Contents

Preface xi

Part I Introduction to EPCC Industry 1

۱v

- **1** Introduction *3*
- 1.1 What Is EPCC Industry 3
- 1.2 Types of Projects 4
- 1.2.1 Cost of a Project 5
- 1.2.2 Purpose of a Project 7
- 1.2.3 Engineering Needs 8
- 1.2.4 Licensors Need 8
- 1.2.5 Profit Based 8
- 1.2.6 Schedule Based 9
- 1.3 Function of Different Disciplines 9
- 1.4 Different Phases of the Project 11
- 1.5 Importance of Chemical Process Engineers 14
- 1.6 Interaction with Operating Industry or Customers 15
- 1.7 Interaction with Vendors 15
- 1.8 Workshare with Multiple Offices 17
- 1.8.1 Importance of Workshare 17
- 1.8.1.1 Low-Cost Services 17
- 1.8.1.2 Labor Shortages 18
- 1.8.1.3 Level the Workload 18
- 1.8.1.4 Time Differences in Countries 18
- 1.8.2 Types of Workshares 19
- 1.8.2.1 Workshare with an Individual 19
- 1.8.2.2 Workshare a Piece of a Project 19
- 1.8.2.3 Workshare Part of the Engineering Team 19

vi Contents

Part II Roles of Chemical Engineers in Different Phases of the Project 21

2 Phase 1 (Scope Planning) 23

- 2.1 Perform Feasibility Studies 23
- 2.1.1 Study Types 23
- 2.1.2 Study Duration 24
- 2.2 Interaction with Customer, Recommendations, and Meetings 24
- 2.3 Preparation of Preliminary Scope Reports 25
- 2.3.1 Assumptions Required 25
- 2.3.2 Basis of Design Document 26
- 2.3.2.1 Contents 26
- 2.3.2.2 Comparison of Study Report with the Design Basis Document 26
- 2.3.2.3 Basis of the Equipment 26
- 2.3.2.4 Report Format 27
- 2.3.2.5 Study Report Tracking 27
- 2.4 Technology Selection 28
- 2.4.1 Technology Options 28
- 2.4.2 Meeting Between Customer and EPCC 28
- 2.4.3 Initiate a Study Contract with Technology Companies 28
- 2.4.4 Review Report from Technology Companies 29
- 2.4.5 Customer and EPCC Make a Technology Selection *30*
- 2.4.6 Technology Selection Based on Other Criteria 30

3 Phase 2 (Scope Definition) *31*

- 3.1 Develop a Block-Flow Diagram 31
- 3.1.1 What Is a Block-Flow Diagram (BFD) 31
- 3.1.2 Information Needed to Develop a BFD 31
- 3.1.3 Utility Block-Flow Diagrams 31
- 3.1.4 Examples 31
- 3.1.5 Uses of BFD and UBFDs 31
- 3.2 Develop a Process-Flow Diagram 32
- 3.2.1 What Is Process-Flow Diagram 32
- 3.2.2 Information Needed to Develop a PFD 33
- 3.2.3 Utility Flow Diagrams 35
- 3.2.4 Example 35
- 3.2.5 Uses of PFD and UFD 35
- 3.2.6 Distinguishing New Scope from Existing 35
- 3.2.7 Revisions to the PFDs and UFDs 36
- 3.2.8 Titleblock for the PFD 36
- 3.3 Prepare IFE Quality P&IDs 36
- 3.3.1 IFE Quality P&IDs 36
- 3.3.2 Uses of IFE P&IDs 37
- 3.3.2.1 General Uses *37*
- 3.3.2.2 Estimating Uses for Phase 2 Estimate 37

- 3.3.2.3 Reviews with the Customer 37
- 3.3.3 Example of a P&ID 38
- 3.4 Identify Major Pieces of Equipment, Instruments, and Electrical 38
- 3.4.1 Identification of Major Pieces of Equipment 38
- 3.4.2 Controls and Electrical Estimate 39
- 3.4.3 Mechanical Engineering Estimate *39*
- 3.5 Estimate Preliminary Sizing of Major Equipment and Instruments 40
- 3.5.1 Preliminary Sizing of Major Equipment 40
- 3.5.2 Instrument Sizing 41
- 3.5.3 Estimation of Electrical Loads Based on Preliminary Horsepower 41
- 3.6 Metallurgy Selection of Major Equipment 42
- 3.6.1 Provide Preliminary Information on the Stream 42
- 3.6.2 Special Consideration for the Metallurgy 43
- 3.6.3 Most of the Services in Refinery Are Carbon Steel 43
- 3.6.4 Importance of a Metallurgy 44
- 3.7 Complete Simulations for Different Cases and Prepare IFE Quality HMB 45
- 3.8 Complete Studies 47
- 3.9 Preliminary Estimate of Utility Summary 47
- 3.9.1 Introduction to Utility Summary 47
- 3.9.2 Use of Utility Summary and Value Plus Suggestions 47
- 3.10 Participation in LOPA 49
- 3.10.1 What Is LOPA 49
- 3.10.2 Format of LOPA 49
- 3.10.3 LOPA Team 49
- 3.10.4 Difference Between LOPA and HAZOP 49
- 3.11 Prepare IFE Quality Design Basis 50

4 Phase 3 (Scope Development) 51

- 4.1 Perform Detailed Hydraulics 51
- 4.1.1 What Is Detailed Hydraulics 51
- 4.1.2 Examples of Criticality of Hydraulics 52
- 4.1.3 Importance of Design Safety Margin 52
- 4.1.4 Battery Limit Table Coupled with Hydraulics 53
- 4.1.5 Line Sizing Criteria for Hydraulics 54
- 4.2 Detail Design of Other Equipment 54
- 4.2.1 Heat Exchangers 54
- 4.2.2 Vessels 56
- 4.2.3 Columns 56
- 4.3 Input to Line List and the Process 57
- 4.4 Create Change Orders and Report Any Changes to Project 63
- 4.5 Process Data for Inline Instruments 64
- 4.5.1 Input to Inline Instrument Datasheets 64
- 4.5.2 How Process Engineers Get the Data 64
- 4.5.3 How Control System Use the Data 65

- 4.5.4 Data Checking and Work Process 65
- 4.6 Prepare Preliminary Safety Valve Evaluations 66
- 4.7 Prepare and Issue Equipment Datasheets 68
- 4.8 Communication with Other Disciplines, Projects, and the Customer 70
- 4.9 Participate in HAZOP 70
- 4.10 Follow Up and Implementation of HAZOP Items 71
- 4.11 Issue and Prepare IFR/IFH/IFA/IFD Quality P&IDs/PFDs/MSDs (Including Tie-in/Demo P&IDs) 72
- 4.12 Complete and Lead Line-by-Line Reviews of P&IDs 73
- 4.13 Prepare IFD Quality Design Basis 74
- 4.14 Issue IFD HMBs 74
- 4.15 Utility Summary IFD 75
- 4.16 Prepare DPDT Diagrams 75
- 4.17 Prepare Material Selection Diagram 76
- 4.18 Drafting of the Drawings and Backchecking 77
- 4.19 Input to 30% Model Reviews and Plot Plan Development 79
- 4.20 Input to Cost Estimate 80
- 4.21 Budget Estimate, Schedule, and Staffing Plan 80
- 4.21.1 Interactive Schedule Planning Meetings 80
- 4.21.2 Budget Preparation 81
- 4.21.3 Schedule and Dates 81
- 4.21.4 Staffing Plan 81
- 4.21.5 Project Status Progress and Tracking 86
- 4.22 Lead Workshare Meetings 87
- 4.23 Input to Internal Meetings with Project and Discipline Teams 88
- 4.24 Plant Visits 89
- 4.25 Input to Preparation of Demolition and Tie-in P&IDs 89
- 4.25.1 Tie-in P&IDs 89
- 4.25.2 Demo P&IDs 89
- 4.26 Preparation of Pipe Service Index 90
- 4.27 Process Audit 91
- 5 Phase 4 (Detailed Design) 95
- 5.1 Participate in the Final HAZOP 95
- 5.2 HAZOP Action Item Closeout and Hold Items 95
- 5.3 Project Support as Needed 96
- 5.4 Provide Offline Instrument Data 96
- 5.5 Squad Check of Process and Vendor Data 98
- 5.6 Finalize Safety Valves Design and Issue IFD Datasheets 99
- 5.7 Closeout of Documents 101
- 5.8 Input to 60% and 90% Model Reviews 101
- 5.9 Lead Workshare Meeting *102*
- 5.10 IFC and IFC-R P&IDs 102
- 5.11 Line List Updates and Input to New Lines 103
- 5.12 Leading MOC Meetings 103

- 5.13 Cause-and-Effect Table 105
- 5.14 Input to SP Items and Tie-in Forms 106
- 5.14.1 SP Items 106
- 5.14.2 Tie-in Forms 106

6 Phase 5 (Construction and Support) 109

- 6.1 Preparation of Procedures and Manuals *109*
- 6.2 Tie-in Execution 109
- 6.3 Provide Answers to the Construction Team 109
- 6.4 Updating P&IDs as Needed 111

7 Phase 6 (Commissioning and Startup) 113

- 7.1 Perform General Process Activities 113
- 7.2 Prepare and Complete Pre-startup and Safety Checklists 114
- 7.3 Check Performance Test of All the Equipment 116
- 7.4 Participate in Control System Loop Testing 116
- 7.5 Leak Testing 117
- 7.6 Drying-Out and Oxygen Freeing 118
- 7.7 Startup Assistance 118

Part III The Process Engineer 119

8 Role by Process Engineer's Position 121

- 8.1 Entry-Level Process Engineer 0 Years Experience 121
- 8.2 Junior Process Engineer 1–2 Years Experience 121
- 8.3 Mid-Level Process Engineer 3–6 Years Experience 121
- 8.4 Lead Process Engineers 7–10 Years Experience *122*
- 8.5 Senior Process Engineers 10–15 Years Experience *122*
- 8.6 Process Managers 15+ Years Experience 122
- 8.7 Competency Guide for Process Engineers 122

9 Interaction of Process Engineers with Others 137

- 9.1 Project Tree 137
- 9.2 Customer 138
- 9.3 Mechanical Engineer 139
- 9.4 Projects 140
- 9.5 Piping Design 140
- 9.6 Piping Engineering 141
- 9.7 Control System Engineer 141
- 9.8 Electrical Engineer 142
- 9.9 Civil Engineer 142
- 9.10 Construction Team 143
- 9.11 Cost Estimating 143
- 9.12 Project Controls 144

Contents

- 9.13 Licensor 144 9.14 Other EPCC Engineer 145 CAD and Drafting Coordinator 145 9.15
- Document Control 146 9.16

Ouestions 147 Answers 149 Acronyms 153

Appendix 155

Appendix A Project Conceptual Diagram 157

- A.1 Explanation of Figure A.1 157
- A.2 Explanation of Figure A.2 158
- A.3 Explanation of Figure A.3 158
- Explanation of Figure A.4 A.4 159
- Explanation of Figure A.5 A.5 160
- A.6 Explanation of Figure A.6 161
- A.7 Explanation of Figure A.7 162

Appendix B Project Schedule Diagrams 163

Explanation of Figure B.1 163 B.1

Project 3D Model and Plot Diagrams 165 Appendix C

- C.1 Explanation of Figure C.1 165
- C.2 Explanation of Figure C.2 166
- C.3 Explanation of Figure C.3 167
- C.4 Explanation of Figure C.4 167
- C.5 Explanation of Figure C.5 168

Appendix D Process Engineering Diagrams 171

- Explanation of Figure D.1 D.1 171
- D.2 Explanation of Figure D.2 171
- D.3 Explanation of Figure D.3 171

References 175

Index 177

x