); oxidising biocides and/or bleaches (e.g. chlorine, chlorine dioxide, hydrogen peroxide, sodium perborate); foam controlling agents such as silicone antifoams; oxygen scavengers such as hydrazines and/or hydroxylamines; pH controlling and/or buffering agents such as amines, borates, citrates and/or acetates; chromium salts; zinc salts; and/or other water treatment agents such as polymeric dispersants and coagulants including polymaleic, polyacrylic and polyvinylsulphonic acids and their salts, starches and/or carboxy methyl cellulose, and/or molybdates.

[0037] Disclosed but not claimed are formulations comprising an effective amount of a product of the invention as aforesaid and any of the aforesaid known water treatment agents. Such formulations may, for example, contain from 5 to 95 by weight of a product of the invention and from 5 to 90% by weight of one or more of any of the aforesaid water treatment agents.

[0038] Disclosed but not claimed is the use of those two families of polymers of formula (1) and (2) having different detectable moieties by means of their distinct absorption maxima so that they can be distinguished by analyzing by means of absorption analytical methods such as UV/VIS spectroscopy.

[0039] Preferably, the substituting groups of the styrene monomer of the first family are chosen from H, SO₃H, SO₃Na, NH₂, COOH, CH₂Cl, OH, -CH₂OH and -N(CH₃)₂.

[0040] The preferred analysis method is UV/VIS spectroscopy.

[0041] The following examples illustrate the invention.

Reference Example 1

Preparation of DPPE

[0042] 480 g tetra-sodium vinylidene diphosphonate (37.4% aqueous solution, 0.47 moles) and 358 g hypophosphorus acid (16% aqueous solution, 0.47 moles) were charged to a reaction vessel and heated to 100 °C.

[0043] 22.3 g sodium persulphate (10% aqueous solution 0.0094 moles) were added via an addition funnel over 1 hour. The reaction mixture was left to reflux for further 2 hours and allowed to cool. The product contained no unreacted vinyl diphosphonate by ³¹P NMR.

Example 2

Preparation of DPPE capped NaSS-stat-AA-stat-SVS telomer

[0044] Into a 1 L jacketed reactor equipped with a reflux condenser and mechanical agitator was added Sodium Vinyl Sulphonate (127.7g, 25% active), a solution of DPPE (70g, 14.7% active) and a solution of Sodium Styrene Sulphonate (146.4g, 10%). The reaction mixture was heated to reflux temperature (115°C jacket temperature) with stirring. Once reflux temperature was attained, three feeds were added independently to the reactor. Feed 1 comprised acrylic acid (127.4g, 80%) and was added to the reaction mixture over 120 minutes. Feed 2 was comprised of Sodium vinyl Sulphonate (383.2g, 25% active) and Sodium Styrene Sulphonate (146.4g, 10%) and was added in parallel over 120 minutes.

[0045] The final feed was Sodium persulphate (84.2g, 10%) and was added over 190 minutes. Upon completion of the persulphate feed, the reaction mixture was held at reflux temperature for a further 30 minutes whereupon it was cooled to room temperature and the solution discharged. Analysis by ^{31}P NMR revealed 75% of the DPPE adduct had been reacted to form polymeric species. Aqueous GPC gave a bimodal distribution with an Mn 3198, Mw 8947 g/mol. HPLC analysis demonstrated near quantitative conversion of Acrylic acid (<10 ppm) and Sodium Styrene Sulphonate (<10ppm).

Example 3**Preparation of DPPE capped 2VP-stat-AA-stat-SVS telomer**

[0046] Into a 250 ml 3 necked round bottomed flask equipped with a reflux condenser and magnetic stirrer bar was added a solution of Sodium Vinyl Sulphonate (13.1 g, 25% active) and a solution of DPPE (5g, 14.7% active). The reaction flask was heated in an oil bath set at 95°C. Once the targeted temperature was attained, three feeds were added independently to the flask. Feed 1 comprised acrylic acid (9.1g, 80%) and 2-vinyl pyridine (1.1g, 99.8%) and was added to the reaction mixture over 120 minutes. Feed 2 was comprised of Sodium vinyl Sulphonate (39.4, 25% active) and was added in parallel over 120 minutes. The final feed was Sodium Persulphate (6g, 10%) and was added over 195 minutes.

[0047] Upon completion of the Persulphate feed, the reaction mixture was held at temperature for a further 30 minutes whereupon it was cooled to room temperature and the solution discharged. Analysis by ^{31}P NMR revealed 60% of the DPPE adduct had been reacted to form polymeric species. Aqueous GPC (PEO calibration) gave a bimodal distribution with an Mn 3358, Mw 11580 g/mol.

[0048] Multidetector GPC analysis (RI and UV @ 254 nm) confirmed homogenous incorporation of 2VP across the Molecular weight distribution. HPLC analysis demonstrated near quantitative conversion of Acrylic acid (<10 ppm) and 2-vinyl pyridine (<20ppm).

Example 4**Preparation of DPPE capped 4VP-stat-AA-stat-SVS telomer**

[0049] Into a 250 ml 3 necked round bottomed flask equipped with a reflux condenser and magnetic stirrer bar was added a solution of Sodium Vinyl Sulphonate (13.1 g, 25% active) and a solution of DPPE (5g, 14.7% active). The reaction flask was heated in an oil bath set at 95°C. Once the targeted temperature was attained, three feeds were added independently to the flask. Feed 1 comprised acrylic acid (9.1g, 80%) and 4-vinyl pyridine (1.1g, 99.8%) and was added to the reaction mixture over 120 minutes. Feed 2 was comprised of Sodium vinyl Sulphonate (39.4, 25% active) and was added in parallel over 120 minutes. The final feed was Sodium Persulphate (6g, 10%) and was added over 195 minutes.

[0050] Upon completion of the Persulphate feed, the reaction mixture was held at temperature for a further 30 minutes whereupon it was cooled to room temperature and the solution discharged. Analysis by ^{31}P NMR revealed 49.3% of the DPPE

adduct had been reacted to form polymeric species. Aqueous GPC (PEO calibration) gave a bimodal distribution with an Mn 4300, Mw 8900 g/mol.

[0051] Multidetector GPC analysis (RI and UV @ 254 nm) confirmed homogenous incorporation of 4VP across the Molecular weight distribution. HPLC analysis demonstrated near quantitative conversion of Acrylic acid (<10 ppm) and 4-vinyl pyridine (<20ppm).

Example 5

Preparation of DPPE capped 2-SPV-stat-AA-stat-SVS telomer

[0052] Into a 250 ml 3 necked round bottomed flask equipped with a reflux condenser and magnetic stirrer bar was added a solution of Sodium Vinyl Sulphonate (13.1 g, 25% active) and a solution of DPPE (5g, 14.7% active). The reaction flask was heated in an oil bath set at 95°C. Once the targeted temperature was attained, three feeds were added independently to the flask. Feed 1 comprised acrylic acid (9.1g, 80%), 1-(3-Sulfopropyl)-2-vinyl pyridinium betaine (2.32g, 99%) and water (20.8g) was added to the reaction mixture over 120 minutes. Feed 2 was comprised of Sodium Vinyl Sulphonate (39.4, 25% active) and was added in parallel over 120 minutes. The final feed was Sodium Persulphate (6g, 10%) and was added over 195 minutes. Upon completion of the Persulphate feed, the reaction mixture was held at temperature for a further 30 minutes whereupon it was cooled to room temperature and the solution discharged. Analysis by ³¹P NMR revealed 44.9% of the DPPE adduct had been reacted to form polymeric species. Aqueous GPC (PEO calibration) gave a bimodal distribution with an Mn 11556, Mw 20580 g/mol. HPLC analysis demonstrated near quantitative conversion of Acrylic acid (<10 ppm) and 1-(3-Sulfopropyl)-2-vinyl pyridinium betaine (<20ppm).

Example 6

Preparation of DPPE capped 4SPV-stat-AA-stat-SVS telomer

[0053] Into a 250 ml 3 necked round bottomed flask equipped with a reflux condenser and magnetic stirrer bar was added a solution of Sodium Vinyl Sulphonate (13.1 g, 25% active) and a solution of DPPE (5g, 14.7% active). The reaction flask was heated in an oil bath set at 95°C. Once the targeted temperature was attained, three feeds were added independently to the flask. Feed 1 comprised acrylic acid (9.1g, 80%), 1-(3-Sulfopropyl)-4-vinyl pyridinium betaine (2.32g, 99%) and water (20.8g) and was added to the reaction mixture over 120 minutes. Feed 2 was comprised of Sodium vinyl Sulphonate (39.4, 25% active) and was added in parallel over 120 minutes. The final feed was Sodium Persulphate (6g, 10%) and was added over 195 minutes. Upon completion of the Persulphate feed, the reaction mixture was held at temperature for a further 30 minutes whereupon it was cooled to room temperature and the solution discharged. Analysis by ³¹P NMR revealed 47.2% of the DPPE adduct had been reacted to form polymeric species. Aqueous GPC (PEO calibration) gave a bimodal distribution with an Mn 5500, Mw 11300 g/mol. HPLC analysis demonstrated near quantitative conversion of Acrylic acid (<10 ppm) and 1-(3-Sulfopropyl)-4-vinyl pyridinium betaine (<20ppm).

Example 7

UV absorbance profile

[0054] UV absorber monomers synthesised in examples 2-6 have been detected using UV/VIS spectroscopy. For monomers, a 10 ppm (as active polymer) solution of each sample was prepared. For polymers, a 100 ppm (as active polymer) solution of each polymer was prepared. The pH of these solutions was adjusted at 5.5. The absorbance was then measured over the wavelength range of 200 nm to 400 nm in standard 1 cm path length cells using a Perkin Elmer UV/VIS spectrophotometer.

[0055] The absorbance maximum and the corresponding absorbance were determined for each sample.

[0056] The results are gathered in table 3 and 4 below.

Table 3: UV/VIS data Family 1

Sample	Absorbance maximum (nm)	Corresponding Absorbance
NaSS monomer	246	1,09
Example 2	223	0,48

Table 4: UV/VIS data Family 2

Sample	Absorbance maximum (nm)	Corresponding Absorbance
2VP monomer	278	0,92
Example 3	264	0,25
4VP monomer	246	1,05
Example 4	258	0,18
2SPV monomer	287	0,43
Example 5	269	0,24
4SPV monomer	271	0,63
Example 6	257	0,13

[0057] Data from table 3 and 4 show a shift of maximum absorbance between UV-absorber monomers and polymers. This shift corresponds to a perfect incorporation of UV-absorber monomers during polymerisation.

Example 8

Thermal stability of UV profiles

[0058] Solutions of polymers from example 2 to 6 were made up to the desired concentration (5% active polymer) in synthetic sea water. The pH was adjusted to 5.5. 60 mls of each solution was poured into a Teflon liner (internal volume of 100 mls) of a stainless steel bomb. The individual solutions were then degassed for approximately 30 minutes. The Teflon liners were then sealed and placed into the stainless steel bombs which were placed in an oven at 212°F for 1 week. Following this, the bombs were allowed to cool.

[0059] The UV absorption profiles were determined for each aged solution after dilution at 100 ppm active polymer and compared to the one obtained on un-aged solution at the same concentration. The UV absorption profile before and after aging are exactly the same.

Example 9

Barium sulfate scale inhibition

[0060] The polymers prepared in examples 2-6 were tested for their ability to inhibit barium sulphate scale formation. The test method for measuring inhibition of barium sulphate consisted of measuring the level of soluble barium after mixing of two incompatible salt solutions in a bottle, then observing the change in the mixture without agitation for a given time, and measuring the soluble barium by a spectroscopic method (ICP-AES). The experiments include a control test without inhibitor and tests in the presence of inhibitors.

[0061] This evaluation was carried out at 95°C and pH 5.5 after mixing two brines, one of which has the composition of the formation water of the Forties Field in the North Sea (contains barium) and the other has the seawater composition containing

sulfate. The inhibitor was placed in the seawater. The inhibitor concentration was 15 ppm (of active ingredient) relative to the final mixture.

[0062] The pH of the seawater solution containing inhibitor was brought to about 5.5 with a sodium acetate/acetic acid buffer solution.

[0063] The brine compositions (Forties water and seawater) were the following:

Forties Water

Ion	mg/L		Salt	Salt (g/L)
Na ⁺	31275		NaCl	79.50
Ca ⁺	2000		CaCl ₂ , 2H ₂ O	7.34
Mg ²⁺	739		MgCl ₂ , 6H ₂ O	6.18
K ⁺	654		KCl	1.25
Ba ²	269		BaCl ₂ , 2H ₂ O	0.48
Sr ²⁺	87.6		SrCl ₂ , 6H ₂ O	2.35

Seawater

Ion	mg/L		Salt	Salt (g/L)
Na ⁺	10890		NaCl	24.40
Ca ²⁺	428		CaCl ₂ , 2H ₂ O	1.57
Mg ²⁺	1368		MgCl ₂ , 6H ₂ O	11.44
K ⁺	460		KCl	0.88
SO ₄ ²⁻	2690		Na ₂ SO ₄	3.97

[0064] 100 ml of each of these liquids was placed in polyethylene bottles. Once the temperature of the brines has settled to 95°C in an oven, the contents of the "Forties water" bottle were poured into the bottle containing the barium. The mixture was shaken manually then replaced in the oven at 95°C for 2 hours. For each test series, two control tests were run:

Min blank: this is a test without inhibitor and the barium ion content will be minimal (maximum precipitation of BaSO₄);

Max blank: this is a test without sulfate and without inhibitor; the seawater is replaced by purified water and the barium ion content will be maximal as there is no precipitation.

[0065] After two hours of testing, the bottles were removed from the oven and a 5 ml sample is taken then diluted in 5 ml of a "soaking" solution whose composition is: 5000 ppm KCl / 1000 ppm PVA (polyvinyl sodium sulfonate) adjusted to pH 8 - 8.5 (with 0.01 N NaOH). The barium from these samples is assayed (ICP-AES) and the inhibition effectiveness deduced, expressed in the formula below:

$$\% \text{ efficiency} = \frac{[\text{Ba}^{2+}] - [\text{Ba}^{2+}]_{\min}}{[\text{Ba}^{2+}]_{\max} - [\text{Ba}^{2+}]_{\min}} * 100$$

where

$[\text{Ba}^{2+}]_{\max}$ = Ba²⁺ concentration in max blank

$[\text{Ba}^{2+}]_{\min}$ = Ba²⁺ concentration in min blank

[0066] The results are shown in the following table 5.

Table 5

Inhibitor	% BaSO ₄ inhibition effectiveness (15 ppm)
Example 2	37
Example 3	42
Example 4	45
Example 5	42
Example 6	48

[0067] This test was also conducted on thermally aged polymers obtained in example 8, i.e. thermal aging Sea Water at 122°F during 1 week. The level of performance measured on aged polymers was the same as the one measured on fresh polymers and presented in table 5.

Example 10

Adsorption on clay under static conditions

[0068] The additives according to the invention were evaluated for their ability to adsorb on clay.

[0069] For this purpose, a solution of known concentration of inhibitor in synthetic brine was brought into contact for 20 hours, at 85°C, with a known quantity of solid.

[0070] The solid suspension was then centrifuged and filtered, then analyzed in terms of dissolved organic carbon. The adsorbed amount was measured using the following protocol:

- For each solution of additive diluted in seawater at the concentration in question, the organic carbon concentration (COT_{SM} in ppm) and a response coefficient K (additive concentration in solution / organic carbon concentration in solution) were determined.
- The organic carbon concentration ($COT_{filtrate}$ in ppm) in the supernatant solution after adsorption was determined.

[0071] The adsorbed quantity (QA) was then calculated using the following formula:

$$QA = \frac{(COT_{SM} - COT_{filtrate}) \times K \times V_{SM}}{1000 \times M_{Solid} \times S_{BET}}$$

where:

V_{SM} = volume of solution in cm³

M_{Solid} = mass of solid in grams

S_{BET} = specific surface of solid

[0072] The clay used was ground kaolinite. Its specific surface measured by the BET method with nitrogen was 12 m²/g. For each product, solutions of 1.0 mg/l active ingredient were prepared in a brine which composition is presented in the table below.

Salt	Concentration (g/l)
NaCl	2,4
MgCl ₂ · 6H ₂ O	5,7
CaCl ₂ · 2H ₂ O	1,5

[0073] For each test, 15 ml of solution and 2,0 g of kaolinite were used, i.e. a liquid:solid ratio of 7,5.

[0074] The results are shown in the following Table 6 below.

Table 6

Inhibitor	Quantity Adsorbed (mg additive / m ² clay)
Example 2	0,28
Example 3	0,31
Example 4	0,33
Example 5	0,39
Example 6	0,31

REFERENCES CITED IN THE DESCRIPTION

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Patentkrav

1. Fremgangsmåde til bibringelse af kedelstenshæmning i et oliefelt, hvilken fremgangsmåde omfatter trinene:

- 5 a) injektion af mindst to indløbsstrømme af en fluid i mindst to produktionszoner i en olieproducerende brønd, der er koblet til oliefeltet, eller i mindst to forskellige olieproducerende brønde, hvor en kedelstenshæmmer indføres i oliefeltet og/eller i
- 10 fluiden, så den er til stede i de to zoner eller brønde, og hvor der anvendes to forskellige kedelstenshæmmere, der hver er dedikeret til den ene af de to zoner eller brønde, hvilke forskellige kedelstenshæmmere har forskellige dele, der er detekterbare, således at disse to forskellige
- 15 kedelstenshæmmere har forskellige absorptionsmaksima, der kan bestemmes ved hjælp af en absorptionsanalytisk metode, hvilket betyder, at kedelstenshæmmerne kan skelnes fra hinanden ved hjælp af den absorptionsanalytiske metode;
- 20 b) fortrængning af olie fra den olieproducerende brønd;
- c) indvinding af en udløbsstrøm af fluiden, der omfatter olien; og
- d) måling af mængderne af de forskellige kedelstenshæmmere i den indvundne strøm af fluid eller i en fluid, der er afledt fra den indvundne strøm af fluid, ved hjælp af den
- 25 absorptionsanalytiske metode; hvor mindst to udløbsstrømme, én fra hver af de to zoner eller én fra hver af de to brønde, kombineres før indvindingstrinet c);
- hvor:
- 30 - den ene af de to kedelstenshæmmere er en polymer (P1) opnået ved polymerisering af:
- en ethylenisk umættet carboxylmonomer;
 - en ethylenisk umættet sulfonsyremonomer eller vandopløselige salte deraf;
- 35 - en styrenmonomer, der eventuelt kan være substitueret med en til tre grupper, der kan være identiske eller forskellige,
- i nærvær af et hypophosphoraddukt med formel (A1):



hvor:

X er H eller et alkalimetal eller ammonium,

Y er en alkylengruppe, der er lineær eller forgrenet og har

5 1 til 5 carbonatomer;

og

- den anden kedelstenshæmmer er en polymer (P2) opnået ved polymerisering af:

- en ethylenisk umættet carboxylmonomer;

10 - en ethylenisk umættet sulfonsyremonomer eller vandopløselige salte deraf;

- en heteroaromatisk vinylmonomer, der omfatter mindst ét heteroatom udvalgt blandt N, P eller O, der kan være substitueret med mindst én carbonhydridgruppe med 1 til
15 6 carbonatomer, og eventuelt indeholder funktionelle grupper, såsom sulfat, carboxylat, fosfonat og/eller fosphinat,

i nærvær af et hypophosphoraddukt med formel (A1):



20 hvor:

X er H eller et alkalimetal eller ammonium,

Y er en alkylengruppe, der er lineær eller forgrenet og har 1 til 5 carbonatomer,

hvor hypophosphoraddukterne med formel (A1) kan være

25 identiske eller kan være forskellige.

2. Fremgangsmåde ifølge krav 1, hvor den absorptionsanalytiske metode er UV/VIS-spektroskopi.

30 3. Fremgangsmåde ifølge et hvilket som helst af kravene 1 til 2, hvor Y i formel (A1) er en methylen- eller en ethylengruppe.

4. Fremgangsmåde ifølge et hvilket som helst af kravene 1
35 til 3, hvor X i formel (A1) er Na.

5. Fremgangsmåde ifølge et hvilket som helst af kravene 1 til 4, hvor den heteroaromatiske vinylmonomer indeholder

sulfat-, carboxylat-, phosphonat- og/eller
phosphinatfunktionelle grupper.

6. Fremgangsmåde ifølge et hvilket som helst af kravene 1
til 5, hvor der anvendes mindst tre indløbsstrømme af fluid
med indførelse af mindst tre forskellige kedelstenshæmmere,
der hver er dedikeret til én af de tre zoner eller
brønde.

7. Fremgangsmåde ifølge et hvilket som helst af kravene 1
til 6, hvor hver kedelstenshæmmer indføres ved en
koncentration fra 0,2 til 50 ppm.

8. Polymer med et absorptionsmaksimum på mellem 215 og
240 nm og med den gennemsnitlige generelle formel (1):



hvor

X er H eller et alkalimetal eller ammonium,

Y er en alkylengruppe, der kan være lineær eller forgrenet
og har 1 til 5 carbonatomer, og

Z1 er en polymerkæde opnået ved polymerisering af en
ethylenisk umættet carboxylmonomer med en ethylenisk
umættet sulfonsyremonomer eller vandopløselige salte deraf
og en styrenmonomer, der kan være substitueret med en til
tre grupper, der kan være identiske eller forskellige, og
er udvalgt til tilvejebringelse af absorptionsmaksimummet,
i nærvær af et hypophosphoraddukt med formel (A1):



hvor X, Y har samme betydning som i formel (1).

9. Polymer ifølge krav 8, hvor de substituerende grupper
på styrenmonomeren er udvalgt blandt H, SO₃H, SO₃Na, NH₂,
Me₂N COOH, CH₂Cl, CH₂OH og OH.

10. Polymer med et absorptionsmaksimum på mellem 240 og
400 nm og med den gennemsnitlige generelle formel (2):



hvor X er H eller et alkalimetal eller ammonium,

Y er en alkylengruppe, der kan være lineær eller forgrenet og har 1 til 5 carbonatomer, og

Z2 er en polymerkæde opnået ved polymerisering af en ethylenisk umættet carboxylmonomer med en ethylenisk umættet sulfonsyremonomer eller vandopløselige salte deraf og en heteroaromatisk vinylmonomer, der eventuelt er substitueret med en til tre grupper, der kan være identiske eller forskellige, og er udvalgt til tilvejebringelse af absorptionsmaksimummet, i nærvær af et hypophosphoraddukt

med formel (A1):



hvor X, Y har samme betydning som i formel (2).

11. Polymer ifølge et hvilket som helst af kravene 8 til 10, hvor de ethylenisk umættede carboxylmonomerer er acrylsyre, methacrylsyre, maleinsyre, fumarsyre, itaconsyre, aconitsyre, mesaconsyre, citraconsyre, crotonsyre, isocrotonsyre, angelinsyre eller tiglinsyre.

12. Polymer ifølge et hvilket som helst af kravene 8 til 11, hvor de ethylenisk umættede sulfonsyremonomerer er vinylsulfonsyre eller 2-acrylamido-2-methylpropansulfonsyre, allylsulfonsyre, methallylsulfonsyre.

13. Polymer ifølge et hvilket som helst af kravene 8 til 12, hvor polymeren er (a) baseret på Z1 ifølge krav 8, der er en polymerkæde opnået ved polymerisering af en ethylenisk umættet carboxylmonomer med en ethylenisk umættet sulfonsyremonomer eller vandopløselige salte deraf og en styrenmonomer, eller (b) baseret på Z2 ifølge krav 10, der er en polymerkæde opnået ved polymerisering af en ethylenisk umættet carboxylmonomer med en ethylenisk umættet sulfonsyremonomer eller vandopløselige salte deraf og en heteroaromatisk vinylmonomer, hvor polymeriseringen inddrager en ethylenisk umættet sulfonsyremonomer, som er vinylsulfonsyre, og en ethylenisk umættet carboxylmonomer, som er acryl- og/eller maleinsyre.

14. Polymer ifølge et hvilket som helst af kravene 8 til 13, hvor Y i formel (1) som defineret i krav 8 eller i formel (2) som defineret i krav 10 er en methylen- eller
5 ethylengruppe.

15. Polymer ifølge et hvilket som helst af kravene 8 til 14, hvor X i formel (1) som defineret i krav 8 eller i formel (2) som defineret i krav 10 er Na.