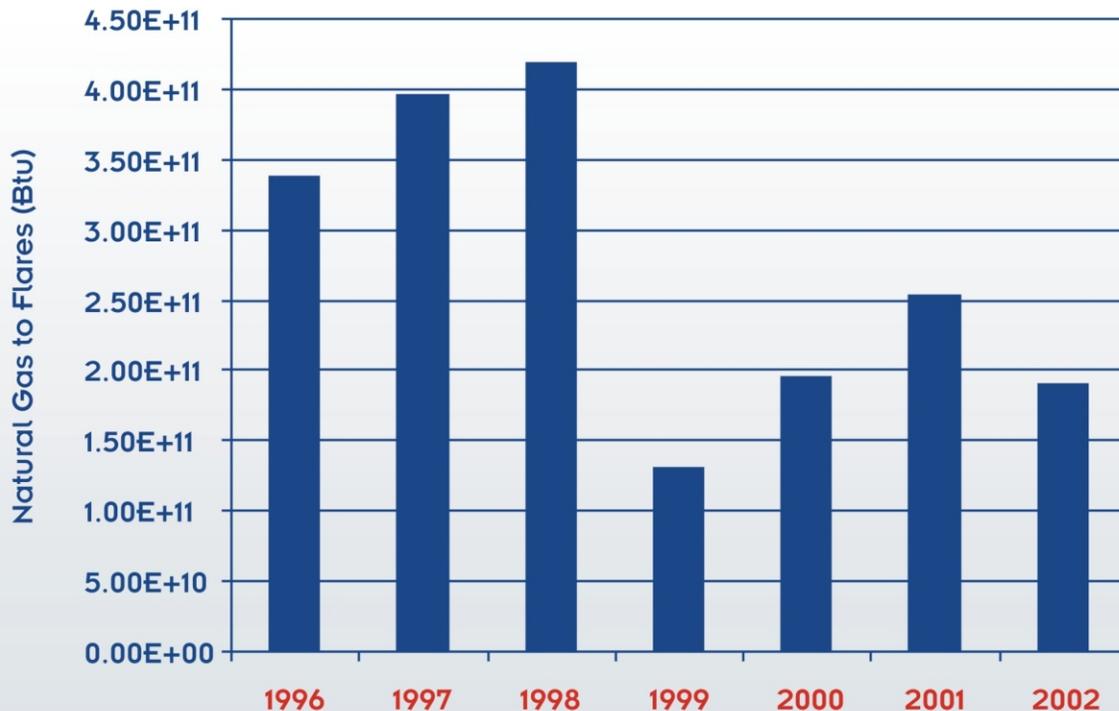


Flare System Improvements



Natural gas consumption has declined in the cross-connected flares since 1996, in spite of the start up of a new flare in 2000.

- ▶ As permitted under new environmental regulations, the plant has replaced natural gas with a by-product fuel containing hydrogen as a cofeed to waste gases prior to flaring.
- ▶ Improvements reduce excess natural gas use in the rimfire burners on all flares.
- ▶ Planning and coordinating unit outages in cross-connected flares increase thermal oxidizer utilization and decrease flaring time. Improvements to the analyzer maintenance program and instrument system reliability reduce trips by the oxidizer. Both improvements provide natural gas savings.

Benefits

- ▶ Reduces natural gas use by 90 MMBtu per hour.
- ▶ Reduces NO_x by 27 tons per year.
- ▶ Reduces CO by 55 tons per year.



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