

Plants, terminals and equipment  
for the entire LNG value chain

# Paving the way for LNG



Making our world more productive

## Introduction

Driven by increasing natural gas demand and decreasing costs along the whole LNG value chain (due to significant economies of scale, improvements in technologies, etc.), investments in LNG infrastructure are growing rapidly in the last years. LNG has turned from being an expensive and regionally traded fuel to a globally traded source of energy with rapidly diminishing costs.

In China, Norway and lately in particular in the US, petroleum fuels have been successfully substituted by LNG in various applications, mainly for heavy trucking, remote-power generation and marine fueling. Today the volumes are still relatively small, however studies indicate substantial demand for additional domestic LNG capacities in many countries. These include the entire Baltic Area (ECA) and South East Asia. As a consequence, an appropriate infrastructure consisting of small- to mid-scale LNG liquefaction plants, import terminals and refuelling stations will be built up and/or expanded.

With more than 125 years of comprehensive experience in the handling of cryogenic liquids, Linde Engineering has a track record in the design and performance of a wide range of natural gas projects including upstream natural gas liquids recovery (NGL plants), feed gas pre-treatment and liquefaction, transport and distribution of LNG regasification in both LNG import and export terminals.

Linde Engineering is well recognised as a reliable technology provider and EPC contractor, both by its customers and the financial world. In-house manufacturing capabilities for core cryogenic equipment, such as heat exchangers (both coil-wound and plate-fin type), vaporisers, pumps, expanders and vacuum-insulated piping, complement Linde Engineering's unique profile and enable it to customise the process design and core equipment. Linde Engineering's integrated project management concept assures the handling of complex interfaces and delivers a plant, equipment or packaged unit in due time and quality.

Linde offers innovative and economical solutions for the entire LNG value chain and has more than 40 years experience in designing, building and operating LNG plants and proprietary cryogenic equipment.



# Linde brochures

## NGL/LNG plants and LNG terminals

- Natural gas liquid recovery. CRYO-PLUS™ technology.
- Natural gas production in Stavanger.
- Baseload LNG production in Xin Jiang.
- LNG technology.
- Gateways to clean energy. LNG import terminals.

## Cryogenic equipment and packaged units

- Cryostar: Equipment and expertise for industrial gas, LNG, hydrocarbons and clean energy
- Cryostar: Turbo expanders for cold production and energy recovery
- Cryostar: High-pressure pumps
- Cryostar: Small-scale liquefaction and distribution, biomethane and natural gas
- Aluminum plate-fin heat exchangers
- Coil-wound heat exchangers
- Coldboxes
- Manufacturing
- EcoREL shipboard reliquefaction plant for LNG carriers
- LNG dispensers
- Columns and pressure vessels
- Vaporisation of cryogenic fluids
- EcoVAP LNG regasification plants
- Air-heated vaporisers
- Water-bath vaporisers

## Abbreviations

PFHE	Plate-Fin Heat Exchanger
CWHE	Coil-Wound Heat Exchanger
BOG	Boil-Off Gas
FGSS	Fuel Gas Supply System
FPSO	Floating Production Storage and Offloading
FSRU	Floating Storage Regasification Unit

HPP	High-Pressure Pump
SMR	Single Mixed Refrigerant
mmscfd	million standard cubic feet per day
tpd	tonnes per day
mtpa	million tonnes per annum
ECA	Emission Control Area

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# Linde along the LNG value chain. Cryogenic equipment and packaged units.

## NG processing (upstream) and NG delivery by pipeline



## NG liquefaction



### Process units/EPC

- Dehydration units
- C<sub>2</sub>/C<sub>3</sub> recovery, fractionation/isomerisation
- Caustic washing
- Sulphur recovery
- Nitrogen rejection
- Cryogenic methane purification
- Helium recovery, purification and liquefaction
- Helium storage (Helicon tank container)
- Cryogenic CO<sub>2</sub> rejection

- Hg removal
- Amine washing
- Mole sieve dehydration
- HHC removal
- NG liquefaction (series of patented processes with Mixed Refrigerant or Nitrogen Expansion Cycle)
- LNG storage tanks (flat-bottom, bullets, spheres)

### Equipment/package units

- PFHE
- Coldboxes
- Cryogenic expander with cryogenic compressor and possible oil brake from 2–12 MW (TC series)
- Expander with process compressor and active magnetic bearings from 2–12 MW (MTC series)
- Expander with generator and oil-lubricated bearings from 2–12 MW (TG series)
- Hydrocarbon condensate and LPG pumps
- Pressure let-down: single and two-stage turbine (0.5–12 MW)
- Hermetic turbine (150–600 kW)
- Block-in-kettle PFHE
- Helium liquefier

- CWHE
- PFHE
- Coldboxes
- NG and biogas liquefaction units for capacities up to 100 tpd
- Return gas blowers/BOG compressors
- Cryogenic expanders with cryogenic compressors and possible oil brakes (TC series)
- Expanders with process compressors and active magnetic bearings (MTC series)
- Expanders with generators and oil-lubricated bearings (TG series)
- Cryogenic liquid expanders with generators (LTG series)
- Hydrocarbon condensate and LPG pumps, Nitrogen compressors, new compressors (5 wheels), vertical sealless VS pumps
- EcoLNG micro-scale liquefaction units
- Sub-X<sup>®</sup> submerged combustion vaporisers for peak shaving plants

## LNG shipping/distribution/regasification

LNG shipping incl. FPSO, FSRU, supply regasification vessel



LNG distribution



LNG terminals and regasification



### Process units/EPC

- Floating LNG (Topsides, at least liquefaction island), CO<sub>2</sub> pre-cooled LNG processes
- Complete LNG/CLNG fuelling station
- Complete small- to mid-scale LNG import terminals
- World-scale LNG import terminals (design and manufacturing of main equipment)
- LINORC™ (Linde Organic Rankine Cycle unit)

### Equipment/package units

- PFHE
- Coldboxes
- LNG tanks
- EcoBOT and EcoREL (BOG reliquefaction systems for large carriers), BOG handling systems, BOG compressors, BOG FGSS incl. HPP pumps, NG heaters, EcoVAP, LNG (sendout) vaporisers/FSRU regas packages
- Turbines and compressors for expander liquefaction cycles
- Water-bath vaporisers (for Nitrogen)
- Standard tanks (bullet-type, flat-bottom)
- LNG pumps SUBTRAN (60 kW) and possible dispensing systems
- Water-bath vaporisers
- LNG/CNG re-fuelling stations (equipment)
- Reciprocating and centrifugal submerged pumps
- Ambient air vaporisers (up to 500 bar)
- Larger pumps for transfer and re-fuelling stations
- Dispensers incl. payment protocol interface
- BOG compressors
- Return gas blowers
- LNG vaporisers (water-bath, air-heated or Sub-X® submerged combustion type)
- Wobbe Index control
- LIN booster and LIN HP pumps
- LIN vaporisers
- Truck loading pumps

# Linde along the LNG value chain. NGL/LNG plants and LNG terminals.

NG processing (upstream) and NG delivery by pipeline



NG liquefaction

Small-scale liquefaction plants



Mid-scale liquefaction plants



World-scale liquefaction plants



## Linde technology

CRYO-PLUS™ customised and standard plant concept for NGL C<sub>2</sub>/C<sub>3</sub>, recovery and fractionation

StarLNG™ standard plant concept with SMR (LIMUM® 1) or Nitrogen Expansion Cycle liquefaction process

StarLNG™ standard plant concept with SMR (LIMUM® 3)

Patented MFC®/MFC® 3 triple mixed refrigerant cycle process

## EPC or EP scope

Process plants including pre-treatment, utilities and truck loading, optional: nitrogen rejection, methane purification, integration with LNG plant

Process plants incl. pre-treatment, utilities, LNG storage and ship/truck loading facilities, HHC removal, nitrogen rejection

Process plants incl. pre-treatment, utilities, LNG storage and ship/truck loading facilities, HHC removal, nitrogen rejection

Process plants incl. pre-treatment, utilities, LNG storage and ship/truck loading facilities, optional: integrated NGL recovery, nitrogen rejection, He recovery, purification and liquefaction

## Proprietary equipment

Engineering, design, fabrication and site construction of process modules and key cryogenic equipment

Engineering, design, fabrication and site construction of process modules and key cryogenic equipment, e.g. PFHE/coldbox, LNG storage facility (bullet tanks up to 1,250 m<sup>3</sup>), cryogenic expander, LNG pump, cryogenic vessel

Engineering, design, fabrication and site construction of process modules and key cryogenic equipment, e.g. PFHE/coldbox or CWHE, LNG storage facility (pressurised sphere or atmospheric flat-bottom tank), cryogenic expander, LNG pump, cryogenic vessel

Engineering, design, fabrication and site construction of process units and key cryogenic equipment, e.g. CWHE, LNG storage facility (atmospheric flat-bottom tank) with partner companies, LNG pump, cryogenic vessel, PFHE

## Reference projects

- (Number of trains × capacity in mmscfd)
- Canadian County (USA) 1 × 150
- Parachute Creek (USA) 1 × 350
- Mayfield Western Oklahoma (USA) 1 × 200
- Cottonwood (USA) 1 × 60
- McKenzie City (USA) 1 × 100
- Stateline I+II (USA) 2 × 100
- Canadian Valley (USA) 1 × 200
- Williston (USA) 1 × 100
- Poza Rica (Mexico) 1 × 200
- Tamaulipas (Mexico) 2 × 200
- Constanta (Romania) 1 × 140

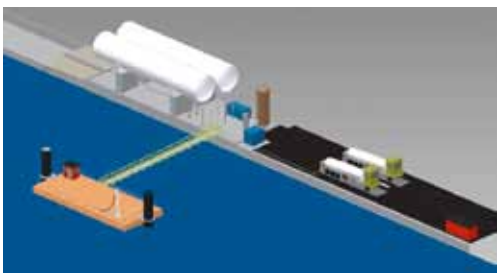
- Bergen (Norway) 120 tpd/0.04 mtpa
- Kwinana (Australia) 180 tpd/0.06 mtpa

- Stavanger (Norway) 900 tpd
- Tuha (China) 1,300 tpd
- Beichuan (China) 813 tpd
- Jimunai (China) 1,200 tpd
- Jincheng (China) 1,337 tpd
- Xinghe (China) 1,357 tpd
- Bazhong (China) 960 tpd
- Barra do Riacho (Brazil), FEED import/export LNG terminal
- 2 × 1.25 mtpa liquefaction
- Marlin/Bintulu (Malaysia) 1,840 tpd boil-off gas reliquefaction

- Hammerfest (Norway) 1 × 4.3 mtpa
- Puerto La Cruz (Venezuela) FEED 1 × 4.3 mtpa

## LNG bunkering and terminal storage

### LNG bunkering



### Small-scale LNG import terminals



### Mid-scale LNG import terminals



### World-scale LNG terminals



### EPC or EP scope

Complete bunkering station including own bullet tanks up to 1,250 m<sup>3</sup>

Complete LNG import terminal

Complete LNG import terminal including LNG storage tanks (flat-bottom LNG tanks with partners), LNG vaporiser and reconderiser

LNG import terminal excluding LNG storage tanks (by partners only), LNG vaporiser and reconderiser

### Proprietary equipment

Engineering, design, fabrication and site construction of key cryogenic equipment and systems, e.g. LNG pump and dispensing system, water-bath vaporiser, LNG subcooling system with LIN for BOG handling

Engineering, design, fabrication and site construction of key cryogenic equipment and systems, e.g. truck loading station, BOG compressor, return gas blower, LNG subcooling system with LIN for BOG handling, steam-heated vaporiser

Engineering, design, fabrication and site construction of key cryogenic equipment and systems, e.g. BOG compressor, return gas blower, LNG vaporiser, Wobbe Index control, LIN booster and LIN HP pump, LIN vaporiser

Engineering, design, fabrication and site construction of key cryogenic equipment and systems, e.g. flat-bottom LNG tanks, BOG compressor, return gas blower, LNG vaporiser, Wobbe Index control, LIN booster and LIN HP pump, LIN vaporiser, Organic Rankine Cycle key components

### Reference projects

- Rotterdam (Netherlands), basic engineering 1 × 500 m<sup>3</sup> pressurized bullet LNG storage tank (future extension 2 × 500 m<sup>3</sup>), truck loading with 2 × 70 m<sup>3</sup>/h loading bays
- Bremerhaven (Germany), as above
- Hamburg (Germany), as above
- Agotnes (Norway) 1 × 450 m<sup>3</sup> pressurized bullet LNG storage tank

- Pori (Finland), FEED 5 × 1,000 m<sup>3</sup> pressurized bullet LNG storage tanks (future extension 4 × 1,000 m<sup>3</sup>), truck loading with 2 × 70 m<sup>3</sup>/h loading bays

- Nynäshamn (Sweden) 12.7 tph regasification rate, 20,000 m<sup>3</sup> full containment LNG tank, truck loading with 2 × 75 m<sup>3</sup>/h loading bays
- Lysekil (Norway), 21 tph regasification rate, 30,000 full containment LNG tank, truck loading with 2 × 100 m<sup>3</sup>/h loading bays

- Barra do Riacho (Brazil), FEED LNG import terminal 435 tph regasification rate, 2 × 160,000 m<sup>3</sup> full containment LNG storage tanks with membrane technology

# Your partner for the production and processing of gases

## Delivering reliable process plants for maximum capital efficiency

Linde has been optimizing gas processing technologies for 140 years, successfully delivering more than 4,000 plant engineering projects around the globe. Favoring trusted, lasting business relationships, the company collaborates closely with customers to enhance plant lifecycle productivity and innovate process flows. The company's proven gas processing expertise plays an indispensable role in the success of customers across multiple industries – from natural gas and oil refining through petrochemicals and fertilizers to electronics and metal processing.

## Operational excellence along the entire plant lifecycle

We work closely with our customers to gain an in-depth understanding of individual needs. Building on the unique synergies of Linde as an integrated plant operator and engineering company, Linde offers innovative process technologies and services to exceed our customers' reliability and profitability expectations. This commitment to innovation extends along the entire plant lifecycle. The LINDE PLANTSERV® service team supports customers every step of the way – from maintenance and repairs to full revamps. Leveraging the latest digital technologies to offer on-site and remote operational and support services, we consistently take asset performance to the next level.

## Making the impossible possible

From the desert to the Arctic, from small- to world-scale, from standardized to customized designs, Linde's engineering specialists develop solutions that operate under all conditions. The company covers every step in the design, project management and construction of gas processing plants and components. Customers can always rely on Linde to deliver the plants, components and services that fit their needs best – anywhere in the world.

Discover how we can contribute to your success at [www.linde-engineering.com](http://www.linde-engineering.com)

Get in touch with our natural gas plants team:

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## Core competencies at a glance

### Plant engineering

- Air separation plants
- LNG and natural gas processing plants
- Petrochemical plants
- Hydrogen and synthesis gas plants
- Adsorption plants
- Cryogenic plants
- Carbon capture and utilization plants
- Furnaces, fired heaters, incinerators

### Component manufacturing

- Coldboxes and modules
- Coil-wound heat exchangers
- Plate-fin heat exchangers
- Cryogenic columns
- Cryogenic storage tanks and containers
- Air-heated vaporizers
- Water bath vaporizers
- Spiral-welded aluminum pipes

### Services

- Revamps and plant modifications
- Plant relocations
- Spare parts
- Operational support, troubleshooting and immediate repairs
- Long-term service contracts
- Expert reviews for plants, operations and spare part inventory
- Operator training