**DESIGN OF FOUNDATION OF STEEL STRUCTURE FOR FRACTIONATION PLANT**

**Saurabh Dewarde1 , Shubham Kanade2 , Ankit Karde3 , Rohan Mane4**

*1* *Mr. Manjunath M*

*St. John College of Engineering and Management, Maharashtra, India*

***Abstract –*** *In Oil & Gas, Refinery & Power Plants different types of Equipments plays a major role for process requirements. Majority of Equipments are categorized into Horizontal Vessels, Vertical vessels, Exchangers, Storage tanks. These are further divided into Static Equipments and Dynamic Equipments based on rotations and vibration. Equipment Foundations design is major challenge for Structural Engineers to withstand process loads and Environmental loads for different load combination in terms of safety and economy. Most of the Vertical Equipments Foundation are Octagonal in shape for Constructability point of view and economy point of view. In the present project Equipment Foundation has been analyzed by using Staad Software and designed by using International codes as per American code of institute.*

***Keyword****s - Horizontal Vessels, Vertical vessels, Foundation.*

**1.INTRODUCTION**

**1.1 GENERAL**: Foundations are substructures that are constructed below the ground level which support the superstructures above the ground level. The main function of the footing or foundation is to

* Transmit the load safely and effectively coming on to it to the underlying soil without exceeding the “Safe bearing capacity of the soil”.
* Ensuring that the settlements of the structure are within the permissible limits.
* In addition to that, the foundation should provide adequate safety against possible instability due to overturning, sliding and uplift.
* The design is carefully done so that foundation has to provide adequate steel to resist tensile forces and at the same time it should be verified that more steel than required should not be placed as it gives brittle failure.

**1.2 TYPES OF EQUIPMENT FOUNDATIONS:**

* Vertical Vessel Foundation
* Horizontal Vessel Foundation

**1.2.1 VERTICAL VESSEL FOUNDATION:**

Vertical vessels are process equipment placed vertically on either foundation at grade either in a concrete or steel structure. Vertical vessels are cylindrical in shape with each end capped by a domed cover called a head. The length to diameter ratio of a vertical vessel is typically 3:1. Vertical vessels are usually supported by legs, lugs and skirts. They can be Short and stubby or tall and slim.

**1.2.2 HORIZONTAL VESSEL FOUNDATION:**

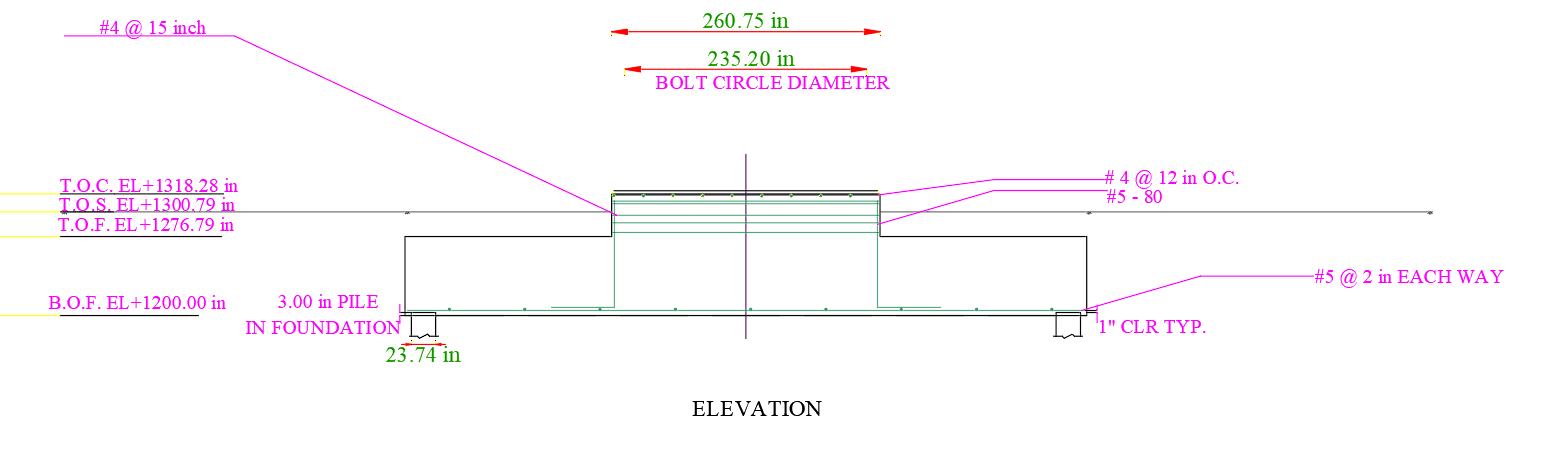
Horizontal vessels are relatively large diameter cylindrical pressure vessel used for variety of pressure functions. The height above grade is usually determined by NPSH requirements of pumps in the liquid outlet line or gravity flow requirement to other equipment. Foudation type is similar to both of them. Horizontal vessels are usually supported on fixed end saddle and sliding end saddle.

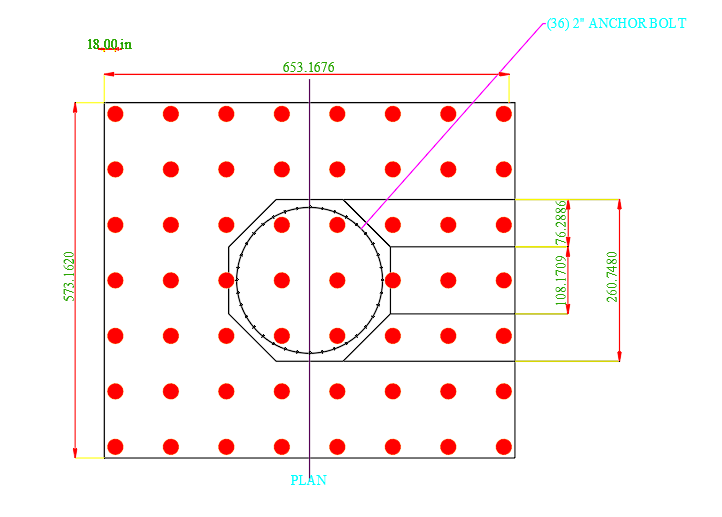
**2.METHOLOGY**

**2.1 VERTICAL VESSEL:**

**2.1.1 VESSEL 1:**

|  |  |  |
| --- | --- | --- |
| Table 1 | Operating | Empty |
| Live load | 1 kN/m2 | 1 kN/m2 |
| Dead load | 10488.834 kN | 6307.464 kN |
| Shear | 324.739 kN | 119.884 kN |
| Moment | 10827.890 kNm | 6511.38 kNm |



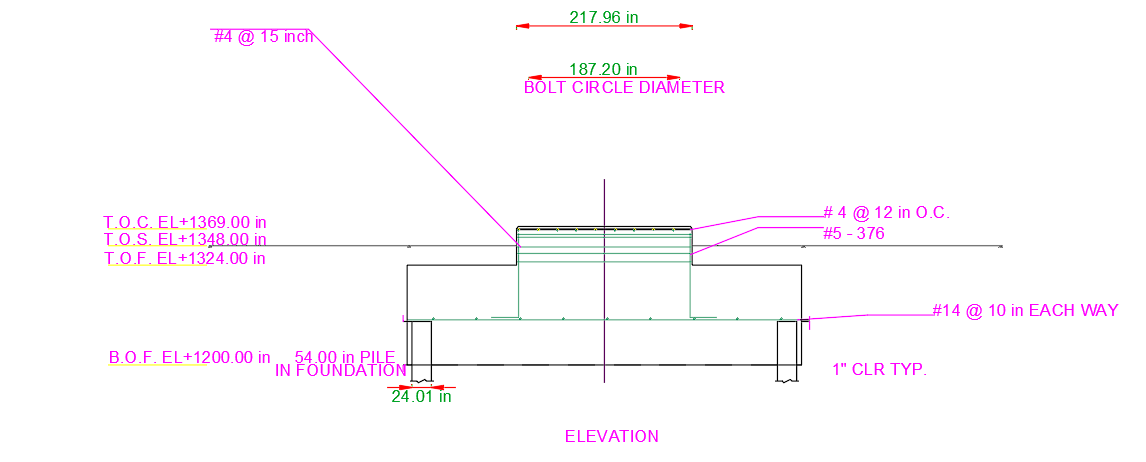
Fig. 1, 2 - fig shows the STAAD Foundation output

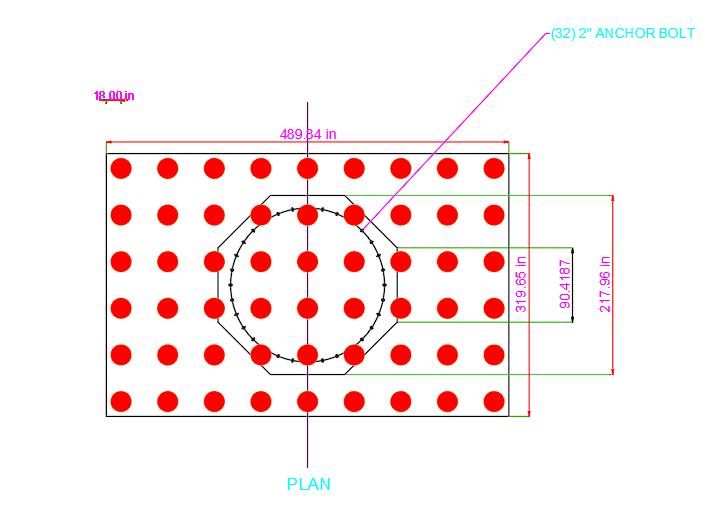
|  |  |
| --- | --- |
| Table 2: Anchor Bolt | |
| Grade | F1554  Grade 36 |
| Tensile strength | 399895.5 kN/m2 |
| Yield strength | 248211 kN/m2 |
| Diameter | 0.069 m |

|  |  |
| --- | --- |
| Table 3: Pedestal: | |
| Geometry | Octagonal |
| Length of each side | 2.747 m |
| Height of pedestal | 1.053 m |
| Area | 36.188 m2 |

**2.1.2 VESSEL 2:**

|  |  |  |
| --- | --- | --- |
| Table 4 | Operating | Empty |
| Live load | 1 kN/m2 | 1 kN/m2 |
| Dead load | 10562.98 kN | 5744.472 kN |
| Shear | 328.129 kN | 40.085 kN |
| Moment | 15612.58 kNm | 8483.188 kNm |



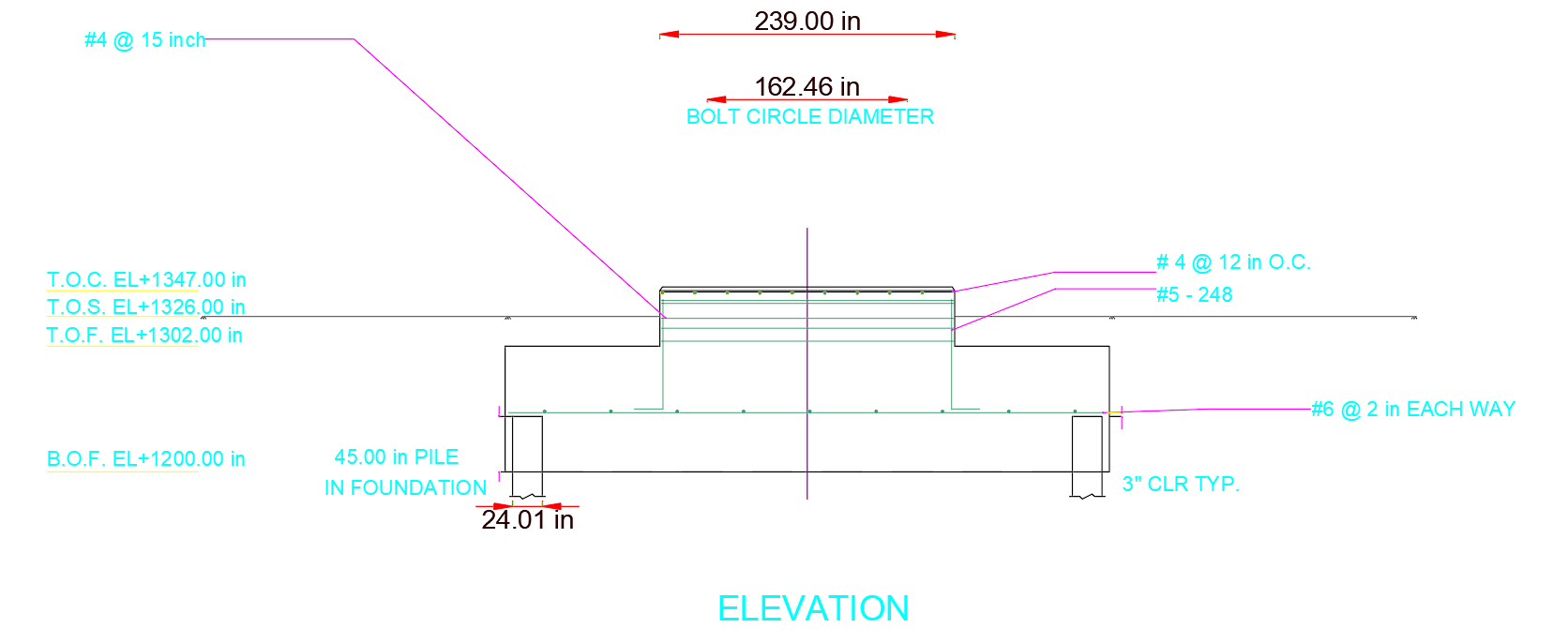
Fig. 3, 4: fig shows the STAAD Foundation output

|  |  |
| --- | --- |
| Table5: Anchor Bolt | |
| Grade | F1554  Grade 36 |
| Tensile strength | 399895.5 kN/m2 |
| Yield strength | 248211 kN/m2 |
| Diameter | 0.074 m |

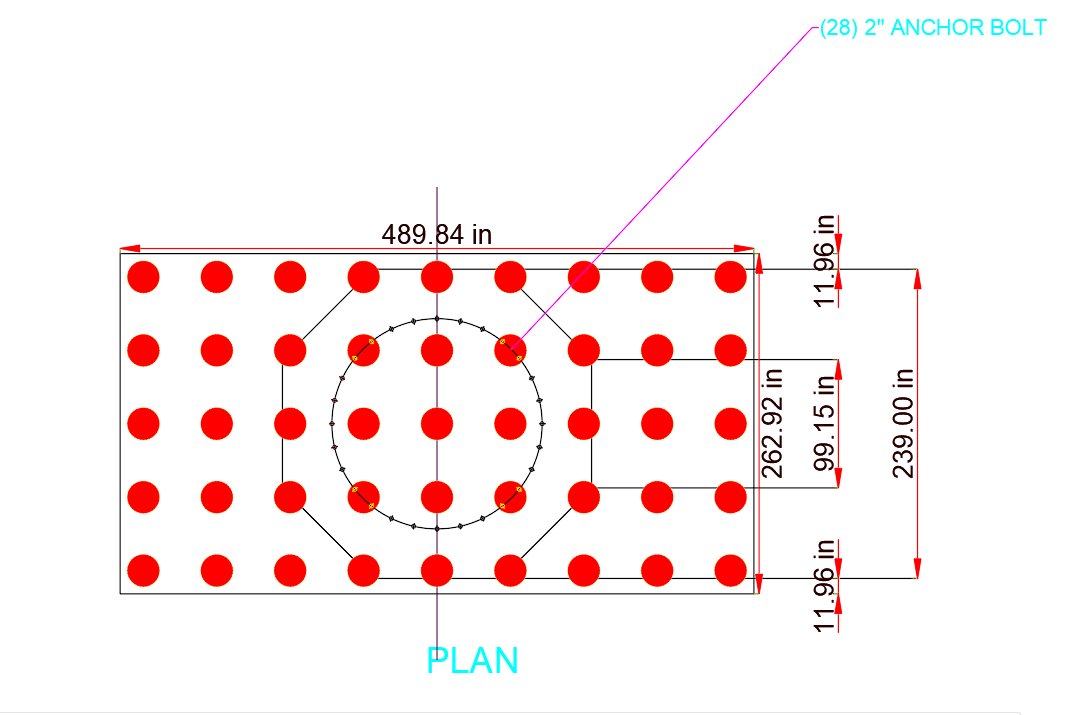
|  |  |
| --- | --- |
| Table 6: Pedestal | |
| Geometry | Octagonal |
| Length of each side | 2.514 m |
| Height of pedestal | 1.143 m |
| Area | 30.53 m2 |

**2.1.3 VESSEL 3:**

|  |  |  |
| --- | --- | --- |
| Table 7 | Operating | Empty |
| Live load | 1 kN/m2 | 1 kN/m2 |
| Dead load | 6848.7 kN | 2759.016 kN |
| Shear | 212.694 kN | 85.681 kN |
| Moment | 11787.795 kNm | 4748.594 kNm |



|  |  |  |
| --- | --- | --- |
| Table 11 | Operating | Empty |
| Shear | 24.241 kN | 15.247 kN |
| Vertical load | 9.924 kN.m | 6.242 kN.m |

Fig. 5, 6: fig shows the STAAD Foundation output

|  |  |
| --- | --- |
| Table 8: Anchor Bolt | |
| Grade | F1554  Grade 36 |
| Tensile strength | 399895.5 kN/m2 |
| Yield strength | 248211 kN/m2 |
| Diameter | 0.069 m |

|  |  |
| --- | --- |
| Table 9: Pedestal | |
| Geometry | Octagonal |
| Length of each side | 2.514 m |
| Height of pedestal | 1.143 m |
| Area | 30.53 m2 |

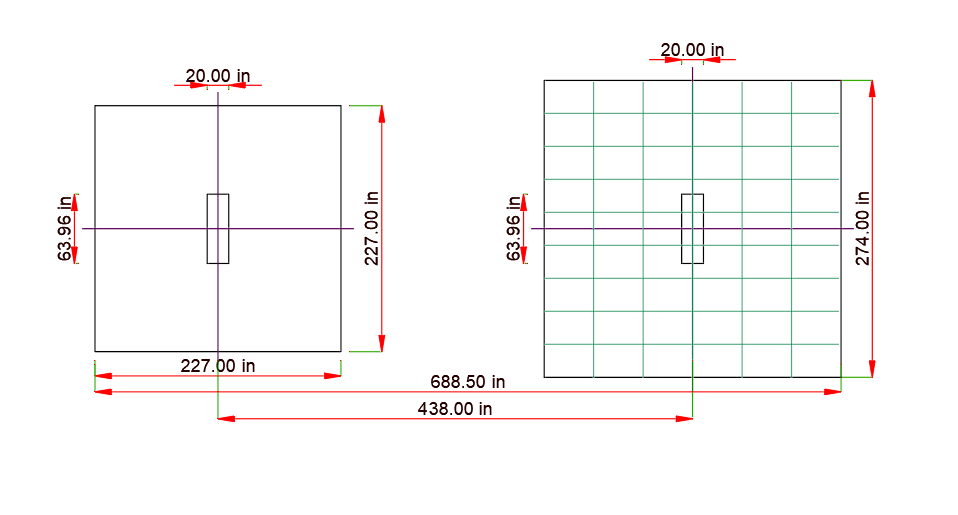
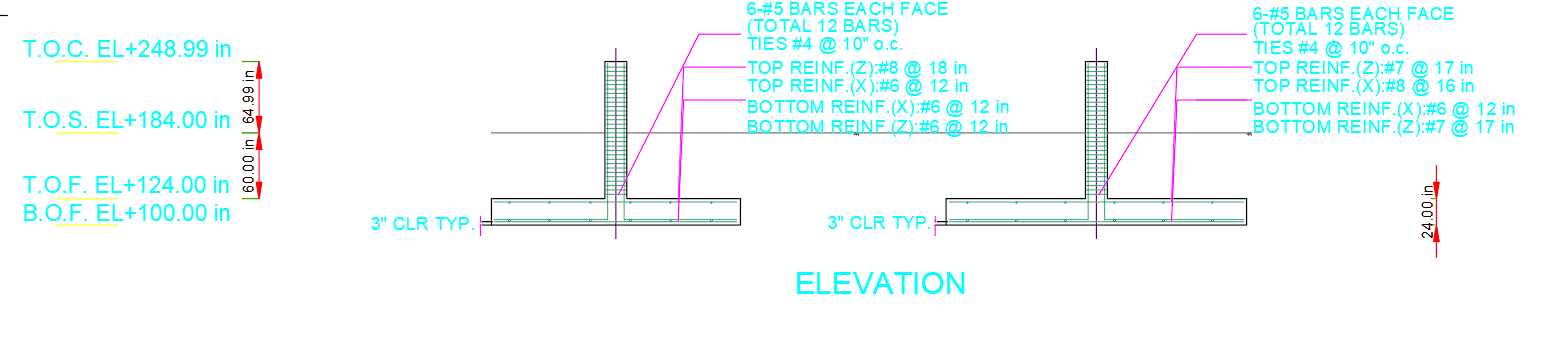
**2.2 HORIZONTAL VESSEL:**

**2.2.1 VESSEL 1:**

**Seismic in transverse direction (for sliding):**

**Seismic in longitudinal direction (for sliding):**

|  |  |  |
| --- | --- | --- |
| Table 10 | Operating | Empty |
| Shear | 32.6 kN | 20.514 kN |
| Moment | 146.453 kN.m | 90.201 kN.m |

fig shows the STAAD Foundation output

**Seismic in transverse direction (for fixed):**

|  |  |  |
| --- | --- | --- |
| Table 12 | Operating | Empty |
| Shear | 48.127 kN | 30.304 kN |
| Moment | 216.399 kN.m | 136.141 kN.m |

**Seismic in longitudinal direction (for fixed):**

|  |  |  |
| --- | --- | --- |
| Table 13 | Operating | Empty |
| Shear | 56.574 kN | 35.539 kN |
| Vertical load | 9.924 kN.m | 6.242 kN. |

**2.2.2 VESSEL 2:**

**Seismic in transverse direction (for sliding):**

|  |  |  |
| --- | --- | --- |
| Table 14: | Operating | Empty |
| Shear | 27.755 kN | 13.415 kN |
| Moment | 136.352 kN.m | 65.891 kN.m |

**Seismic in transverse direction (for fixed):**

|  |  |  |
| --- | --- | --- |
| Table 15 | Operating | Empty |
| Shear | 38.564 kN | 18.628 kN |
| Moment | 189.635 kN.m | 91.504 kN.m |

**Seismic in longitudinal direction (for sliding):**

|  |  |  |
| --- | --- | --- |
| Table 16 | Operating | Empty |
| Shear | 19.922 kN | 9.612 kN |
| Vertical load | 8.46 kN.m | 4.083 kN.m |

**Seismic in longitudinal direction (for fixed):**

|  |  |  |
| --- | --- | --- |
| Table 17 | Operating | Empty |
| Shear | 46.486 kN | 22.435 kN |
| Vertical load | 8.46 kN.m | 4.083 kN.m |

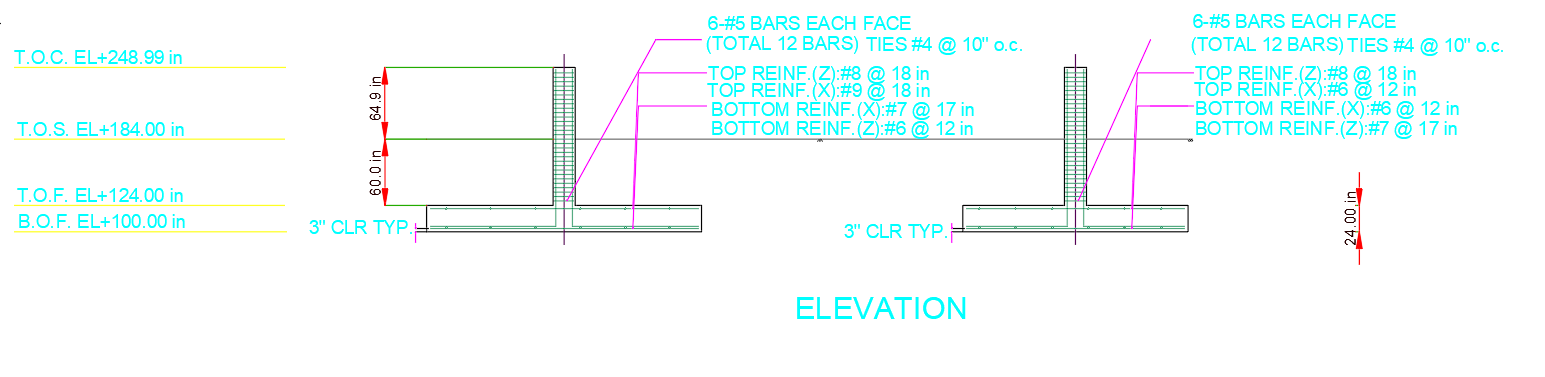


Fig. 9: fig shows the STAAD Foundation output

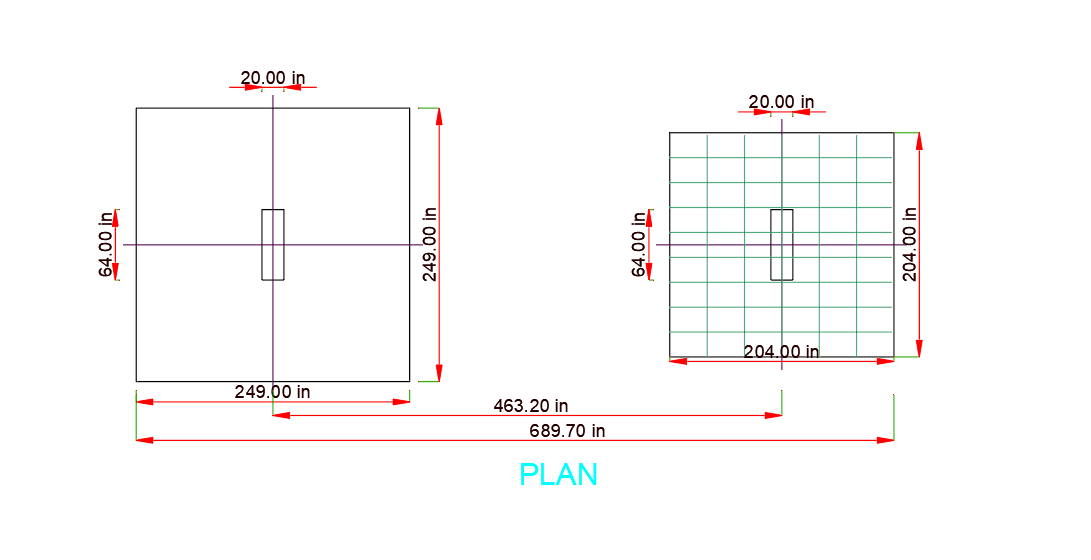


Fig. 10: fig shows the STAAD Foundation output

**CONCLUSIONS:**

The conclusion as per the result obtain from the STAAD foundation:

We came into conclusion that:

1. **For vertical vessel 1**: the value calculated for the overturning moment is slightly increased. The manually calculated value was **18612.956 kip-ft** while STAAD calculated the value was **164002.586 kip-ft.** due to which there is change in no. of dowels. Through manual calculation it was **50 Nos**. and the STAAD result was **80 Nos**. also STAAD foundation has calculated checks for one way shear which found out to be safe.
2. **For vertical vessel 2**: the value calculated for the overturning moment is slightly increased. The manually calculated value was **32040.971 kip-ft** while STAAD calculated the value was **442375.553 kip-ft.** due to which there is change in no. of dowels. Through manual calculation it was **50 Nos**. and the STAAD result was **376 Nos**. also STAAD foundation has calculated checks for one way shear which found out to be safe.
3. **For vertical vessel 3 :** the value calculated for the overturning moment is slightly increased. The manually calculated value was **18353.735kip-ft** while STAAD calculated the value was **290123.983 kip-ft**. due to which there is change in no. of dowels. Through manual calculation it was **50 Nos**. and the STAAD result was **248 Nos**. The tensile force also changes. while STAAD value was **16.706 kip-ft**. also STAAD foundation has calculated checks for one way shear which found out to be safe.
4. **For horizontal vessel 1:** the footing geometry provided for fixed and sliding saddle was identical. The minimum length provided was **15 ft** and maximum was **25 ft**. but the final length and width of vessel adopted was **18.91 ft.** with depth same as provided **2ft**.if we provide load combination in STAAD Foundation as per PIP we can see that the Foundation is failing in bearing check as well as the footing size is inadequate so to avoid such errors we will provide the load combination as per ASCE 7-05.
5. **For horizontal vessel 2:** the footing geometry provided for fixed and sliding saddle was identical. The minimum length provided was **15 ft** and maximum was **25 ft**. but the final length and width of vessel adopted was **20.75 ft**. with depth same as provided **2ft**.if we provide load combination in STAAD Foundation as per PIP we can see that the Foundation is failing in bearing check as well as the footing size is inadequate so to avoid such errors we will provide the load combination as per ASCE 7-05.

**REFERENCES**

1. *Finite Element Analysis Software – STAAD Foundation, STAAD Pro, AutoCAD Naviswork.*
2. *ACI (American concrete institute )-Concrete code – ACI – 318-11*
3. *ASCE (American society of civil engineer )-Loading code- ASCE-SEI-7-10*
4. *PIP (Process industry practices)-Structural code-STE05121-STE03360*
5. *Structural magazine - Burns & McDonnell performed an Engineer, Procure, Construct contract for a new NGL Fractionation Plant for ONEOK Hydrocarbon, L.P. located in Mont Belvieu, TX.*
6. *Tutorial links*

[*https://www.youtube.com./watch?v=G2elijkignZ8&t=226s*](https://www.youtube.com./watch?v=G2elijkignZ8&t=226s) *– Horizontal Vessel Foundation Isolated design*

[*https://www.youtube.com./watch?v=hZ\_5G6qdzMU&t=1550s*](https://www.youtube.com./watch?v=hZ_5G6qdzMU&t=1550s) *– For loading criteria*