

Design Energy Efficient Water Utilization Systems Allowing Operation Split*

LIAO Zuwei (廖祖维)^{1,2}, WU Jintao (武锦涛)^{1,2}, JIANG Binbo (蒋斌波)^{1,2,**}, WANG Jingdai (王靖岱)^{1,2} and YANG Yongrong (阳永荣)^{1,2}

¹ State Key Laboratory of Chemical Engineering, Zhejiang University, Hangzhou 310027, China

² Department of Chemical and Biochemical Engineering, Zhejiang University, Hangzhou 310027, China

Abstract This article deals with the design of energy efficient water utilization systems allowing operation split. Practical features such as operating flexibility and capital cost have made the number of sub operations an important parameter of the problem. By treating the direct and indirect heat transfers separately, target freshwater and energy consumption as well as the operation split conditions are first obtained. Subsequently, a mixed integer non-linear programming (MINLP) model is established for the design of water network and the heat exchanger network (HEN). The proposed systematic approach is limited to a single contaminant. Example from literature is used to illustrate the applicability of the approach.

Keywords water utilization network, heat integration, wastewater minimization, operation split

1 INTRODUCTION

Energy and water are important resources to process industries. Since the modern society faces energy shortage and water scarcity problems, considerable attention has been paid to reduce energy and water consumption.

For water using operations such as absorption, extraction, and washing, it is required to operate at particular temperature levels. The water streams need to be heated up or cooled down to satisfy the temperature requirements of the operations. Under such circumstances, energy consumption should be considered in the design of water utilization systems.

During the past decade, considerable design techniques have been developed to minimize the energy and water consumption simultaneously. Conceptual design tools such as two dimensional grid diagram [1–3], separate system [1–3], source-demand energy composite curve [4], and graphical thermodynamic rule [5] have been introduced to design the water network and the corresponding heat exchanger network (HEN). Mathematical programming techniques have also been used for the problem. Bagajewicz et al. [6] proposed two sequential linear programming (LP) problems to determine the minimum water usage and energy consumption targets. Once these targets are identified, a mixed integer linear programming (MILP) model is generated to obtain the detailed network. Zheng [7] considered the multi-contaminant situation and obtained different water networks under different economic targets. Other researchers [8–11] treated the water network and the HEN sequentially. Since the water network obtained in the first step was not unique, the resulting HEN may not be optimal. Du et al. [12] introduced genetic algorithm and simulated annealing algorithm to solve the problem simultaneously. Leewongtanawit et al. [13, 14] developed a mixed integer non-linear

programming (MINLP) model that relies on the combining of water superstructure and HEN superstructure to provide an overall network design. Recently, Liao et al. [15] introduced a modified transshipment model that treats direct and indirect heat transfers separately.

Kuo and Smith [16] first addressed that for particular processes such as extracting and washing, the operations are allowed to split, as seen in Fig. 1. They applied these split options to further reduce the freshwater usage. Later, Xu et al. [17] developed a mathematical programming model, which allows operation split for the water network with regeneration reuse. When the energy aspect is taken into account, the split of operations may further reduce the energy consumption. Consider now a two operation example of Table 1 to see how the operating cost can be decreased by operation split. Given that the water and energy cost are specified at 1.5 RMB Yuan·t^{−1} and 38 Yuan·GJ^{−1}, the approach of Liao et al. [15] is applied to this problem. The resulting minimum utility cost is 1114.6 RMB Yuan·h^{−1}, with the corresponding network shown in Fig. 2. If operation 1 is allowed to split at the concentration of 83.67 μg·g^{−1}, then a network with 999.6 RMB Yuan·h^{−1} utility cost can be obtained as shown in Fig. 3. On the other hand, the split of operations may cause additional equipment cost. Therefore, the tradeoffs between capital cost increasing and operating cost reducing should be evaluated.

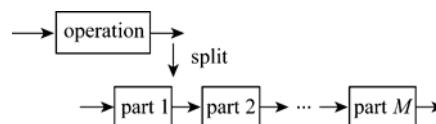


Figure 1 Split of original operation

The designer now faces the question of whether a better network may be possible using a different design strategy. What is really the correct utility target?

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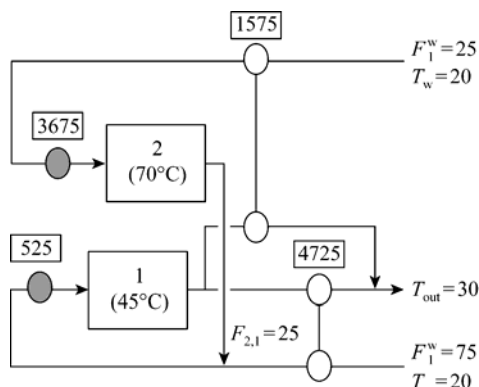
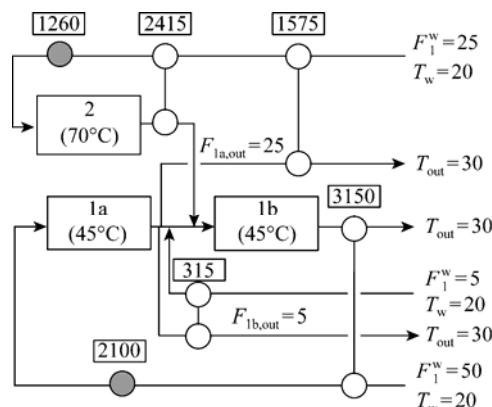
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** To whom correspondence should be addressed. E-mail: jiangbb@zju.edu.cn

Table 1 Data for Example 1

Process number	Mass load of contaminant /g·s ⁻¹	c_{in}^{max} /μg·g ⁻¹	c_{out}^{max} /μg·g ⁻¹	Temperature /°C
1	5	25	100	45
2	2.5	50	100	70

Note: Temperature of freshwater: $T_w=20^\circ\text{C}$; temperature of wastewater: $T_{1,out}=30^\circ\text{C}$, $T_{2,out}=70^\circ\text{C}$, $\Delta T_{min}=10^\circ\text{C}$.

**Figure 2 Solution for Example 1 not allowing operation split****Figure 3 Solution for Example 1 allowing operation split**

How many number of splits are required to achieve this? It should be noted that when operation split is allowed in the water network design, the design variables will increase rapidly. For example, if the maximum number of N is permitted to split in one operation, the total number of streams increases from N_M^2 to $(N_M N)^2$, where, N_M is the number of operations. In this article, an effective two step procedure is introduced to deal with such a problem. In the first step, a rigorous determination of the targets including utility consumption and the number of the operation splits is obtained. Once these targets are identified, the detailed network design is carried out in the second step by an MINLP formulation.

2 PROBLEM STATEMENT

Given are a set of water-using/water-disposing processes, which require water of a certain quality and temperature. It is desired to determine a network of

water-stream interconnections among the processes and to design a network of heat exchangers between these streams. The objective is the simultaneous minimization of the freshwater usage and the energy consumption of the whole system. Several assumptions are specified: ① all operations operate isothermally; ② the contaminant load is fixed and is independent of the flow rate; ③ the operations are allowed to split by concentration; ④ the water flow rate does not change through an operation; ⑤ single contaminant is permitted.

3 MODEL DEVELOPMENT

3.1 Targeting procedure for operation split

Let us consider the general case of N_M operations. Without loss of generality, assume operation q is allowed to split into several sub operations, the maximum number of which is given by N_q . Indeed, these sub operations divide the whole operation into several concentration intervals. Let q^m denote the m th sub operation of operation q . Also, let L_q be the mass load of q^m , $c_{q^m,in}^{max}$ and $c_{q^m,out}^{max}$ be the maximum inlet and outlet concentrations of q^m respectively. Assume that the mass load distribution is proportional to the concentration distribution:

$$\frac{L_{q^m}}{L_q} = \frac{c_{q^m,out}^{max} - c_{q^m,in}^{max}}{c_{q,out}^{max} - c_{q,in}^{max}} \quad (1)$$

Given that the first sub operation q^1 has the lowest concentration and the potential sub operations are arranged in the concentration increasing order:

$$c_{q^{m-1},out}^{max} = c_{q^m,in}^{max} \quad q \in P, \quad m \in E_q \quad (2)$$

Consider the following general binary variables:

$$Y_{q^m} = \begin{cases} 1, & \text{sub operation } q^m \text{ exist} \\ 0, & \text{otherwise} \end{cases} \quad (3)$$

These binary variables are related to the variables L_{q^m} through the inequalities:

$$L_{q^m} - L_q Y_{q^m} \leq 0 \quad q \in P, \quad m \in E_q \quad (4)$$

Note that when Y_{q^m} takes a zero value, q^m does not exist, but when it is set to one, any amount of L_{q^m} that does not exceed L_q can exist.

To account for the capital cost of sub operations, all cost causing factors such as the flow rate, the concentration gradient, and the number of sub operations should be considered. However, this will likely strongly increase the computational effort required. Therefore, the capital costs of the sub operations are assumed to be fixed as e_3 in this article.

An MINLP problem based on the preceding binary variables to solve the operation split case is then proposed:

$$P_1 = \min e_1 \sum_{q \in P} \sum_{n \in E_q} F_{p,q^n} + e_2 \sum_{\forall (i^u, j^v) \in C} Q_{i^u j^v}^h + e_3 \sum_{q \in P} \sum_{n \in E} Y_{q^n} \quad (p = w) \quad (5)$$

s.t.

Eq. (1)–Eq. (4)

$$\sum_{p \in \tilde{P}} \sum_{n \in E_p} F_{q^m, p^n} = \sum_{p \in \tilde{P}} \sum_{n \in E_p} F_{p^n, q^m} \quad q \in P, \quad m \in E_q \quad (6)$$

$$\sum_{p \in \tilde{P}, p \neq q} \sum_{n \in E_p} F_{p^n, q^m} (c_{p^n, \text{out}} - c_{q^m, \text{out}}) + L_{q^m} = 0 \quad q \in P, \quad m \in E_q \quad (7)$$

$$\sum_{p \in \tilde{P}, p \neq q} \sum_{n \in E_p} F_{p^n, q^m} (c_{p^n, \text{out}} - c_{q^m, \text{in}}^{\max}) \leq 0 \quad q \in P, \quad m \in E_q \quad (8)$$

$$c_{q^m, \text{out}} \leq c_{q^m, \text{out}}^{\max} \quad q \in P, \quad m \in E_q \quad (9)$$

$$c_{q, \text{out}}^{\max} = c_{q, \text{out}}^{\max}, \quad c_{q, \text{in}}^{\max} = c_{q, \text{in}}^{\max} \quad q \in P \quad (10)$$

$$0 \leq c_{q^m, \text{out}}^{\max} - c_{q^m, \text{in}}^{\max} \leq c_{q, \text{out}}^{\max} - c_{q, \text{in}}^{\max} \quad q \in P, \quad m \in E_q \quad (11)$$

$$\delta_{p^m q^n, k+1} + \sum_{(i^u, j^v) \in C_k} Q_{p^m q^n, i^u j^v, k} = \delta_{p^m q^n, k} + F_{p^m q^n} \Delta t_{p, k} c_p \quad \forall (p^m, q^n) \in H, \quad k = k_p, \dots, K-1 \quad (12)$$

$$\delta_{i^m j^n, k} + \sum_{(p^u, q^v) \in H_k} Q_{p^u q^v, i^m j^n, k} = \delta_{i^m j^n, k+1} + F_{i^m j^n} \Delta t_{ij, k} c_p \quad \forall (i^m, j^n) \in C, \quad k = 1, \dots, k_i - 1 \quad (13)$$

$$\sum_{p^m} (\delta_{p^m q^n, K} - Q_{p^m q^n}^c) = \sum_{i^u} (\delta_{i^u j^v, 1} - Q_{i^u j^v}^h) \quad q = j, \quad \forall (p^m, q^n) \in H, \quad (i^u, j^v) \in C \quad (14)$$

$$\delta_{p^m q^n, k_p} = \delta_{i^u j^v, k_i} = 0 \quad \forall (p^m, q^n) \in H, \quad (i^u, j^v) \in C \quad (15)$$

$$Q_{i^u j^v}^h, \quad Q_{p^m q^n}^c, \quad \delta_{p^m q^n, k}, \quad \delta_{i^u j^v, k} \geq 0, \quad F_{p^m q^n} \geq 0$$

$$\forall q \in \hat{P}, \quad p \in \tilde{P}, \quad m \in E_q, \quad n \in E_p, \quad (p^m, q^n) \in H, \quad (i^u, j^v) \in C, \quad k = 1, 2, \dots, K \quad (16)$$

where, e_1 , e_2 are cost coefficients for freshwater and heating utility, respectively. The set of Eq. (6) corresponds to the total mass balance of each sub operation. The set of constraints (7) represents the contaminant balance around the sub operations, while the set of constraints (8) and (9) show the maximum inlet and outlet concentration constraints of these sub operations. Constraints set (10) accounts for the upper and lower concentration bounds of the sub operations, while constraints set (11) shows the concentration range of the sub operations. The next constraints set (12)–(15) considers the transshipment model repre-

sentation of the HEN. Finally, the non-negativity constraints are shown in constraints set (16).

3.2 Design of water network and heat exchanger network

Once the targets are obtained, a water network and an HEN can be constructed. By considering the number of heat exchange matches, the problem can be written as follows:

$$P_2 = \min \sum_{(p^m, q^n) \in H} \left[y_{p^m q^n}^c + \sum_{(i^u, j^v) \in C} (y_{p^m q^n, i^u j^v} + y_{i^u j^v}^h) \right] \quad (17)$$

s.t.

Constraints (6)–(9), (12)–(16)

$$e_1 \sum_{q \in P} \sum_{n \in E_q} F_{p, q^n} + e_2 \sum_{\forall (i^u, j^v) \in C} Q_{ij}^h = \alpha \quad (p = w) \quad (18)$$

$$\sum_{k=1}^K Q_{p^m q^n, i^u j^v, k} - U_{p^m q^n, i^u j^v} y_{p^m q^n, i^u j^v} \leq 0 \quad \forall (p^m, q^n) \in H, \quad (i^u, j^v) \in C \quad (19)$$

$$Q_{i^u j^v}^h - U_{i^u j^v}^h y_{i^u j^v}^h \leq 0 \quad \forall (i^u, j^v) \in C \quad (20)$$

$$Q_{p^m q^n}^c - U_{p^m q^n}^c y_{p^m q^n}^c \leq 0 \quad \forall (p^m, q^n) \in H \quad (21)$$

$$y \in \{0, 1\} \quad (22)$$

where, α is the target utility consumption determined by P_1 , and U is the upper bound on the heat transfer. The set of constraints (18) corresponds to the utility consumption constraint. The next series of constraints sets (19) to (22) relate the continuous variables to the binary variables. These constraints are used to count the number of interconnections.

3.3 Model solution

P_1 and P_2 are solved sequentially; the targets including freshwater flow rate, energy consumption, and number of splits obtained by P_1 are set as parameters in P_2 . Both P_1 and P_2 are coded in GAMS [18] and are solved on a PC machine (2.4 GHz, 512 MB RAM). The MINLP problems are solved using the algorithm of Viswanathan and Grossmann [19], which is available in GAMS as the solver DICOPT. According to this algorithm, the MINLP problems are decomposed into a series of NLP and MILP sub problems. In this article, the sequential quadratic programming (SQP) algorithm of SNOPT [20] solver is used for the NLP problem and the combined algorithm of CPLEX solver [18] is used for the MILP problem. Note that the solution does not provide the global optimum since the MINLP problem is non-convex.

4 CASE STUDY

A modified version of the example from Savulescu and Smith [3] is presented. The data of the case study

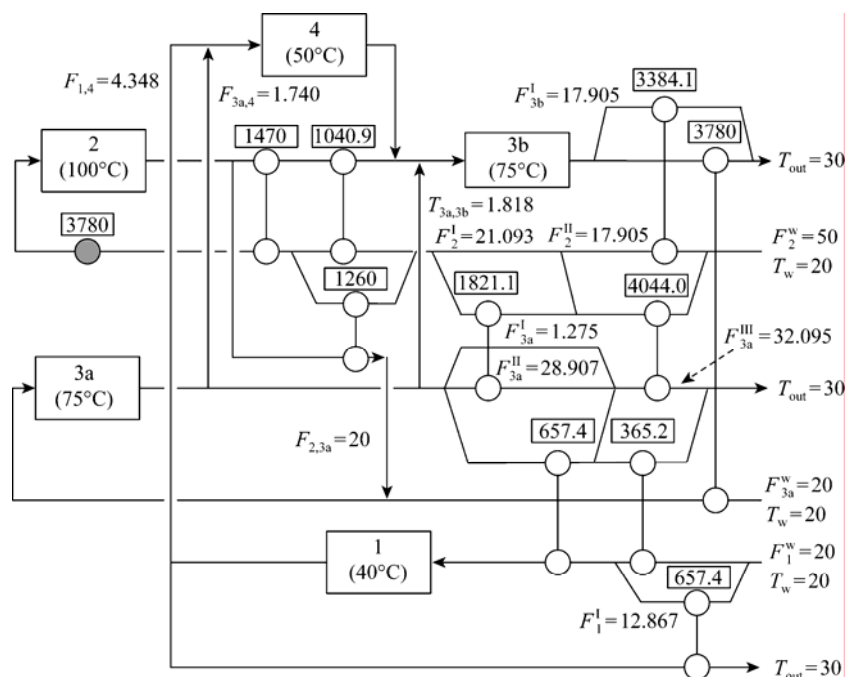


Figure 4 Optimal water network and HEN for case study

is shown in Table 2. The modification is that the discharge temperature of operation 4 is changed from 30°C to 50°C, namely, the energy of wastewater from operation 4 cannot be used. Under such condition, the total freshwater and energy consumption will be increased if operation split is not allowed. Assume e_3 is 10^5 RMB Yuan·year⁻¹, and e_1 and e_2 are the same as in Example 1. The approach of Liao *et al.* [15] is applied to this case. The resulting target is 8.55×10^6 RMB Yuan·year⁻¹ with the consumption of 90 t·h⁻¹ freshwater and 4260 kW energy, respectively. As compared with the original case, the energy consumption is increased by 10.6%. Now, consider the case that operation split is allowed. Assume all N_q are specified at 3; P_1 is applied to this case. The targeting freshwater and energy consumptions are 90 t·h⁻¹ and 3850 kW, respectively. The increase in energy consumption is avoided, and the total cost 8.2×10^6 RMB Yuan·year⁻¹ is also lower than the no split case. The targeting condition is that only operation 3 will split into two parts at the concentration of 600 $\mu\text{g} \cdot \text{g}^{-1}$. Next, the resulting targets are used for the detailed network design. P_2 is applied to this case. Fig. 4 shows the resulting design of the water network with energy aspect.

Table 2 Data for Example 2

Operation number	Mass load of contaminant/g·s ⁻¹	$c_{\text{in}}^{\text{max}}$ / $\mu\text{g} \cdot \text{g}^{-1}$	$c_{\text{out}}^{\text{max}}$ / $\mu\text{g} \cdot \text{g}^{-1}$	Temperature /°C
1	2	0	100	40
2	5	50	100	100
3	30	50	800	75
4	4	400	800	50

Note: Temperature of freshwater: $T_w = 20^\circ\text{C}$; temperature of wastewater from operation 1, 2, 3: $T_{\text{out}} = 30^\circ\text{C}$; temperature of wastewater from operation 4: $T_{\text{out}} = 50^\circ\text{C}$.

5 CONCLUSIONS

In the design of energy efficient water utilization systems, the split of water using operations should be considered to reduce the total utility cost. The synthesis of networks allowing split is now carried out in two stages. The utility and split targets are first obtained. Then, the detailed network design is carried out based on the MINLP model. Although this strategy may lead to local optimum solution, the design procedure of the example shows fairly low complexity, which is favorable in the industry.

NOMENCLATURE

C	set of cold streams, $C = \{(i, j) i \in \tilde{P}, j \in \tilde{P}, t_i < t_j\}$
C_k	set of cold streams at interval $(k, k+1)$, $C_k = \{(i, j) (i, j) \in C, k_i \geq k\}$
c	contaminant concentration, $\mu\text{g} \cdot \text{g}^{-1}$
c_p	stream heat capacity, $\text{J} \cdot \text{kg}^{-1} \cdot ^\circ\text{C}^{-1}$
D_k	set of sink points at temperature level k , $D_k = \{p p \in \tilde{P}, k_p = k\}$
E	set of sub operations
F	water flow rate, $\text{kg} \cdot \text{s}^{-1}$
H	set of hot streams, $H = \{(p, q) p \in \tilde{P}, q \in \tilde{P}, k_p < k_q\}$
H_k	set of hot streams at interval $(k, k+1)$, $H_k = \{(p, q) (p, q) \in H, k_p \leq k\}$
K	number of temperature levels
L	mass load of operation, $\text{g} \cdot \text{s}^{-1}$
P	set of operation
$\tilde{P}$	set of water source point, $\tilde{P} = \{P, w\}$
$\tilde{\tilde{P}}$	set of water sink point, $\tilde{\tilde{P}} = \{P, ww_q\}$
Q	heat load, kW
S_k	set of source points in temperature level k , $S_k = \{q q \in \tilde{P}, k_q = k\}$
t	water temperature, $^\circ\text{C}$
$\Delta t_{pq,k}$	temperature difference of stream (p, q) in temperature interval $(k, k+1)$, $^\circ\text{C}$
U	upper bound on the heat transfer, kW
w	freshwater source
ww	wastewater discharge place

- $\delta_{pq,k}$ cascade heat of hot stream (p, q) between interval ($k-1, k$) and interval ($k, k+1$), kW
- $\delta_{ij,k}$ cascade heat of cold stream (i, j) between interval ($k+1, k$) and interval ($k, k-1$), kW

Superscripts

- c cold utility
- h hot utility
- m, n, u, v sub operation
- max maximum
- I, II, III branch of a stream

Subscripts

- i, j, p, q kink point of the water network
- in inlet
- k temperature level
- out outlet

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