

CONTENTS

ABSTRACT	i
ACKNOWLEDGEMENTS	iii
LIST OF SYMBOLS	xii
1 INTRODUCTION	1
1.1 Project Definition and Goals	1
1.2 Overview of Dissertation	2
2 THEORY & LITERATURE REVIEW	4
2.1 Plate Heat Exchangers	4
2.1.1 Construction and Operation	4
2.1.2 Advantages and Disadvantages	7
2.1.3 Heat Transfer	9
2.1.3.1 Overall Heat Transfer Coefficient	10
2.1.3.2 Log Mean Temperature Difference	10
2.1.3.3 Hydraulic Diameter	11
2.1.3.4 Film Heat Transfer Coefficient	12
2.1.4 Pressure Drop	14
2.1.5 Plate Design	16
2.1.5.1 Corrugation Angle	19
2.1.5.2 Corrugation Wavelength	21
2.1.5.3 Corrugation Amplitude	23
2.1.5.4 Channel Gap	23
2.1.5.5 Port Location	25
2.1.5.6 Distributor Section	28
2.1.6 Two Phase Flow	28
2.2 Fouling	29

2.2.1	Definition of Fouling Resistance	30
2.2.2	Effect of Fouling on Heat Transfer and Pressure Drop	32
2.2.2.1	Heat Transfer	32
2.2.2.2	Pressure Drop	34
2.2.3	Fouling Mechanisms	37
2.2.4	Stages in Fouling	39
2.2.4.1	Initiation	40
2.2.4.2	Mass Transport	40
2.2.4.3	Deposition	41
2.2.4.4	Removal and Autoretardation	42
2.2.4.5	Ageing	43
2.2.5	Fouling Curves	43
2.2.6	Parameters Influencing Fouling in Plate Heat Exchangers	45
2.2.6.1	Operating Parameters	45
2.2.6.1.1	Flow Velocity	45
2.2.6.1.2	Temperature	46
2.2.6.2	Fluid Properties	46
2.2.6.3	Plate Parameters	47
2.2.6.3.1	Surface Material	47
2.2.6.3.2	Surface Roughness	47
2.2.6.3.3	Plate Design	48
2.2.7	Fouling Mitigation	50
2.2.7.1	Removal Before Entry	50
2.2.7.2	Increasing Solubility	50
2.2.7.3	Weaken and Remove	51
3	EXPERIMENTAL APPARATUS & PROCEDURE	53
3.1	Experimental Apparatus	53
3.1.1	Flow Loop of Experimental Set-up	53
3.1.1.1	Calcium Sulphate Solution	55
3.1.1.2	Hot Water	55
3.1.1.3	Compressed Air	56
3.1.2	Plate Heat Exchanger	56
3.1.3	Data Acquisition	60

3.1.4 Error Analysis	60
3.1.5 Modifications of Experimental Set-up	60
3.2 Calcium Sulphate	62
3.2.1 Solution Preparation	63
3.2.2 Concentration Determination	64
3.2.2 On-Line Concentration Measurement	65
3.3 Experimental Procedure	67
3.3.1 Start-Up Procedure	67
3.3.2 The Experimental Run	68
3.3.3 Shut-Down Procedure	68
4 EXPERIMENTAL RESULTS & DISCUSSION	70
4.1 Alfa Laval P01 and M3 Plate Heat Exchangers	70
4.1.1 Heat Transfer	70
4.1.2 Pressure Drop	73
4.1.3 Summary of Experimental Parameters	76
4.2 Fouling Data and Deposit Pattern in Alfa Laval PHEs	80
4.2.1 Current Experiments	80
4.2.2 Preliminary Experiments	84
4.2.3 Future Experiments	85
4.3 Effect of Solution Flow Velocity on Fouling in Alfa Laval PHEs	86
4.4 Effect of Solution Concentration on Fouling in Alfa Laval PHEs	90
4.4.1 Initial Solution Concentration	90
4.4.2 Topping Up of Solution Concentration	93
4.4.3 Time and Amount of Top-Up	94
4.5 Effect of Solution Inlet Temperature on Fouling in Alfa Laval PHEs	96
4.6 Effect of Port Position on Fouling in Alfa Laval PHEs	98

4.7 Flow and Fouling Patterns in Alfa Laval Plate Channels	101
4.7.1 Diagonal Flow	101
4.7.2 Side Flow	105
4.7.3 Effect of Port Position in Polycarbonate Plate Experiments	108
4.8 Fouling Mitigation in Alfa Laval PHEs	110
4.8.1 Effect of Added Salt on Fouling	110
4.8.2 Effect of Velocity Surge on Deposit Removal	112
4.8.3 Effect of Continuous Air Injection on Deposit Removal	116
4.8.4 Effect of Air Flush on Deposit Removal	120
4.8.5 Ion-Sputtered Plates	121
4.8.6 Effect of Velocity Surge Ion-Sputtered Plates	124
4.8.7 Effect of Magnetic Treatment on Fouling	127
4.9 Flat Plate Heat Exchangers	130
4.9.1 Heat Transfer	130
4.9.2 Pressure Drop	134
4.10 Fouling in Flat Plate Heat Exchangers	136
4.11 Effect of Plate Condition on Fouling in Flat PHEs	139
4.12 Effect of Solution Concentration on Fouling in Flat PHEs	141
4.13 Flow and Fouling Patterns in Flat PHEs	143
4.13.1 Flow Patterns	143
4.13.2 Fouling Patterns	145
4.13.3 Effect of Channel Gap on Fouling Patterns	148
4.14 Effect of Distributor Designs on Fouling on Flat PHEs	151
4.14.1 Distributor Design A	151
4.14.2 Distributor Design B	154
4.14.3 Distributor Design C	156

4.14.4 Distributor Design D	158
4.14.5 Distributor Design E	160
4.14.6 Comparisons of All Distributor Designs	162
4.15 Repeatability of Data	165
5 FOULING & EXCESS HEAT TRANSFER AREA	167
5.1 The Standard Plate Heat Exchanger	168
5.2 An Approximate Fouling Model	170
5.3 Excess Heat Transfer Area Evaluation	173
5.4 Excess Heat Transfer Area Incorporation	174
5.4.1 Additional Parallel Plates	176
5.4.2 Larger Plates of Different Aspect Ratios	177
5.4.3 Additional Plates in a Second Pass	178
5.4.4 Fouling Trends	180
6 FLOW SIMULATION	187
6.1 Mathematical Formulation	190
6.1.1 Laminar Equations	190
6.1.2 Turbulent Equations	192
6.1.2.1 Turbulent Characteristics	192
6.1.2.2 The k - ε Turbulence Model	193
6.1.2.3 Reynolds Stress Model	195
6.1.3 Wall Boundary Conditions for Turbulent Flow	196
6.1.3.1 Wall Function Method	197
6.1.3.2 Near-Wall Approach	198
6.1.4 Wall Boundary Conditions for Turbulent Heat Transfer	199
6.2 Computational Implementation with CFX	200
6.3 The Simulations	201
6.3.1 Flow Passing Through a 2-D Channel with a Single Corrugation on the Bottom Surface	203

6.3.2 Flow Passing Through a 2-D Channel with Multiple Corrugations on the Top and Bottom Surfaces	206
6.3.2.1 Effect of Corrugation Wavelength on Heat Transfer and Pressure Drop	208
6.3.2.2 Effect of Plate Channel Gap on Heat transfer and Pressure Drop	211
6.3.3 Flow Passing Over a 2-D Backward-Facing Step	214
6.3.3.1 The k - ε Model	215
6.3.3.2 Differential Reynolds Stress Model	216
6.3.4 Inlet Conditions for Flow in Flat Plate Channels	218
6.3.5 Double Backward-Facing Step	219
6.3.6 Simplified 3-D Geometry of a Flat Plate Heat Exchanger	221
6.3.6.1 Isothermal Laminar Flow	222
6.3.6.2 Laminar Flow with Heat Transfer	223
6.3.6.3 Isothermal Turbulent Flow	226
6.3.7 True Geometry of a Flat Plate Heat Exchanger	227
6.3.7.1 The Grid	227
6.3.7.2 Isothermal Flow	229
6.3.7.2.1 Turbulent Flow and the k - ε Model	229
6.3.7.2.2 Turbulent Flow and Different Reynolds Stress Model	231
6.3.7.2.3 Laminar Flow	234
6.3.7.2.4 Comparison of CFD Flow Model Predictions Experimental Results	235
6.3.7.3 Turbulent Flow with Heat Transfer	238
6.3.7.3.1 Heat Transfer Area #1	238
6.3.7.3.2 Heat Transfer Area #2	239
6.3.7.3.3 Comparisons with Experiments	240

6.3.8 Distributor Designs in Plate Heat Exchangers	241
7. CONCLUSIONS & RECOMMENDATIONS FOR FUTURE WORK	253
7.1 Conclusions	253
7.2 Recommendations for Future Work	260
APPENDIX A: FURTHER EXPERIMENTAL PROCEDURES	263
A.1 Preparation of Titration Solutions	263
A.2 Start-Up and Shut-Down Procedures	264
APPENDIX B: CFX COMMAND FILES	267
B.1 Flow Passing Through a 2-D Channel with a Single Corrugation on the Bottom Surface	267
B.2 Flow Passing Through a 2-D Channel with Multiple Corrugations on the Top and Bottom Surfaces	268
B.3 Flow Passing Over a 2-D Backward-Facing Step	269
B.4 Inlet Conditions for Flow in Flat Plate Channels	271
B.5 Double Backward-Facing Step	272
B.6 Simplified 3-D Geometry of a Flat Plate Heat Exchanger	273
B.7 True Geometry of a Flat Plate Heat Exchanger	275
B.8 Distributor Designs in Plate Heat Exchangers	277
BIBLIOGRAPHY	282