

VELAN

The World Leader in

Coker Ball Valves



PROFILE

Velan is one of the world's leading manufacturers of industrial steel valves, supplying gate, globe, check, ball, butterfly and knife gate valves for critical applications in the chemical, petrochemical, oil and gas, fossil and nuclear power, cogeneration, pulp and paper and cryogenic industries. See the back cover of this catalog for a summary of the many quality products that Velan designs and manufactures.

Founded in 1950, Velan earned a reputation for excellence as a major supplier of forged valves for nuclear power plants and the U.S. Navy. Velan Inc. pioneered many designs which became industry standards, including bellows seal valves, all stainless steel knife gate valves and forged valves up to 24".

Velan valves are manufactured in 12 specialized manufacturing plants, including five in Canada & U.S.A., four in Europe and three in Asia. We have over 1,600 employees, 75% of whom are located in our North American operations.

A considerable leap forward in Velan technology was the introduction of forgings for valves larger than 2" (50 mm), and up to 24" (600 mm), for higher safety applications. Velan forged valves offer greater strength and increased toughness for maximum reliability and safety. They have become the first choice of fossil and nuclear power stations, the navy and for all severe and critical applications in the chemical and hydrocarbon processing industries.

CONTENTS

Coker Ball Valve Reliability Worldwide.....	1
Complete Range Of Delayed Coker Ball Valves	2
Four-Way Switch Valves.....	3
Isolation Valves.....	4
Ring Valves (For Backpressure Control)	5
High Pressure (Hydrodrill) Valve ...	5
Logic Control Panel	5
Focus On Delayed Coker Applications.....	6

HEAD OFFICE & PLANT 5



MONTREAL, CANADA 115,000 sq. ft. (10,683 m²)
2–60" (50–1500 mm) dual plate check valves, 3–48" (80–1200 mm) triple-offset butterfly valves,
3/8–2" (10–50 mm) metal & resilient seated ball valves

MANUFACTURING LOCATIONS

CANADA

VELAN INC.
**HEAD OFFICE &
PLANT 5**
7007 Côte de Liesse
Montreal, QC H4T 1G2
Tel: (514) 748-7743
Fax: (514) 748-8635

PLANT 1
2125 Ward Avenue
Montreal, QC H4M 1T6
Tel: (514) 748-7743
Fax: (514) 748-8635

PLANT 2 / 7
550 McArthur Ave.
Montreal, QC H4T 1X8
Tel: (514) 748-7743
Fax: (514) 341-3032

PLANT 4 / 6
1010 Cowie Street
Granby, QC J2J 1E7
Tel: (450) 378-2305
Fax: (450) 378-6865

U.S.A.
**VELAN VALVE
CORPORATION**
PLANT 3
94 Avenue C
Williston, VT 05495-9732
Tel: (802) 863-2562
Fax: (802) 862-4014

ENGLAND

VELAN VALVES LTD.
Unit 1, Pinfold Road
Lakeside Business Park
Thurmaston
Leicester LE4 8AS
Tel: 44-116 269-5172
Fax: 44-116 269-3695

ITALY

VELAN SRL
Via Delle Industrie 9/5
20050 Mezzago,
Tel: (39) 039 624-1101
Fax: (39) 039 688-3357

FRANCE

VELAN S.A.S
90, rue Challemeil Lacour
F 69 367 Lyon Cedex 7
Tel: (33) 4 78 61 67 00
Fax: (33) 4 78 72 12 18

PORTUGAL

**VELAN VÁLVULAS
INDUSTRIAIS, LDA.**
Av. Ary dos Santos
1679-018 Farnoes
Tel: (351-21) 934-7800
Fax: (351-21) 934-7809

TAIWAN

VELAN-VALVAC
P.O. Box 2020
Taichung, Taiwan
R.O.C.
Tel: (04) 2792649
Fax: (886) 42750855

KOREA

VELAN LTD.
1060-4 Shingil-Dong
Ansan City,
Kyunggi-do 425-833
Tel: (82) 31-491-2811
Fax: (82) 31-491-2813

DISTRIBUTION CENTERS

U.S.A.

VELCAL
537 Stone Road, Unit "A"
Benicia, CA 94510
Tel: (707) 745-4507
Fax: (707) 745-4708

VELEAST
605 Commerce
Park Drive SE
Marietta, GA 30060
Tel: (770) 420-2010
Fax: (770) 420-7063

VELNORTH
94 Avenue C
Williston, VT 05495-9732
Tel: (802) 651-0867
Fax: (802) 865-3030

ENGLAND

VELAN VALVES LTD.
Unit 1, Pinfold Road
Lakeside Business Park
Thurmaston
Leicester LE4 8AS
Tel: 44-116 269-5172
Fax: 44-116 269-3695

GERMANY

VELAN GmbH
Daimlerstrasse 8
D-47877 Willich
Tel: (49) 2154-4938-0
Fax: (49) 2154-4938-99

Velan has sales offices & distributors located worldwide.

Visit the Velan website at www.velan.com
for an updated contact list.

JOSE DEL BUEY - PRODUCT MANAGER

Tel: (514) 748-7743 ext. 5277
Fax: (514) 908-0213
E-mail: jdelbuey@velanvalve.com

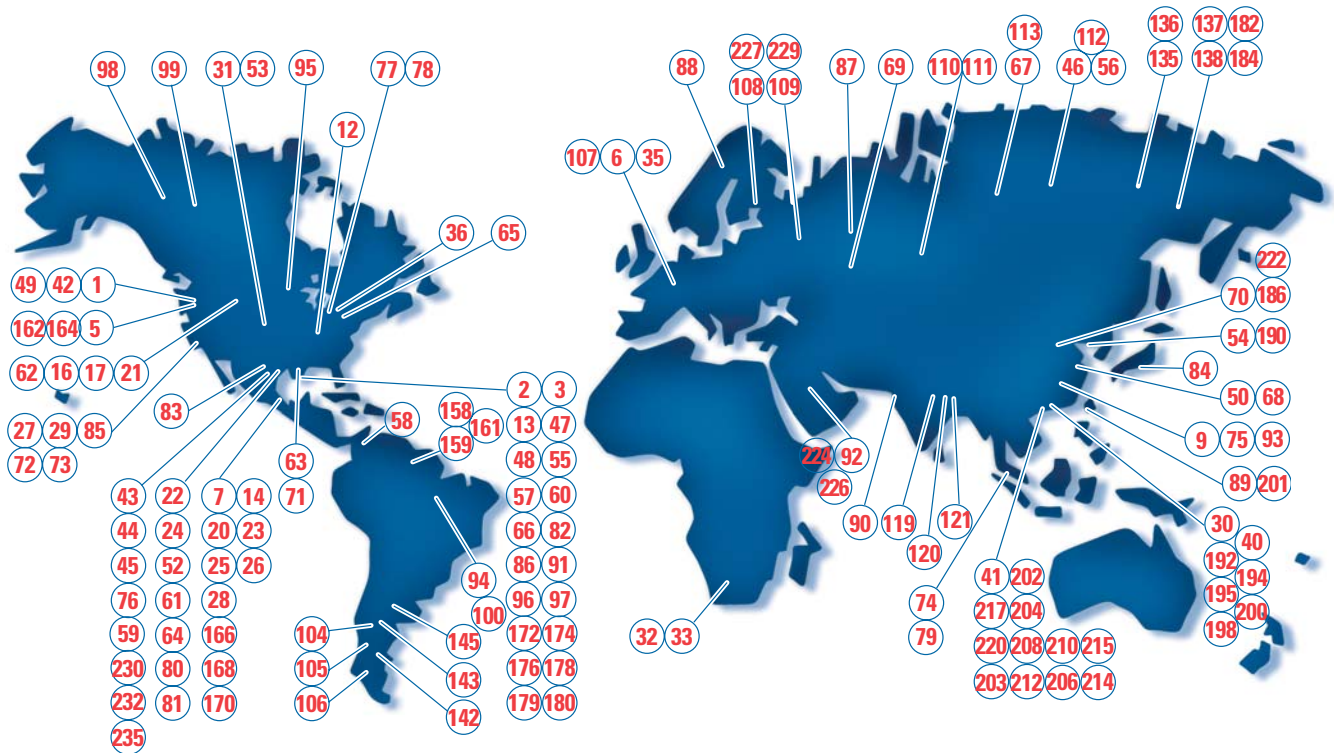
GENERAL INFORMATION

Tel: (514) 748-7743
Fax: (514) 748-8635
sales@velan.com

NOTE: The material in this catalog is for general information only and shall not be used for specific performance data and material selection without first consulting Velan. Velan reserves the right to change designs, materials or specifications without notice. Velan does not accept any liability or damages arising from the use of information in this catalog.

COKER BALL VALVE RELIABILITY WORLDWIDE

DELAYED COKERS WORLDWIDE CHOOSE VELAN COKER BALL VALVES



(Locations shown are currently using Velan Coker Ball Valves)

OVER 20 YEARS EXPERIENCE

The first switch valve built to our design was installed in 1983. It operated 10 years before it was taken out of service for evaluation. The internal components were in perfect condition. The valve was reinstalled using the original components.

Since then we have installed over 235 delayed coker switch valves worldwide.

WORLDWIDE REFERENCES (as of April 2002)

Velan Delayed Coker Valves are currently installed in over 121 Delayed Coker Units (DCU) worldwide.

This includes over 235 four-way switch valves, some of which have been in service for over 20 years.

Also currently installed are over 1350 isolation valves in the following applications:

- Inlet Transfer Line
- Drain
- Heater Isolation
- Blowdown
- Vent
- Bypass
- Quench
- Overhead Vapor
- Backpressure Control
- Hydrodrill Water Cutting

We have also supplied over 450 logic control panels with hard-wired or Programmable Logic Controller (PLC) driven logic. Many of our panels now interface with a PLC or directly with a Distributive Control System (DCS) for remote indication or operation.

These valves are not modified, commodity Valves. They are specifically designed for delayed coker applications.



VELAN DELAYED COKER BALL VALVES

COMPLETE RANGE

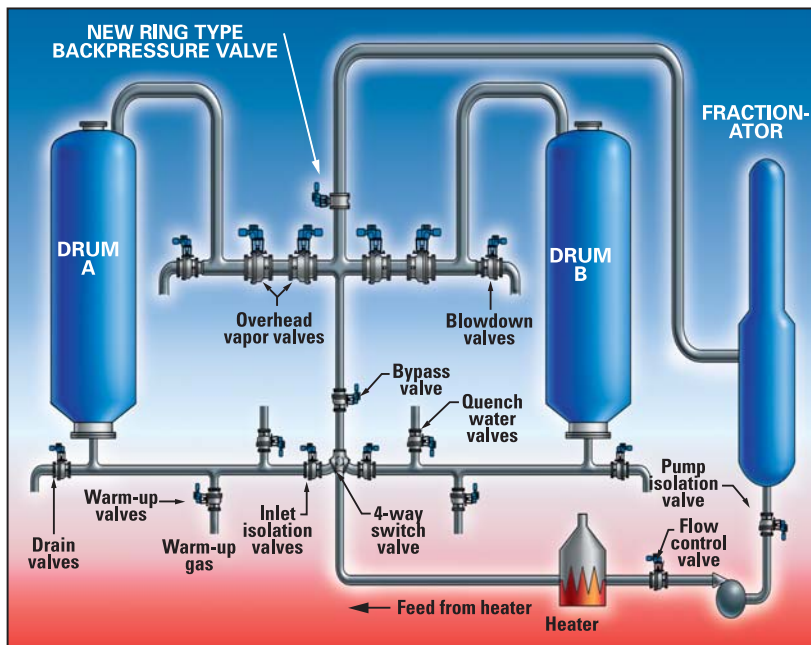
Velan currently supplies valves for delayed coker applications in the widest range of sizes and pressure classes (with a proven track record) in the industry. We have supplied the following valves:

- ✓ Four-Way Switch Valves
6 - 16" – ASME Classes: 300 - 900
- ✓ Isolation Valves
6 - 36" – ASME Classes: 150 - 900
- ✓ HP Water Valves
2 - 8" – ASME Classes: 1500 - 2500
- ✓ Steam Valves
1/4 - 2" – ASME Classes: 300 - 1500

Three years ago we supplied the largest four-way switch valves (16") currently installed in a delayed coker application anywhere.

Over the last five years, we have also supplied the largest overhead vapor and blowdown valves (30"). These are currently installed in nine delayed cokers in the U.S., China and the Middle East.

Valves are generally supplied in high temperature alloys such as C12 and C5, but are also offered in WCB for slightly lower temperature applications (i.e., secondary blowdown).



Velan offers a complete range of valves for all coker applications.

DESIGN FEATURE COMPARISONS

Velan Ball Valves offer a number of advantages for delayed coker service, for example:

ADVANTAGES	VELAN BALL	MODIFIED COMMODITY BALL	PLUG
EXPERIENCE	Over 700 valves are currently installed in delayed cokers worldwide. Valves have been in service 1983.	Few installations and, in some cases, a short time period in service make it difficult to evaluate performance.	Certain essential design features have limited their use in newer installations.
AUTOMATION RELIABILITY	Single 90° rotary motion allows for simple, inexpensive and reliable actuation.	Few installations and, in some cases, a short time period in service make it difficult to evaluate performance.	Automation requires accommodating linear and rotary motion. The mechanism to achieve this continues to be a maintenance concern.
SEALING	Sturdy bellows maintain constant ball to seat contact, and as a result avoid a buildup of coke on the sealing surfaces. A positive seal is maintained through the life of the valve.	Seat loading methods for delayed coker applications have yielded mixed results, e.g.: 1. Weak springs allow the buildup of coke between the ball and seat, which may result in poor sealing. 2. Belleville-type springs load adequately, but have shown some difficulties in adapting to high temperature coking environments.	The "lift and reseat" method allows for the accumulation of coke between seat and plug every time the plug is lifted. In fact, the coke is compacted into the seating area every time the valve is resealed. The ensuing coke buildup may result in poor sealing.
FULL BORE	Standard. Valves are lightweight and compact.	Available. In some cases valves are 10-50% heavier.	Available. Valves are substantially larger and up to 50-200% heavier.
MAINTENANCE	Seats are easily and quickly replaced.	Certain manufacturers rely on integral seats. These seating areas are difficult to service as they often form an integral part of the body end. As a result, the end user may have to rely on a spare body end, which is costly and still requires lapping. Depending on the valve's size, lapping may be difficult.	Seating areas that require weld repair may be difficult to service as they form an integral part of the body. Substantial weld repair of C5 or C12 castings necessitates PWHT, which may further complicate the process of repairing previously machined surfaces.

The above comparison table is intended to highlight some of the advantages of Velan coker ball valves and is not intended to downgrade competitors designs.

FOUR-WAY SWITCH VALVES

OVER 235 VELAN FOUR WAY SWITCH VALVES IN DELAYED COKER INSTALLATIONS

FOUR-WAY VALVE DESIGN FEATURES:

AUTOMATION

The electric, hydraulic or pneumatic actuator is selected in function of coker service. A large torque safety factor ensures the valve will cycle under the most stringent conditions. When selecting actuators, special attention is paid to the coker deck environment.

The Stem Coupling is designed to perform 3 main functions:

- ✓ Protect against "overtorquing" of the stem.
- ✓ Protect the actuator components.
- ✓ Protect against an unintentional switch.

VALVE

A Lantern Ring with steam block and extra deep stuffing box minimizes the risk of leakage occurring through the packing chamber. Live-loading is available on request.

The Sturdy One-Piece Ball and Stem provides optimal strength, and is well suited to applications where fouling due to coke fines are a concern. The one-piece design avoids the problems generally associated with the more conventional two-piece ball and stem, which is highly susceptible to solids buildup in the ball-stem joint and a resulting increase in operating torques.

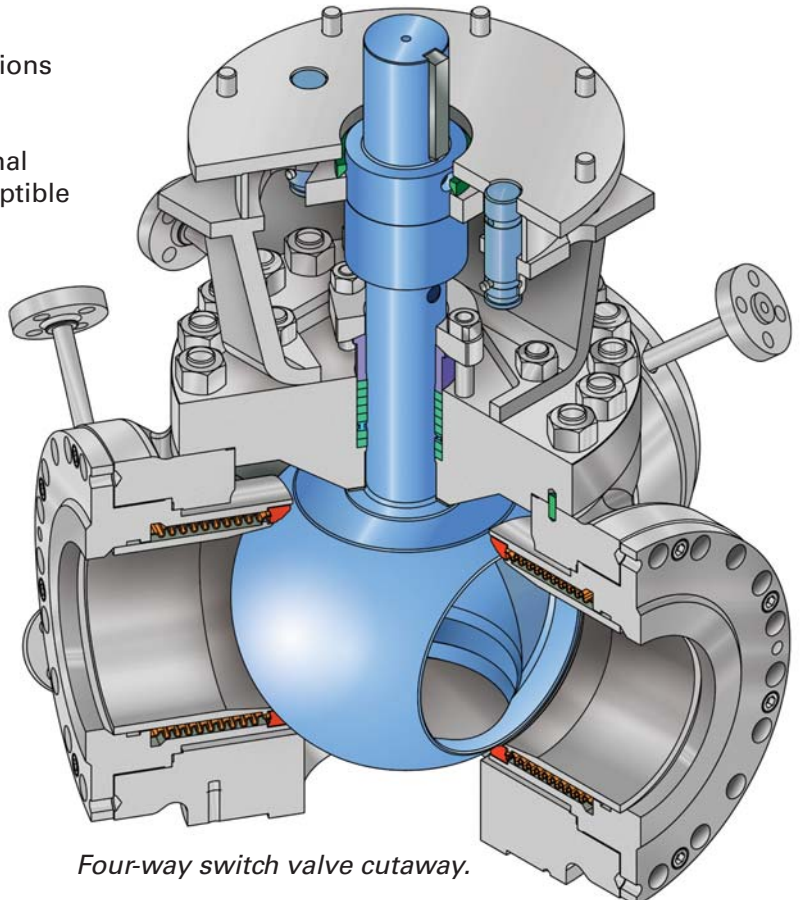
Strong Bellows offer a unique seat loading design that maintains the floating seats in constant contact with the ball and ensures a positive seal.

Scraper Type Seats "scrape" coke buildup from the surface of the ball during each cycle. Seats are hard- faced to ensure a long, trouble-free service life.

Steam Purges to bellows and body area ensure the valve cavities are kept free of coke buildup.



The adjacent photograph shows a 12" switch valve installed with the stem in the horizontal position. The valve is installed in a delayed coker unit, where the valves were interlocked through a DCS for safer operation. Our logic control panel allows the valve to be operated both locally or remotely.



Four-way switch valve cutaway.

ISOLATION VALVES

OVER 1350 VALVES OF THIS DESIGN IN DELAYED COKER INSTALLATIONS



The valves shown in the adjacent photograph were installed as part of a debottleneck project aimed, among other things, at increasing the units' liquid yield. As this was an existing structure it was important to minimize piping changes. Because the existing valves were 70% plug valves the engineering firm evaluated full bore plug valves, but found the units' weights to be substantially higher. Rather than evaluate the structural changes required in order to accept these heavier, larger units the end user opted to use our lighter full bore ball valves. As a bonus, the ball valves provided a better seal than was possible with the previous valves. Two years later the same end user installed 24" Velan Overhead Ball Valves on their number 2 coker.

ISOLATION VALVE FEATURES:

AUTOMATION

The electric, hydraulic or pneumatic actuator is selected in function of coker service. A large torque safety factor ensures the valve will cycle under the most stringent conditions. When selecting actuators, special attention is paid to the coker deck environment.

The Stem Coupling is designed to perform 2 main functions:

- ✓ Protect against "overtorquing" of the stem.
- ✓ Protect the actuator components.

VALVE

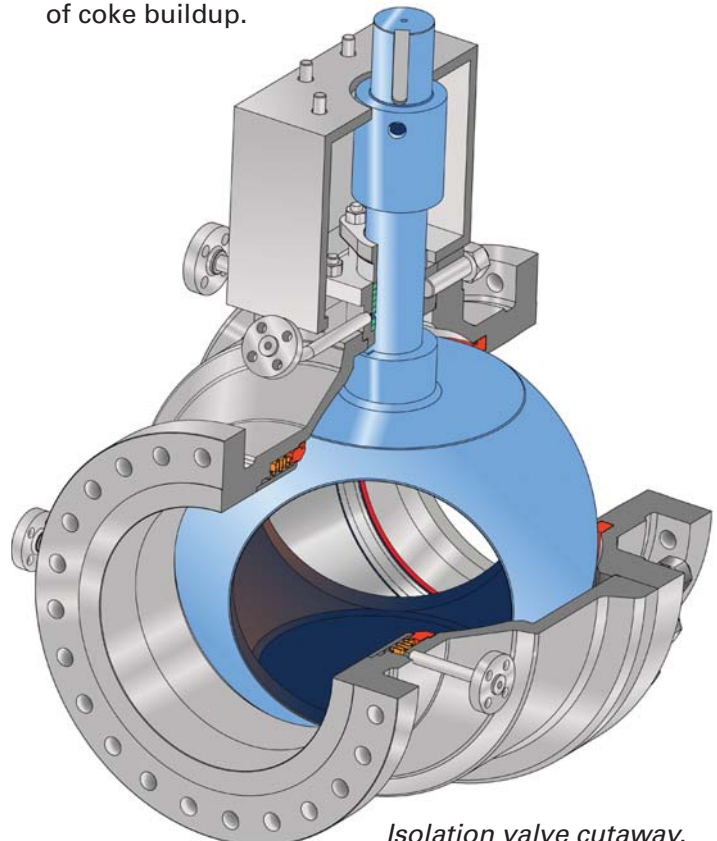
A Lantern Ring with steam block and extra deep stuffing box minimizes the risk of leakage occurring through the packing chamber. Live-loading is available upon request.

The Sturdy One-Piece Ball and Stem provides optimal strength and is well suited to applications where fouling due to coke fines are a concern. The one-piece design avoids the problems generally associated with the more conventional two-piece ball and stem, which is highly susceptible to solids buildup in the ball-stem joint and a resulting increase in operating torques.

Strong Bellows offer a unique seat loading design that maintains the floating seats in constant contact with the ball and ensures a positive seal.

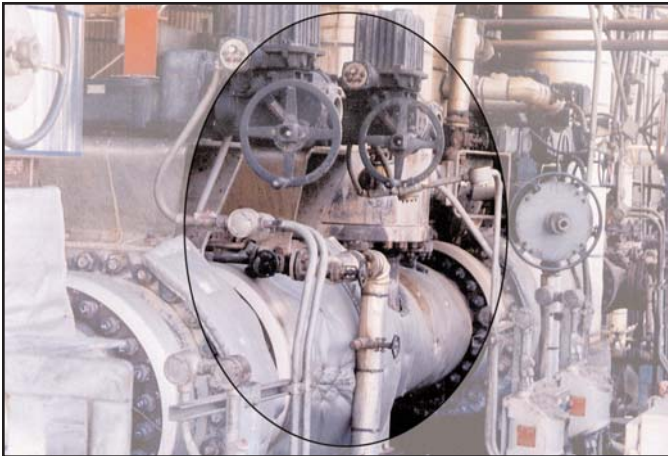
Scraper type seats "scrape" coke buildup from the surface of the ball during each cycle. Seats are hard-faced to ensure a long, trouble-free service life.

Steam Purges to bellows and body area ensure the valve cavities are kept free of coke buildup.



Isolation valve cutaway.

RING VALVES (FOR BACKPRESSURE CONTROL)



This patented Velan Ring Valve was installed to replace an existing butterfly valve. The end user required the use of this valve only when shorter cycle times required quicker drum "backwarming". The end user could not justify the high pressure drop across the butterfly valve with his efforts to increase liquid yield. They required a valve with good throttling characteristics, but which provided no obstruction in the full open position. The Ring Valve fully met these requirements.

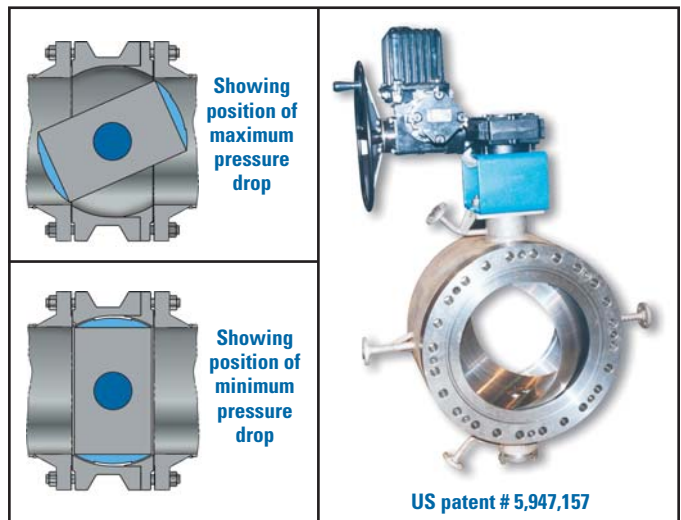
RING VALVE FEATURES:

NO OBSTRUCTION (HIGH CV) in the full open position.

EXCELLENT THROTTLING CHARACTERISTICS. In the "maximum obstruction" position, the valve provides a pressure drop equal to a butterfly valve's set at 15° open.

INTRINSICALLY SAFE DESIGN. The Ring Valve has no seats. It is a throttling valve. As a result, it does not require a mechanical stop in order to avoid full closure and the resulting drum overpressurization.

Steam purges to bearings and body area ensure the valve cavities are kept free of coke buildup.



LOGIC CONTROL PANEL

Velan supplies hard-wired or PLC driven panels to operate as stand-alone units or through a PLC/DCS for safe, sequential valve operation.

Velan supplies panels to operate the switch valve as well as all valves around the coke drum.



HIGH PRESSURE (HYDRODRILL) VALVE

Velan Securaseal Full Bore Ball Valves are generally installed in high pressure applications where the highly erosive and sometimes corrosive reclaimed waters (used to drill the coke out of the drum) can significantly shorten valve life.

In order to ensure long, leak-free, reliable operation all valve wetted parts are hard-faced.



FOCUS ON DELAYED COKER APPLICATIONS

Velan maintains a group that has handled delayed coker applications exclusively for over 20 years. The group's design and service staff maintain contact with end users regularly appraising valve performance in the field. Our approach has yielded several design improvements over the years based on evolving coker operating trends.

EXAMPLES:

Simple, Reliable Automation.

Fully automated, fully interlocked valve operation for a safer drum switch and unheading.

Total remote operation capability of switch and isolation valves including logic or hardware features to avoid unwanted operation.

Process Debottlenecking.

Full bore valves for higher throughput and a lower pressure drop in the overhead lines. This results in a lower drum pressure, which in turn translates into higher liquid yields and enhanced coker profitability.

In fact, the requirement for lower drum pressures resulted in a new, patented backpressure control valve design called the Ring Valve.

Shorter Cycles.

Valves are better suited to perform under the operating conditions imposed by shorter cycle times such as:

- ✓ Increased thermal stresses due to shorter quench times.
- ✓ Water hammer in part due to higher quench rates.

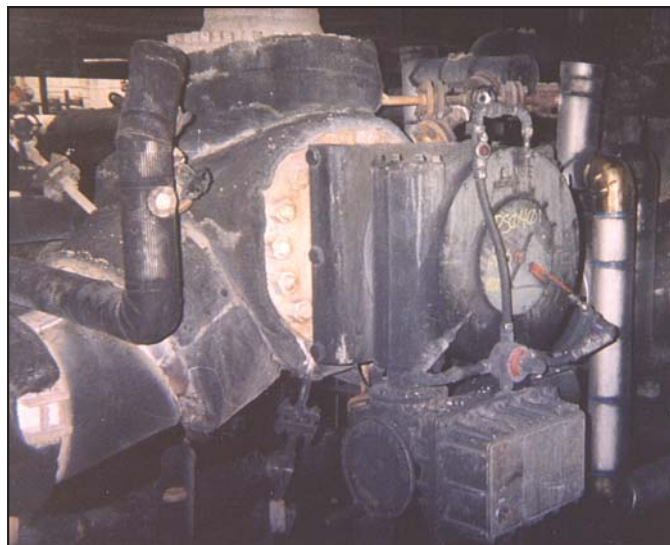
Special Applications.

Needle coke type applications where operating conditions provide new challenges.

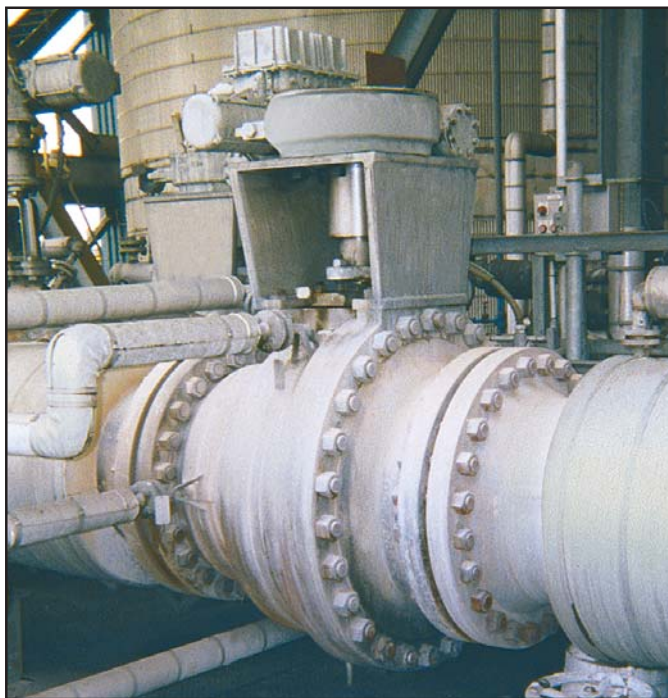
In-Line cleaning capability.

Valves can be decoked without removal from the line.

**Learn more about
Velan Coker Ball Valves,
or any of Velan's complete range
of industrial steel valves
at www.velan.com.**



The 12" Velan Switch Valve shown above has been in uninterrupted service for 7 years. This Valve was installed as part of a Valve automation Project.



These 24" full bore overhead vapor valves have been in uninterrupted service for over 6 years. In an effort to maximize liquid yield Delayed Cokers worldwide are opting for larger overhead lines. In fact some of the newer DCU's have already installed our 30" valves for overhead and blowdown service.