

# FCC Riser - Density Profile

Tracerco has developed several non-intrusive radioisotope technologies to meet customer critical measurement needs that are able to diagnose FCC riser problems or optimize process design and conditions to maximize product throughput.

A TRU-SCAN® of the riser can be used to evaluate the performance of the injection system. Results from a riser TRU-SCAN® provide a catalyst density profile through the length of the riser. The results provide information on the length of the expansion zone where hydrocarbon mixes with the catalyst and cracks. (Figure 1).

Poor fluidization or poor mixing of the catalyst and hydrocarbon cause localized variances in the oil-to-catalyst ratio and cracking reactions. Over-cracked portions of the feed generate low-value light components, while at the same time the under-cracked portion produces more heavy residues.

While a TRU-SCAN® provides a vertical density profile down the length of the riser, a ThruVision™ study is performed at a fixed elevation on the riser cross-section to generate a detailed cross-sectional density profile showing flow distribution. Several measurements at selected vertical positions allows not only flow distribution to be measured but also changes to this as materials move upwards through the riser.

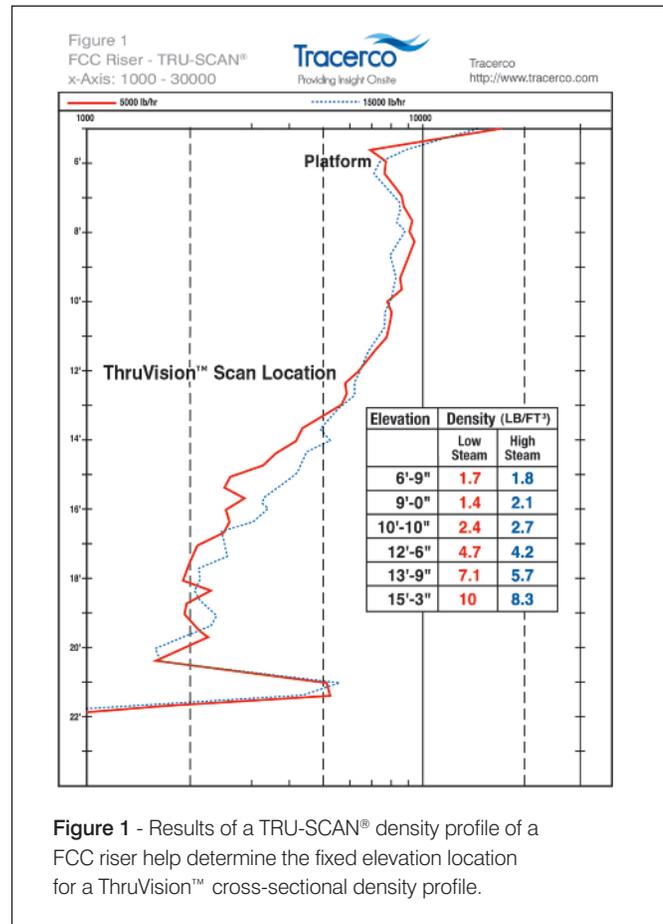
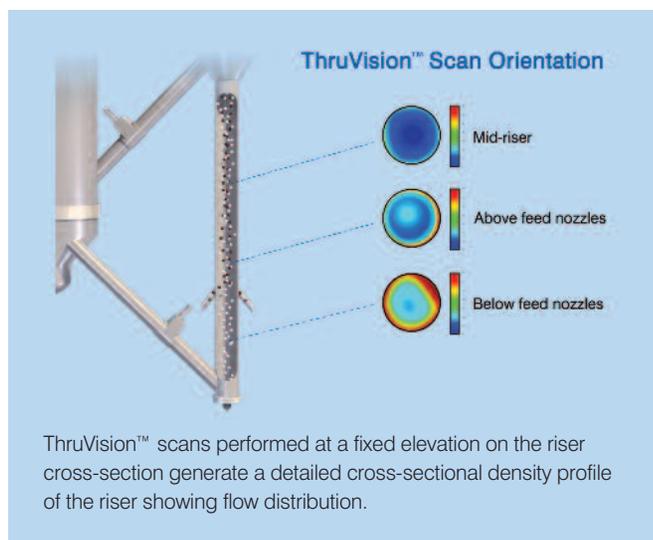
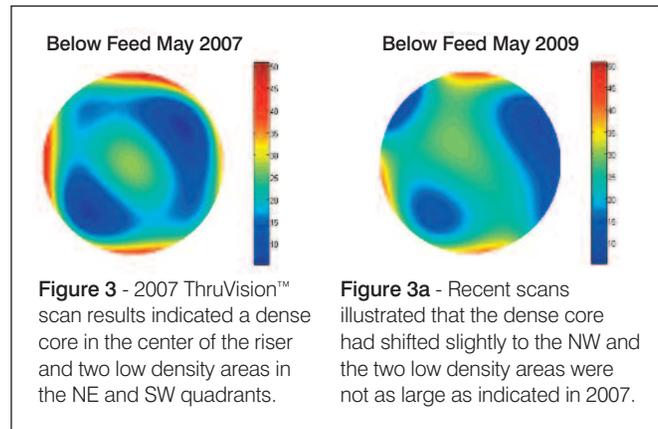
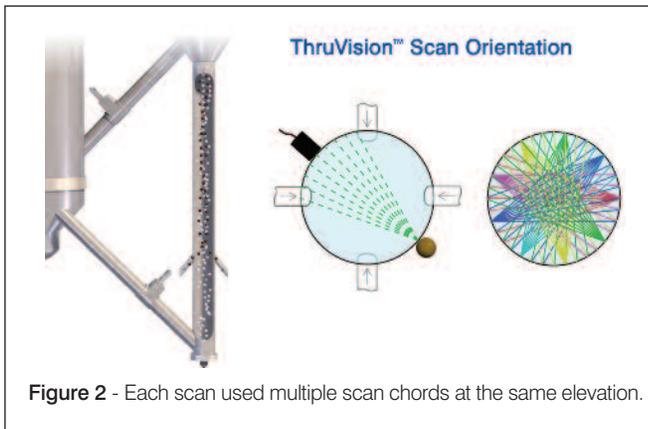


Figure 1 - Results of a TRU-SCAN® density profile of a FCC riser help determine the fixed elevation location for a ThruVision™ cross-sectional density profile.



## Project Field Test

A refiner requested riser ThruVision™ scans be performed for comparison of scans carried out two years previously to determine ongoing operational performance. Two ThruVision™ scan elevations were selected on the reactor riser with each scan segmented into multiple scan chords at the same elevation as illustrated in Figure 2.



## Project Analysis

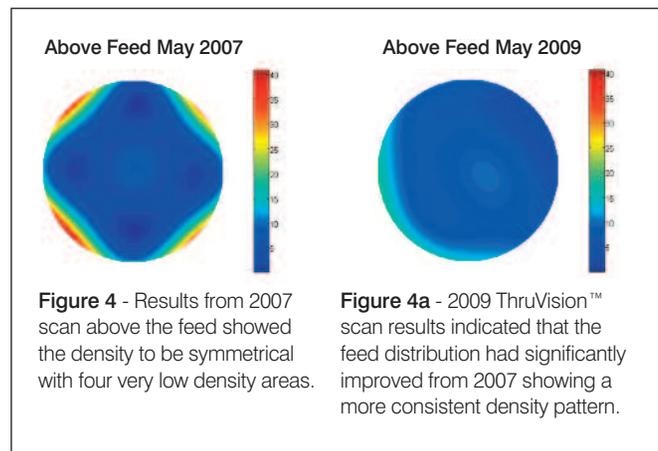
The first set of results illustrates density comparisons of scans performed below and above the feed nozzles. The 2007 scans (Figure 3) indicated a dense core in the center of the riser and two low density areas in the northeast and southwest quadrants. The recent scans illustrated that the dense core in the middle had shifted slightly to the northwest and the two low density areas in the northeast and southwest quadrants were not as large as indicated on the 2007 scans (Figure 3a).

The scan results from the second elevation, above the feed nozzles, are illustrated in Figures 4 and 4a. Results of the scan performed in 2007 (Figure 4) showed the density to be very symmetrical with four very low density areas, a dense core in the middle, and concentric rings of increasing density along the walls. The density ranged from 1 to above 20 lbs/ft<sup>3</sup> along the walls, with the majority of the flow between the 3 to 6 lbs/ft<sup>3</sup> density range.

ThruVision™ scan results from 2009 (Figure 4a) indicated that the feed distribution had significantly improved from 2007 showing a more consistent density pattern with the lowest density between 3 to 6 lbs/ft<sup>3</sup> along the east northeast wall of the riser. The central core density had increased from 6+ to 9+ lbs/ft<sup>3</sup> and the majority of the area was now between 6 to 9 lbs/ft<sup>3</sup>. The concentric rings of higher density that were present in 2007 scan results disappeared, with the highest densities now on the south and west walls.

## Customer Conclusion

Density profiles obtained from scans of the reactor riser can be useful to determine the uniformity of distribution between catalyst and feed, and to identify flow inefficiencies such as catalyst maldistribution. Tracerco Diagnostics™ FCCU studies have diagnosed operating problems and helped improve the performance of all major components of FCC units. Each project is customized to provide information needed to optimize or troubleshoot a specific process.



### For further information:

If you would like to obtain additional information on Tracerco's Process Diagnostics® technology please contact a technical advisor in your area to schedule an onsite presentation or visit our website at [www.tracerco.com](http://www.tracerco.com).

#### North American Headquarters

4106 New West Drive  
Pasadena, TX 77507, USA  
Tel 281 291 7769  
Fax 281 291 7709  
Toll Free 800 288 8970

#### Field Office Locations:

Corpus Christi, TX 78408, USA  
Tel 361 888 8233  
Concord, CA 94520, USA  
Tel 925 687 0900  
Paramount, CA 90723, USA  
Tel 562 633 8800  
Newark, DE 19702, USA  
Tel 302 454 1109

Merrillville, IN 46410, USA  
Tel 219 945 0400

Baton Rouge, LA 70820, USA  
Tel 225 761 0621

Salt Lake City, UT 84119, USA  
Tel 801 478 0736

Edmonton AB, T6E 6A6, Canada  
Tel 1 780 469 0055

Sarnia, N7S 5G5, Canada  
Tel 1 519 332 6160

Calgary, AB, T2Y 2Z7, Canada  
Tel 1 403 931 6705

Rio de Janeiro, RJ, Brazil,  
CEP 22775-044  
Tel +55 21 3385 6800