## Contents

Preface xvAcknowledgments xix

Part I Fundamentals and Approaches 1

1	An Overview of Corrosion in Oil and Gas I	ndustry: Upstream,
	Midstream, and Downstream Sectors 3	
	Vahua T Al lawahi	

۱v

- Yahya T. Al-Janabi
- 1.1 Introduction 3
- 1.2 Corrosion in Upstream Production Operations 4
- 1.2.1 Causes of Corrosion in Upstream Environments 7
- 1.2.1.1 Oxygen 8
- 1.2.1.2 Hydrogen Sulfide, Polysulfides, and Sulfur 9
- 1.2.1.3 Carbon Dioxide 10
- 1.2.1.4 Strong Acids 11
- 1.2.1.5 Concentrated Brines 11
- 1.2.2 Corrosion Types in Petroleum Production Operations 11
- 1.2.3 Corrosion Inhibitors for Oil and Gas Production 12
- 1.2.3.1 Oil and Gas Wells 12
- 1.2.3.2 Inhibitor Selection 13
- 1.2.3.3 Practical Challenges with Inhibition 14
- 1.2.3.4 Inhibitor Application Methods 14
- 1.2.3.5 Oxygen Removal 16
- 1.2.4 Problems Encountered and Protective Measures 17
- 1.2.4.1 Drilling Fluid Corrosion 17
- 1.2.4.2 Primary Production 18
- 1.2.4.3 Corrosion in Secondary Recovery Operations 20
- 1.2.5 CO<sub>2</sub> Injection 23
- 1.2.6 Corrosion of Oil and Gas Offshore Production Platforms 23
- 1.2.7 Corrosion of Gathering Systems and Tanks 23
- 1.2.7.1 Sweet Gas Corrosion 24
- 1.2.7.2 Sour Gas Corrosion 24

vi Contents

- 1.2.7.3 Oil Wells Corrosion 24
- 1.3 Corrosion in Midstream Sector 25
- 1.3.1 Control of Internal Corrosion in Carbon Steel Oil Pipeline Systems 27
- 1.3.2 Control of Internal Corrosion in Carbon Steel Gas Pipeline Systems 28
- 1.3.3 Control of Internal Corrosion in Carbon Steel Water Pipeline Systems 28
- 1.3.4 Chemical Inhibition of Internal Corrosion in Carbon Steel Pipeline Systems 29
- 1.4 Corrosion in Downstream Sector 30
- 1.4.1 Materials of Construction 31
- 1.4.2 Corrosion in Refineries and Petrochemical Plants 32
- 1.4.3 Corrosion Inhibitors in Refinery and Petrochemical Plants 33
- 1.4.4 Corrosion Control of Water-Recirculating Systems 33
- 1.4.4.1 Typical Corrosion Reactions in Water-Recirculating Systems 34
- 1.4.4.2 Water Corrosivity 35
- 1.4.4.3 Corrosion Control 36
- 1.5 Conclusions and Outlook 37 References 38
- 2 Fundamentals of Corrosion and Corrosion Control in Oil and Gas Sectors 41 Anil Bhardwai
- 2.1 Introduction *41*
- 2.2 Material Degradation and Corrosion *41*
- 2.3 Electromotive Force (EMF) Series and Galvanic Series 49
- 2.4 Forms of Corrosion 51
- 2.4.1 Uniform Corrosion 51
- 2.4.2 Galvanic or Two-Metal Corrosion 52
- 2.4.2.1 Factors Affecting Galvanic Corrosion 53
- 2.4.2.2 How to Reduce Galvanic Corrosion 54
- 2.4.2.3 Benefits of Galvanic Effect 54
- 2.4.3 Crevice Corrosion 54
- 2.4.4 Pitting 55
- 2.4.5 Intergranular Corrosion 57
- 2.4.6 Erosion-Corrosion 58
- 2.4.7 Stress-Corrosion Cracking (SCC) 60
- 2.4.8 Under-Deposit Corrosion (UDC) 61
- 2.4.9 Acid Corrosion 63
- 2.4.10 Microbiologically Influenced Corrosion 63
- 2.5 Factors Influencing Oilfield Corrosion 66
- 2.5.1 Free Water and Water Composition 66
- 2.5.2 Type of Oil 68
- 2.5.3 Gas Composition 69
- 2.5.4 Pressure Effect 70
- 2.5.5 Temperature Effect 71

- 2.5.6 Velocity Effect 71
- 2.6 Corrosion Control 72
- 2.6.1 Material Selection 72
- 2.6.2 Environment Control 73
- 2.6.3 Proper Design 73
- 2.6.4 Chemical Treatment 73
- 2.7 Conclusions and Outlook 74 References 74

# 3 Environmental Factors Affecting Corrosion Inhibition in Oil and Gas Industry 77

- Mohamed A. Migahed
- 3.1 Introduction 77
- 3.2 Environmental Factors Affecting Corrosion Inhibition 78
- 3.2.1 Influence of Temperature and Pressure 78
- 3.2.2 Influence of Flow Parameters 81
- 3.2.3 Effect of Natural Gases 83
- 3.2.3.1 Effect of Sulfur Dioxide 83
- 3.2.3.2 Effect of Hydrogen Sulfide 86
- 3.2.3.3 Effect of Carbon Dioxide 88
- 3.2.4 Effect of Cationic Species 91
- 3.2.5 Effect of Anionic Species 91
- 3.2.6 Effect of Microorganisms 96
- 3.2.7 Effect of pH 98
- 3.2.8 Effect of the Pre-corrosion 100
- 3.3 Conclusions and Outlook *101* References *102*

### 4 Key Materials in Oil and Gas Production and the Choice of Inhibitors 111

- Thiago J. Mesquita and Hervé Marchebois
- 4.1 Introduction 111
- 4.2 Materials in Oil and Gas Industry 112
- 4.2.1 Carbon Steel or CRA? 112
- 4.2.2 Non-metallic Materials 116
- 4.3 The Choice of Corrosion Inhibitor for Oil and Gas Production 116
- 4.3.1 Factors Affecting the Efficiency of Corrosion Inhibitor 117
- 4.3.2 Laboratory Corrosion Inhibitor Selection 119
- 4.4 Principles of CI Qualification Tests *120*
- 4.4.1 Bubble Test *121*
- 4.4.2 Partitioning Test 122
- 4.4.2.1 Corrosivity of the Water Phase After Partitioning 122
- 4.4.2.2 Titrability and Partitioning Coefficient 123
- 4.4.3 Impact on the Process Test 124
- 4.4.3.1 Emulsion Tendency 124
- 4.4.3.2 Foaming Tendency 125

4.4.4 4.4.5 4.4.6 4.5	Wheel Test125HP Corrosion Test Loop127HP Jet Impingement Test128Conclusions and Outlook129References130
5	Corrosion Inhibition in Oil and Gas Industry: Economic
	Considerations 135
	Anupama R. Prasad, Anupama Kunyankandy, and Abraham Jose
5.1	Introduction 135
5.2	Corrosion: Global Economic Loss 136
5.2.1	Historical Summary of Corrosion Cost Studies 137
5.2.2	NACE–IMPACT: Global Corrosion Cost 138
5.2.3	Global Corrosion Management–IMPACT Estimate 139
5.3	Depreciation in Oil and Gas Industries 140
5.3.1	Corrosion Attacks 140
5.3.2	Failures and Risk Factors 141
5.4	Fiscal Impacts 142

and Abraham Joseph

- Corrosion Costs a Lot 143 5.4.1
- 5.5 Inhibition: Monetary Measures 144
- 5.5.1 Worthy Monitoring 145
- Protection in Proper Way 146 5.5.2
- Conclusions and Outlook 147 5.6 References 148

Part II Choice of Inhibitors 151

6	Corrosion Inhibitors for Acidizing Process in Oil and Gas	
	Sectors 153	
	Kashif R. Ansari, Dheeraj Singh Chauhan, Ambrish Singh, Viswanathan S. Saji,	
	and Mumtaz A. Quraishi	
6.1	Introduction 153	
6.2	Acidizing Process 154	
6.2.1	Type of Oil Well Reservoirs 154	
6.2.2	Types of Acid Used 155	
6.2.3	Methods Used to Control Acidizing Process 157	
6.2.3.1	Retarded Acid Systems 157	
6.2.3.2	Gelled Acids 157	
6.2.3.3	Chemically Retarded Acids 157	
6.2.3.4	Emulsified Acids 157	
6.2.4	Acid Selection 157	
6.2.4.1	Rock-Dissolving Capacity of Acid 158	
6.2.4.2	Spending Time of Acid 158	
6.2.4.3	Solubility of Reaction Products 158	
6.2.4.4	Density and Viscosity 158	
6.2.4.5	Etching Pattern After Acidizing 158	

Contents ix

- 6.2.5 Types of Acidizing Process 159
- 6.3 Application of Corrosion Inhibitors in Acidizing Processes 160
- 6.4 Selected Acidizing Inhibitors 169
- 6.5 Conclusions and Outlook 170 References 171

# 7 Corrosion Inhibitors for Sweet Oilfield Environment (CO<sub>2</sub>

Corrosion) 177

- Ubong Eduok and Jerzy Szpunar
- 7.1 Introduction 177
- 7.2 Mechanism of  $CO_2$  Corrosion 178
- 7.3 Factors Affecting Sweet Corrosion 179
- 7.3.1 Effects of Hydrogen Concentration (pH) and Temperature 179
- 7.3.2 Effects of Flow Rate and Partial Pressure 180
- 7.3.3 Effects of Molecular Oxygen and Iron Ions (Fe<sup>2+</sup>) Concentration 181
- 7.4 Toward Inhibition and Control of Sweet Corrosion 181
- 7.5 Altering Corrosion Kinetics with Corrosion Inhibitors 182
- 7.6 Corrosion Inhibitors for Sweet Oilfield Environments 183
- 7.6.1 Corrosion Inhibitors Based on Smaller Molecules *183*
- 7.6.1.1 Imidazoline Derivatives 183
- 7.6.1.2 Cyclic Non-imidazoline Compounds 195
- 7.6.1.3 Acyclic Non-imidazoline Compounds 197
- 7.6.2 Corrosion Inhibitors Based on Macromolecules 210
- 7.6.2.1 Polymers 210
- 7.6.2.2 Plant Biomass Extracts 211
- 7.6.2.3 Others 218
- 7.7 Biocorrosion in Saturated CO<sub>2</sub> Media 218
- 7.8 Conclusions and Outlook 219 References 220
- 8 Corrosion Inhibitors for Sour Oilfield Environment (H<sub>2</sub>S Corrosion) 229
  - Saviour A. Umoren, Moses M. Solomon, and Viswanathan S. Saji
- 8.1 Introduction 229
- 8.1.1 Impact of Corrosion on Economy and Life 229
- 8.1.2 Background on Sour Corrosion 230
- 8.1.3 Factors Influencing Sour Corrosion 232
- 8.1.3.1 Effect of H<sub>2</sub>S Concentration 232
- 8.1.3.2 Effect of Temperature and Exposure Duration 233
- 8.1.3.3 Effect of Flow Rate 233
- 8.1.3.4 Effect of H<sub>2</sub>S Partial Pressure 233
- 8.1.3.5 Effect of Fluid Chemistry 233
- 8.2 Corrosion Inhibitors for Sour Oilfield Environment 233
- 8.2.1 Amine-Based Inhibitors 234
- 8.2.2 Imidazoline-Based Inhibitors 237
- 8.2.3 Gemini Surfactant-Based Inhibitors 238
- 8.2.4 Polymer-Based Inhibitors 244

- **x** Contents
  - Conclusions and Outlook 247 8.3 References 247
  - 9 **Corrosion Inhibitors for Refinery Operations** 255 Yahva T. Al-Janabi
  - 9.1 Introduction 255
  - 9.2 Areas/Units Where Inhibitors Are in Demand in Refineries 257
  - 9.2.1 Atmospheric and Vacuum Crude Oil Distillation Units 257
  - 9.2.2 Fluid Catalytic Cracking: Coker 259
  - 9.2.3 Hydroprocessing 260
  - 9.2.4 Catalytic Reforming 260
  - 9.2.5 Amine (Acid Gas Treatment) Plants 262
  - 9.2.6 Support Units 262
  - 9.3 Types of Aggressive Species Encountered in Refineries 262
  - 9.3.1 Air 263
  - 9.3.2 Water 263
  - Hydrogen Sulfide 263 9.3.3
  - 9.3.4 Hydrogen Chloride 263
  - 9.3.5 Nitrogen Compounds 264
  - 9.3.6 Sour Water 264
  - 9.4 Common Types of Inhibitors Employed/Reported in Refinery Units 264
  - 9.4.1 Neutralizers 264
  - 9.4.2 Filming Inhibitors 265
  - 9.5 Conclusions and Outlook 268 References 268

#### 10 Inhibitors for High-Temperature Corrosion in Oil and Gas Fields 271

Vitalis I. Chukwuike and Rakesh C. Barik

- 10.1 Introduction 271
- 10.2 High-Temperature Corrosion in Oil and Gas Fields 272
- Mechanism of High-Temperature Corrosion in Oil and Gas Field 273 10.3
- High-Temperature Oxidation 274 10.3.1
- High-Temperature Sulfidation 276 10.3.2
- 10.3.3 High-Temperature Carburization 276
- 10.3.4 High-Temperature Chlorination 277
- 10.3.5 High-Temperature Nitridation 277
- Sulfidation-Oxidation 278 10.3.6
- Corrosion Due to Formation of Ash, Deposits, and Molten Salts 278 10.3.7
- 10.4 Categories and Choice of Inhibitors for Oil and Gas High-Temperature Corrosion 278
- Calcium Carbonate Scale and Ash Deposit Inhibitors 278 10.4.1
- 10.4.2 High-Temperature Acidization Corrosion Inhibitors 279
- 10.4.3 High-Temperature Naphthenic Acid Corrosion Inhibitors 283
- Other Inhibitors of High-Temperature Corrosion 285 10.4.4
- Conclusions and Outlook 286 10.5 References 287

- 11Experience in Using Chemicals to Mitigate Corrosion in Difficult<br/>Corrosive Environments in the Oil and Gas Industry<br/>Sunder Ramachandran289
- 11.1 Introduction 289
- 11.2 Corrosion Inhibition for Systems with High Amounts of  $H_2S_290$
- 11.3 Corrosion Inhibition for  $CO_2$  Tertiary Flood Systems and  $CO_2$ Sequestration 292
- 11.4 Corrosion Inhibition in Deepwater Systems 295
- 11.5 Corrosion Inhibition at High Temperatures 296
- 11.6 Conclusions and Outlook 297 References 298
- **12 Polymeric Corrosion Inhibitors for Oil and Gas Industry** 303 Saviour A. Umoren and Moses M. Solomon
- 12.1 Introduction 303
- 12.2 Polymeric Corrosion Inhibitors 304
- 12.2.1 Polymeric Inhibitors for Chemical Cleaning 304
- 12.2.2 Inhibitors for Acidization Process 308
- 12.2.3 Inhibitors for Sweet and Sour Environments 311
- 12.2.4 Inhibitors for High-Temperature Applications 315
- 12.3 Conclusions and Outlook *315* References *317*
- 13 Microbiologically Influenced Corrosion Inhibition in Oil and Gas Industry 321

Bhawna Chugh, Sanjeeve Thakur, and Ashish Kumar Singh

- 13.1 Introduction 321
- 13.2 Biofilm Formation 322
- 13.3 Microbial Communities Related to Corrosion 323
- 13.3.1 Sulfate-Reducing Bacteria 323
- 13.3.2 Iron-Oxidizing Bacteria 324
- 13.3.3 Acid-Producing Bacteria 324
- 13.3.4 Sulfur-Oxidizing Bacteria 325
- 13.3.5 Slime-Forming Bacteria 325
- 13.4 Potential Prevention Strategies 325
- 13.4.1 Periodic Pigging 325
- 13.4.2 Cleanliness 326
- 13.4.3 Cathodic Protection and Coatings 326
- 13.4.4 Biocides/Inhibitors 327
- 13.4.5 Biological Treatment 328
- 13.5 Recent Developments of Chemical Inhibitors to Mitigate MIC 329
- 13.6 Biological Inhibition of MIC 329
- 13.6.1 Corrosion Inhibition by Nitrate-Reducing Bacteria 329
- 13.6.2 Corrosion Inhibition by Regenerative Biofilms 331
- 13.6.2.1 Corrosion Inhibition by Eviction of Corrosive Agents 331
- 13.6.2.2 Corrosion Inhibition by Formation of Protective Barrier Layer 332
- 13.6.2.3 Corrosion Inhibition via Antimicrobial Producing Biofilm 332

xii Contents

- 13.6.2.4 Corrosion Possessing Biofilm Secreted Corrosion Inhibitor 333 13.6.2.5 Corrosion Inhibition with Biofilm Secreted Bio Surfactant 333 13.7 Conclusions and Outlook 333 References 334 14 Vapor Phase Corrosion Inhibitors for Oil and Gas Field Applications 339 Benjamín Valdez-Salas, Michael Schorr-Wiener, and Nelson Cheng
- 14.1 Introduction 339
- 14.2 Magna International VPCIs 340
- Corrosion and Its Control in OGI 14.3 341
- 14.3.1 Fundamentals of Corrosion 341
- Oil and Gas Industries 342 14.3.2
- 14.3.3 OGI Sectors 343
- 14.3.4 Corrosiveness of Oil and Gas Products 345
- 14.3.5 Metals and Alloys in OGI 346
- 14.4 Vapor Phase Corrosion Inhibitors 346
- 14.4.1 Fundamentals 346
- 14.4.2 VPCI Application in OGI 348
- 14.4.3 Testing and Monitoring of VPCI 349
- Research and Development 350 14.4.4
- 14.5 Conclusions and Outlook 353 Acknowledgments 353 References 353
- 15 Mechanisms of Inhibitor Action: Passivation and Self-Healing 359

Ivana Jevremović, Ying-Hsuan Chen, Abdulrahman Altin, and Andreas Erbe

- Introduction 359 15.1
- Systematics and Phenomenology 360 15.2
- 15.3 Surface Active Inhibitors 364
- 15.4Case Study (1): Imidazoline-Based Surfactant for Mitigation of Mild Steel Corrosion in the Presence of  $CO_2$  367
- Case Study (2): The Interaction of 2-Mercaptobenzothiazole (MBT) 15.5 with Copper 369
- 15.6 Case Study (3): β-Cyclodextrin Facilitates Release of Inhibitors 372
- Conclusions and Outlook 375 15.7
  - References 376

Part III Interaction with Co-additives 383

16 Antiscalants and Their Compatibility with Corrosion Inhibitors 385 Qiwei Wang and Tao Chen 16.1 Introduction 385

- 16.2 Scale Formation 385
- 16.3 Scale Mitigation Strategy 388
- 16.3.1 Flow Control 388
- 16.3.2 Fluid Alteration 388
- 16.3.3 Deposit Removal 388
- 16.3.4 Chemical Inhibition 388
- 16.4 Antiscalant Chemistry 389
- 16.5 Antiscalant Function Mechanisms 393
- 16.5.1 Nucleation Inhibition 393
- 16.5.2 Crystal Growth Retardation 394
- 16.5.3 Crystal Shape Modification 395
- 16.5.4 Dispersion 395
- 16.6 Antiscalant Treatment 396
- 16.7 Compatibility with Corrosion Inhibitors 397
- 16.7.1 Impact of Corrosion Inhibitor on Antiscalant Performance 398
- 16.7.2 Impact of Antiscalant on Corrosion Inhibitor Performance 399
- 16.8 Conclusions and Outlook 399 References 400
- 17 Hydrate Inhibitors and Their Interferences in Corrosion Inhibition 407

Yutaek Seo

- 17.1 Introduction 407
- 17.2 Gas Hydrate Blockage Formation Process 407
- 17.3 Hydrates Inhibition Strategies with Alcohols or Glycols 409
- 17.4 Kinetic Hydrate Inhibitors 412
- 17.5 Interaction Between Hydrate and Corrosion Inhibitors 414
- 17.6 Conclusions and Outlook 416 References 416
- 18 Sulfide Scavengers and Their Interference in Corrosion Inhibition 421 Viswanathan S. Saji
- 18.1 Introduction 421
- 18.2 Sulfide Scavengers: Types and Properties 422
- 18.3 Corrosion and Fouling Inhibiting/Inducing Properties of Scavengers and Their Compatibility with Co-additives 424
- 18.4 Conclusions and Outlook 427 References 428

Index 433