STOCHASTIC SUPPLY CHAIN OPTIMIZATION FOR AMMONIA AND UREA PROCESSES

Seangplang Srisamut

A Thesis Submitted in Partial Fulfillment of the Requirements for the Degree of Master of Science 1.5 line The Petroleum and Petrochemical College, Chulalongkorn University in Academic Partnership with The University of Michigan, The University of Oklahoma, and Institut Français du Pétrole

2024



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A Thesis Submitted in Partial Fulfillment of the Requirements for the Degree of Master of Science in Petroleum and Energy Technology The Petroleum and Petrochemical College Chulalongkorn University Academic Year 2023

การหาค่าที่เหมาะสมที่สุดแบบสโตแคสติกสำหรับห่วงโซ่อุปทานของกระบวนการผลิตแอมโมเนีย และยูเรีย

นายเสียงเพลง ศรีสมุทร

วิทยานิพนธ์นี้เป็นส่วนหนึ่งของการศึกษาตามหลักสูตรปริญญาวิทยาศาสตรมหาบัณฑิต สาขาวิชาเทคโนโลยีปิโตรเลียมและพลังงาน วิทยาลัยปิโตรเลียมและปิโตรเคมี จุฬาลงกรณ์มหาวิทยาลัย ปิการศึกษา 2566

Thesis Title	Stochastic Supply Chain Optimization for Ammonia and
	Urea Processes
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เสียงเพลง ศรีสมุทร : การหาค่าที่เหมาะสมที่สุดแบบส โตแคสติกสำหรับหวง โซ่อุปทาน ของกระบวนการผลิตแอม โมเนียและยูเรีย. (Stochastic Supply Chain Optimization for Ammonia and Urea Processes) อ.ที่ปรึกษาหลัก : ผศ. คร.กิติพัฒน์ สีมานนท์

มีเทนจากก๊าซธรรมชาติสามารถใช้เป็นวัตถุดิบในกระบวนการผลิตแอมโมเนียและยูเรียได้ เพื่อรองรับการเติบโตของอุปสงคในภาคเกษตรกรรมการผลิตจากจำนวนประชากรที่เพิ่มขึ้น อย่างต่อเนื่องอย่างไรก็ตามโรงงานที่ใช้วัตถุดิบจากก๊าซธรรมชาติจะผลิตก๊าซการ์บอนไดออกไซด์ เป็นผลพลอยได้ของกระบวนการโรงงานที่นำเสนอนี้มีสองกระบวนการผลิตก็อแอมโมเนียและ ยูเรียซึ่งมีประสิทธิภาพในการผลิตมากขึ้นโดยผลผลิตพลอยได้ก๊าซการบอนได้ออกไซด์ สามารถนำมาใช้เป็นทางงานและประเมินการใช้พลังงานเพื่อให้สามารถทำการตลาดและทำไรให้ กับอุตสาหกรรมจึงได้มีการนำการวิเคราะห์ทางเสรษฐศาสตร์และเทคนิคสโตแคสติกมาใช้เพื่อจัด การกับความต้องการที่ไม่แน่นอนจากตลาดงานวิจัยนี้ประกอบด้วยสามส่วนหลักส่วนแรก เป็นการจำลองกระบวนการพื้นฐานของโรงงานผลิตแอมโมเนียและยูเรียโดยนำเข้าข้อมูลและ ค่าพารามิเตอร์ ที่ได้ มาจากอุตสาหกรรมบิโตรเคมีในประเทศไทยในส่วนที่สองการวิเคราะห์ ทางด้านเคนิกและเสรษฐกิจมีความซึ่งสำคัญสำหรับการศึกษาความเป็นไปได้ในการประเมินค่าใช้จ่าย และ ความสามารถในการทำกำไรในโครงการ

สาขาวิชา เทคโนโลยีปีโตรเลียมและพลังงาน ปีการศึกษา 2566

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##63xxxxxxx : MAJOR PETROLEUM AND ENERGY TECHNOLOGY KEYWOR Stochastic/ Optimization/ Supply chain/ Simulation/ Ammonia/ D: Urea

> Seangplang Srisamut : Stochastic Supply Chain Optimization for Ammonia and Urea Processes. Advisor: Asst. Prof. Kitipat Siemanond, D.Eng.

To support the demand growth in the agriculture sector from increasing population, ammonia and urea productions have been continuously increasing. Methane from natural gas can be used as feedstock in the production process. Nevertheless, the conventional plant using natural gas feedstock produces carbon dioxide as a by-product of the process. This proposed plant contains two processes, producing ammonia and urea can be more efficient in the production, where the byproducts of CO₂ can be used to produce more urea and reduce CO₂ emission. This research proposes ammonia and urea synthesis process using PROII software to simulate workflow and estimate the energy consumption. To be marketable and profitable for the agricultural industry, the techno-economic and stochastic analysis are applied to deal with uncertain demand from the market. This work is comprised of three main parts; the first part is the simulation of the base case process of the proposed ammonia/urea plant. The input data and parameters are obtained from the petrochemical industry in Thailand. In the second part, techno-economic analysis is significant for a feasibility study to estimate expenditure and the profitability of the project. Finally, the stochastic analysis is applied to optimize the production rate and supply chain of the products from various demands of the markets. The optimized supply chain network has been investigated on the production rate, the effect of penalty, and profit feasibility through profit accumulative curve. The conceptual design of manufacturing processes attempts to produce ammonia and urea, based on 1.930 t/d of natural gas feedstock.

Field of Study:	Petroleum and Energy Technology	Student's Signature
Academic Year:	2023	Advisor's Signature

ACKNOWLEDGEMENTS

The author would like to deeply gratitude to Asst. Prof. Kitipat Siemanond, for his expertly guidance, valuable comments, and suggestions on my thesis.

Besides my advisor, I would also like to extend my appreciation to the thesis examination committee, Asst. Prof. Chanin Panjapornpon and Prof. Boonyarach Kitiyanan for the useful suggestion and information.

I extend my next appreciation to all lecturers and staff in The Petroleum and Petrochemical College, who have sincerely helped me during academic year and research process periods.

Furthermore, I am grateful for the full scholarship and full funding of the thesis work provided by The Petroleum and Petrochemical College and Center of Excellence on Petrochemical and Materials Technology.

Finally, my deeply gratitude also extends to my family and my friends, for their worthy support and encouraged me in this effort. This accomplishment would not have been possible without them.

Seangplang Srisamut

TABLE OF CONTENTS

Pa	ıge
ABSTRACT (THAI) iii	i
ABSTRACT (ENGLISH)iv	7
ACKNOWLEDGEMENTS	7
TABLE OF CONTENTSvi	i
LIST OF TABLESix	ζ
LIST OF FIGURES	i
CHAPTER 1 INTRODUCTION	1
CHAPTER 2 LITERATURE REVIEW	3
2.1 Ammonia, Urea Characteristic	3
2.2 Application of Ammonia, Urea	3
2.3 Feed Source of Ammonia, Urea8	3
2.4 The Market of Ammonia and Urea11	l
2.5 Ammonia and Urea Production14	1
2.6 Ammonia Manufacturing Process14	1
2.6.1 Ammonia Plant Design19)
2.6.2 Modern Production Processes	l
2.6.3 Plant Designs in the 21st Century22	2
2.7 Urea Manufacturing Process	3
2.8 Techno-Economic Analysis (TEA)	3
2.8.1 Capital Expenditure (CAPEX) Estimation	1
2.8.2 Operating Expenditure (OPEX) Estimation	1
2.8.3 Profitability Analysis	1
2.8.4 Sensitivity Analysis	1

2.8.5 Equipment Design and Cost Estimation
2.8.5.1 Reactor
2.8.5.2 Flash Drum
2.8.5.3 Distillation Column
2.8.5.4 Centrifugal Pump
2.8.5.5 Compressor
2.8.5.6 Fired Heater
2.9 Stochastic Model
CHAPTER 3 EXPERIMENTAL
3.1 Materials and Equipment
3.1.1 Equipment
3.1.2 Softwares
3.2 Objectives and Scope of Research Work
3.2.1 Objectives
3.2.2 Scope of Research Work40
3.3 Methodology40
3.3.1 Simulation for Ammonia and Urea Manufacturing Processes40
3.3.2 Investment Expenditures of Ammonia and Urea Plants Assessment40
3.3.3 Case Studies40
CHAPTER 4 RESULTS AND DISCUSSION43
4.1 Properties and Specification for Simulation Processes – Ammonia Plant43
4.2 Process Flow Diagram – Case 1 Ammonia Manufacturing Process47
4.2.1 A Conceptual Design of Ammonia Production – Stage 1 Catalytic Reforming
4.2.2 A Conceptual Design of Ammonia Production – Stage 2 Shift Conversion and Gas Sweetening 47
4.2.3 A Conceptual Design of Ammonia Production – Stage 3 Compression48
4.2.4 A Conceptual Design of Ammonia Production – Stage 4 Conversion48
4.3 Energy Consumption Analysis – Ammonia Manufacturing Process53
4.4 Properties and Specification for Simulation Processes – Urea Plant

4.5 Process Flow Diagram – Case 2 Urea Manufacturing Process	.61
4.6 Energy Consumption Analysis – Urea Manufacturing Process	.63
4.7 Techno Economic Analysis of the Manufacturing Process	.65
4.7.1 Fixed Capital Cost	.65
4.7.1.1 Direct Manufacturing Expenditure	.65
4.7.1.2 Indirect Manufacturing Expenditure	.65
4.7.2 Working Capital Investment	.65
4.7.3 Depreciable Investment	.65
4.7.4 Expenditure Assessment for Ammonia and Urea Processes	.66
4.8 Investigation on Optimization of Market Demand (with Fixed Production Capacity of Ammonia and Urea)	.75
4.9 Investigation on Optimization of Market Demand (with Varied Production Capacity of Ammonia and Urea)	97
CHAPTER 5 CONCLUSION	117
APPENDICES	122
Appendix A Graphical Abstract	122
Appendix B Aaaaaa Aaaaaaa Aaaaaaa	123
Appendix C Aaaaaa Aaaaaa Aaaaa	125
Appendix D Aaaaa Aaaaaaaaa Aaaa	128
REFERENCES	130
VITA	133

LIST OF TABLES

Page
Table 4.1 Compositions of natural gas feed
Table 4.2 Properties of steam feed 44
Table 4.3 Properties of air feed 44
Table 4.4 Properties of water make up
Table 4.5 Ammonia production specification 44
Table 4.6 Input data of ammonia process 45
Table 4.7 Overall energy consumption for ammonia manufacturing process
Table 4.8 Energy consumption of ammonia production in stage 1
Table 4.9 Energy consumption of ammonia production in stage 2
Table 4.10 Energy consumption of ammonia production in stage 3
Table 4.11 Energy consumption of ammonia production in stage 4
Table 4.12 Ammonia feed for urea manufacturing process 59
Table 4.13 Carbon dioxide feed for urea manufacturing process 59
Table 4.14 Urea product specification
Table 4.15 Input data of urea process 60
Table 4.16 Energy consumption of urea production 63
Table 4.17 Utility cost coefficient with 470 of CEPCI and 7.2 of $C_{s,f}$
Table 4.18 Expenditure assessment for ammonia manufacturing process
Table 4.19 Expenditure assessment for urea manufacturing process from 3,870 TPD ammonia feed
Table 4.20 Detail Purchased Equipment Cost
Table 4.21 Detail total expenditure for ammonia and urea manufacturing
Table 4.22 Key assumptions used to develop the techno-economic model
Table 4.23 Correlation between ammonia feed to urea product
Table 4.24 The data related to the network 77
Table 4.25 The result of supply chains model network – fixed production capacity of ammonia and urea

Table 4.26 The optimal value of ammonia and urea transportation for 30 days
(historical)
Table 4.27 The result of supply chains model network – varied production capacity of ammonia and urea 100
Table 4.28 The optimal value of Ammonia and Urea for 30 days – varied ammonia and urea production rate (historical)
Table 5.1 Concluded information and key parameters of manufacturing process118
Table 5.2 Concluded information and key parameters of supply chain optimization 119

LIST OF FIGURES

Page
Figure 2.1 Ammonia Market by End-user Industry, Global, 2019 and 20244
Figure 2.2 Feedstock sources of ammonia production in the world
Figure 2.3 Ammonia Market – Growth Rate by Region, 2019-2024
Figure 2.4 Worldwide ammonia production has continued increased from 1946 to 2014
Figure 2.5 Overall production process for ammonia and urea plants
Figure 2.6 Schematic representation of the ammonia synthesis process
Figure 2.7 Haldor Topsoe Process Flow Sheet of Ammonia Production20
Figure 2.8 A simplified flowsheet of the first commercial ammonia plant by BASF23
Figure 2.9 KBR designed one of the first single-train, large-capacity ammonia plants. 24
Figure 2.10 Modern ammonia plants designed by KBR employ its proprietary Purifier
Figure 2.11 Haldor Topsøe offers an ammonia plant design that has a proprietary side- fired reformer in which radiant burners supply heat for the reforming reaction
Figure 2.12 The Linde Ammonia Concept (LAC) features a pressure-swing adsorption unit for high-purity hydrogen production and an air separation unit for high-purity nitrogen production
Figure 2.13 Schematic representation of urea synthesis
Figure 2.14 Scheme of the conventional process for urea production from natural gas.
Figure 2.15 Proposed plant for urea production using chemical looping process (before heat and power integration)
Figure 2.16 Overall methodology approach for techno-economic analysis
Figure 2.17 Structure of integrated forward/reverse logistics network
Figure 4.1 The simulation of ammonia production – stage 1 Catalytic reforming49
Figure 4.2 The simulation of ammonia production – stage 2 shift conversion and gas sweetening
Figure 4.3 The simulation of ammonia production – stage 3 compression
Figure 4.4 The simulation of ammonia production – stage 4 ammonia conversion52

Figure 4.5 Overall energy consumption of ammonia manufacturing process
Figure 4.6 Energy consumption of ammonia process in stage 1
Figure 4.7 Energy consumption of ammonia process in stage 2
Figure 4.8 Energy consumption of ammonia process in stage 3
Figure 4.9 Energy consumption of ammonia process in stage 4
Figure 4.10 The simulation of urea production
Figure 4.11 Energy consumption of urea process
Figure 4.12 Expenditure of ammonia process divided by utility type70
Figure 4.13 Expenditure of urea process divided by utility type70
Figure 4.14 Correlation between ammonia to urea product74
Figure 4.15 Urea utilities expenditure correlation with urea product74
Figure 4.16 The simple supply chain network diagram77
Figure 4. 17 Ammonia and urea demands of each market
Figure 4.18 The results from validation part of 12 scenarios – fixed production rate.
Figure 4.19 The new set of uncertainty market's demands of ammonia and urea in 12 scenarios, 30 days per scenarios (360 days) for validation part
Figure 4.20 profit cumulative frequency curve for supply chain No.12, No13, and deterministic one
Figure 4.21 The simple network diagram for varied production capacity of ammonia and urea
Figure 4.22 The results from validation part of 12 scenarios – varied production rate
Figure 4.23 Profit cumulative frequency curve for stochastic supply chains No.9, No. 12, No.23, and deterministic one – varied production capacity

CHAPTER 1 INTRODUCTION

Ammonia is one of important chemicals in the world. The use of ammonia to produce fertilizer has been increasing every year, relating to growing global population and increasing agriculture demand. Ammonia can be a feedstock to produce urea, the important chemical of nitrogen-based fertilizer and a widely used intermediate in the chemical industry. Ammonia can be used in various application such as solid ammonia energy carrier, liquid ammonia in cooling system, agriculture, chemical intermediate, polymer substance (synthesis fiber), etc.

Ammonia is a colorless, pungent smell gas and weak alkali which is very soluble in water. Ammonia is a compound of nitrogen and hydrogen with the formula NH₃. Mass production of Ammonia mostly uses the Haber–Bosch process, reacting hydrogen (H₂) and nitrogen (N₂) at a moderately-elevated temperature and high pressure.(Chisholm, 1911) Urea is an organic compound with the formula CO(NH₂)₂.

Urea is produced from ammonia and carbon dioxide. The urea synthesis process consists of two main equilibrium reactions. The first is call carbamate formation, that is exothermic reaction of liquid ammonia with gaseous carbon dioxide (CO₂) at high temperature and pressure. The second is called urea conversion, that is endothermic decomposition of ammonium carbamate into urea and water (Meessen and Petersen, 2000).

This research proposes the ammonia and urea synthesis process by using the PROII software to simulate workflow and estimate the energy consumption. This conceptual manufacturing process has production capacity about 3,000-4,000 ton per day for ammonia and 5,000 ton per day for urea, based on obtained data from Thailand's industrial section. The feedstock of the process is methane from natural gas.

In the production process, it has many expenditures on feedstock which are from utilities, chemicals, equipment, operating cost and treatment unit. To be marketable and profitable to industrials, the techno-economic evaluation is considered in this work. Techno-economic evaluation is a methodology framework to analyze the technical and economic efficiency of a process, product or service. It normally combines process modeling, engineering design and economic assessment. The techno-economic evaluation is a key of feasibility study to estimate project expenditure and profitability. This technique represents the capital cost, the operating cost, net present value, and payback period.

For more benefit, this research also includes the stochastic analysis to design optimal supply chain with production rate of ammonia and urea from plant to markets. the stochastic analysis is a basic tool in probability theory and is used in many applied areas especially statistical mechanics. It has become particularly formula as a way of modelling financial markets and strategies. Stochastic programming model also be used in logistics network design under uncertainty. One of the most important and strategic issues in supply chain management is the configuration of the logistics network that has a significant effect on the total performance of the supply chain

CHAPTER 2 LITERATURE REVIEW

2.1 Ammonia, Urea Characteristic

Ammonia is a compound of nitrogen and hydrogen with the chemical formula NH₃. It is a colorless gas with a characteristic acrid smell. Ammonia is lighter than air, its density is 0.589 times that of air. It is easily liquefied due to the strong hydrogen bonding between molecules; the liquid boils at -33.3 °C (-27.94 °F), and freezes at -77.7 °C (-107.86 °F) to white crystals (Chisholm, 1911). Ammonia is a chemical found in trace amounts in nature, it is produced naturally in human body and being produced from nitrogenous animal and plants matter. Ammonia and the ammonium ion are vital components of metabolic processes.

Urea is an organic compound of amide and carbonyl group with chemical formula CO(NH₂)₂. It is also known as carbamide. It is a solid odorless white crystal and noncombustible. It is very soluble in water but insoluble in ether, with a melting point at 132°C. Urea is one of the most widely produced chemicals in the world and based on demand for crops and fertilizer has been increased. More than 90% of the production of urea in the world is used for a nitrogen-release fertilizer.(Meessen and Petersen, 2000).

2.2 Application of Ammonia, Urea

Ammonia can be used in various applications such as fertilizer, explosive, dyes, household cleaners, energy carrier, chemical intermediate, Polymer substance (synthesis fiber), etc. The agriculture industry dominates the global ammonia market, with an estimated market share of more than 80% in 2018. Ammonia is majorly used in fertilizers, and its usage has been increasing through the years, thereby, driving its usage in the agriculture market. Urea is a dry nitrogen material produced by reacting ammonia with carbon dioxide. Urea has the highest percentage of nitrogen among the

commonly used dry fertilizers and is rapidly replacing ammonium nitrate in recent years.

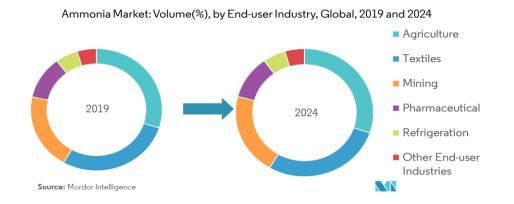


Figure 2.1 Ammonia Market by End-user Industry, Global, 2019 and 2024 (Mordor Intelligence, 2018).

From figure 2.1, it illustrates the major ammonia market is Agriculture section. The rest are textiles, mining, pharmaceutical, refrigeration, and other end-user industries. The forecast period of 2019-2024, the market's demand is increasing in the agriculture industry and the production of explosives (Intelligence, 2018).

M. Raihanul Islam Chowdhunry et al., (2002) researched effect of different methods of urea application on growth and yield in potato. The research was conducted to find out appropriate methods of urea application for maximizing the production of potato. There was a significant effect of different methods of urea application on plant emergence. The delay in plant emergence might be due to the accumulation of free ammonia and nitrites in the soil after the incorporation of urea. Application of urea as 50 % basal + 50 % top dressing produced the best result among the methods, and it was found to be the most cost effective. It might be concluded that split application of urea is the effective way to avoid the detrimental effect of urea on plant emergence and to maximize the tuber yield in Bangladesh (Chowdhury, 2002).

Debasish Chakraborty et al., (2009) studied for solid ammonia. This studied aim at the potential of 'solid' ammonia as a carbon-free energy carrier for mobile and transport applications, system integration and future opportunities. The result of this research illustrates that ammonia as a fuel cell for solid oxide fuel cell has some advantages over hydrocarbon fuels. The advantages include no desulfurization, and no pre-reforming requirement for ammonia. The combination of the direct ammonia fuel cell and the solid ammonia storage is very attractive for automotive applications, for several reasons. First, the operating temperature (400–600°C) of this type of fuel cell is ideal for ammonia decomposition So, there is a very good synergy between the reforming and fuel cell operation. Furthermore, the thermal desorption of ammonia from the solid storage materials can be achieved using the 'waste' heat from the stack, because the waste heat from a direct ammonia fuel cell stack operating at ~500°C will be of very good 'quality' to utilize for degassing ammonia. This will improve the overall system efficiency. Finally, the startup time much lower than the solid oxide fuel cell. This relatively lower operating temperature will also offer more options for materials selection (Chakraborty, 2009).

Sirinapa Santipanusopon, and Sa-Ad Riyajan (2009) studied the effect of ammonia treatment in field natural rubber latex with different storage period time on the properties of concentrated natural rubber latex and stability of skim latex. Fresh natural rubber latex was treated with various ammonia contents, 0.35, 0.60 and 0.80% w/w. The effect of storage time was observed with 0, 15, 30 and 45 days for concentrated natural rubber latex with different ammonia contents. This research demonstrated that magnesium content in field natural rubber latex and latex concentrate decreased with storage period times. The increasing ammonia content lead to the increment of the alkalinity content in both concentrated natural rubber and skim latex (Santipanusopon and Riyajan, 2009).

Zhe Han at al., (2015). The ammonia has been used as substrate for fertilizer such as ammonium nitrate. In this studied, the researchers focus on the alternatives to make ammonium nitrate safer as a fertilizer by reducing its explosivity. The effect of inhibitors, confinement, and heating rate on ammonium nitrate thermal decomposition has been studied. The results show that different types of additives, including sodium bicarbonate, potassium carbonate, and ammonium sulfate are good inhibitors for ammonium nitrate. The effect of confinement is concluded that confinement is dangerous to ammonium nitrate, which should be avoid in ammonium nitrate storage and transportation. The effect of heating rate shown that the lower heating rate lead to the lower the "onset" temperature detected (Han, 2015).

S. Seifi at al., (2016) studied Kaolin intercalated by urea for ceramic applications. They prepared Kaolinite-urea complexes by mixing and ball-milling at room temperature. Urea-intercalated kaolinite has potential applications in industry. This research found that the thermal transformations of intercalated kaolin with urea occur with several mechanisms depending on temperature. The expansion of kaolinite is involved to entering urea into inter-layers that confirms the occurrence of hydrogen bonding between urea and kaolinite. At expanded interlayers, bonds are formed between inner-surface hydroxyls of kaolinite and NH groups of urea that contribute to obtain physical properties of intercalated kaolinite similarly to delaminated kaolinite by intensive grinding that reduce the sintering temperature of more than 25°C, accelerating the densification rate. It was sufficient to induce a significant reduction of the specific energy consumption during large scale manufacturing of clay ceramics for building (Seifi, 2016).

Orbel Barkhordarian at al., (2017) researched a novel ammonia-water cogeneration system that combined power and refrigeration cycle to produce power and refrigeration outputs simultaneously. This cycle has two evaporators that can produce refrigeration output in two different temperature levels and capacities. Ammonia was used in field regarding refrigerating application. One of the key parameters that effect on the cycle performance is ammonia concentration. The effect of evaporator outlet temperature is obvious that refrigeration output decreasing with increasing of basic solution ammonia concentration. They also investigated the effect of key parameters and It is shown that the cycle's thermal performance is acceptable with exergy efficiency of 38.9%, effective exergy efficiency of 42.75% and thermal efficiency of 19% for the base case study (Barkhordarian, 2017).

Jiana Chen at al., (2017) studied effect of urea on nitrogen metabolism and membrane lipid peroxidation in Azolla pinnata. They reported the application of urea to Azolla pinata resulted in 44% decrease in nitrogenase activity, no significant change in glutamine synthetase activity, 660% higher glutamic-pyruvic transaminase, 39% increase in free amino acid levels, 22% increase in malondialdehyde levels, 21% increase in Na+/K+ levels, 16% in Ca2+ /Mg2+ ATPase levels, and 11% decrease in

superoxide dismutase activity. Urea treatment of Azolla induced an increase in glutamic-pyruvic transaminase (GPT) and catalase (CAT) activity and free amino and Malondialdehyde (MDA) concentrations and a decrease in nitrogenase and superoxide dismutase (SOD) activity. These findings demonstrate that urea application promotes amino acid metabolism and membrane lipid peroxidation in Azolla pinnata. These studied estimated the associated urea demand for energy crops (Chen, 2017).

Kiyoshi Sakuragi at al., (2018) researched the application of ammonia pretreatment to enable enzymatic hydrolysis of hardwood biomass. Ammonia pretreatment majorly improved enzymatic hydrolysis of polysaccharides in birch and willow, but was less effective for acacia, eucalyptus, and poplar. The effectiveness of ammonia pretreatment increased with xylan content but decreased with lignin content of the hardwood species. This research present that a delignification process is unnecessary for at least some hardwood biomass, such as birch, prior to enzymatic hydrolysis. Ammonia pretreatment should be effective to improve production of biofuels and biochemicals from hardwoods with high xylan and low lignin contents, such as birch and willow (Sakuragi, 2018).

A Valera-Medina at al., (2018) reviewed highlights previous influential studies and ongoing research to use ammonia as a viable energy vector for power applications. The review presented that the original applications of ammonia were in the chemical and agriculture industries and it still finds its greatest application as a fertilizer for intensive crop farming. However, in addition to its traditional applications, ammonia is an energetic chemical energy store with favorable physical properties, especially when compare to other chemical energy storages media (Valera-Medina, 2018).

ArdaYapicioglu, IbrahimDincer (2019) Modified from this review shown the uses of ammonia in various engine practical applications are Fuel cells, Spark ignition engines, Compression ignition engines, Gas turbines, Boilers, Generators, Refrigeration systems. Also, Ammonia is used as a fuel source in engines and fuel cells for this research purpose. The main finding of this review in the field regarding influence of ammonia in dual fuel combustion is increasing the amount of ammonia used, the exhaust temperatures and efficiency of the engine decrease. However, this increase lead to a reduction in destructive emission which is the main motivation for the use of clean fuel sources for combustion (Yapicioglu and Dincer, 2019).

2.3 Feed Source of Ammonia, Urea

Ammonia can be produced form various feedstock such as naphtha, heavy fuel oil, coal, natural gas coke oven and refinery. Steam reforming of natural gas is the most used as feed source of ammonia production in the world, nearly 72% of ammonia production as represent in figure 2.2. The rest are coal, fuel oil, naphtha and others, respectively (Bicer, 2016).

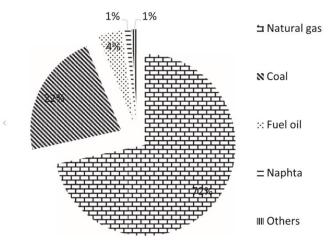


Figure 2.2 Feedstock sources of ammonia production in the world (Bicer, 2016).

Cetinkaya et al., (2012) studied comprehensive life cycle assessment for five different methods of hydrogen generation including steam reforming of natural gas, coal gasification, water electrolysis via wind and solar, and thermochemical water splitting with a Cu-Cl cycle. They demonstrate that the most environmentally mind system is wind electrolysis-based hydrogen production, which is then followed by solar PV based electrolysis process. Both of the renewable energy methods can be utilized in suitable locations with low capacities (Cetinkaya, 2012).

Paul Gilbert at al., (2014) studied and assessed economically viable carbon reductions for the production of ammonia from biomass gasification. To reduce greenhouse gas emission from fertilizer, food supplies that support for growing population, biomass gasification are substituting natural gas reforming for ammonia production using techno-economic and life cycle assessment. The biomass 0.72 kg (35% moisture content) can produce 1 kg of syngas. It can be estimated that for 1 kg ammonia approximately 2.71 kg biomass (35% moisture content) is required (not considering biomass losses in the system). The assessment of economic illustrates that the biomass derived ammonia will be competing mainly with imported fossil fuel based ammonia. The cost of production of ammonia for both natural gas and biomass gasification systems is heavily influenced by the price of the feedstock, as well as by process scale. Producing ammonia from biomass gasification is economically viable at current biomass feedstock and ammonia prices, resulting in greenhouse gas reductions of 65% compared to conventional ammonia production from natural gas. Furthermore, the capital costs have high uncertainty to investor, lead to a very high risk investment (Gilbert, 2014).

Yusuf Bicer at al., (2016) present the result of comparative life cycle assessment of various ammonia production methods. They selected four different ammonia production methods for comparative assessment purposes. municipal wastebased ammonia production, nuclear high temperature-based ammonia production, biomass-based ammonia production, and hydropower-based ammonia production. They illustrate the energy efficiency for hydropower, nuclear high temperature, electrolysis, biomass-based electrolysis, and municipal waste-based electrolysis are calculated as 42.7%, 23.8%, 15.4%, and 11.7%, respectively. The exergy efficiencies of hydropower, nuclear, biomass and municipal waste-based ammonia production methods are yielded as 46.4%, 20.4%, 15.5% and 10.3%, respectively., respectively. They conclude that different resources-based ammonia production methods are thermodynamically analyzed and the energy and exergy efficiency values are comparatively assessed and renewable sources with their improved efficiency can reduce the overall environmental footprint. So, it can replace the current fossil fuel based centralized ammonia production facilities (Bicer, 2016). D. Frattini at al., (2016) researched a sustainable pathway for ammonia synthesis to reduce the use of fossil fuels of the Haber-Bosch process and, taking advantage of renewable sources. In field of use as a renewable energy system, hydrogen can be obtained from biomass gasification, biogas reforming or electrolysis of water with electricity generated by solar or wind energy. The Aspen Plus environment were used as the model development and operating parameters for simulations. The reactor block used to model units is "RGibbs" and the built-in NRTL property method is set as the thermodynamic model for the reforming and clean-up section. The authors reported that the model results are mainly in terms of gas and energy flows. Each of the three new concepts allows to produce ammonia in a novel way and simultaneously reducing the impact on the environment. This study demonstrates that ammonia can be produced in an efficient way from renewable using a thermochemical model developed in Aspen Plus (Frattini, 2016).

Maryam Akbari at al., (2018) studied the ammonia production from black liquor gasification and co-gasification with pulp and waste sludges. They investigated ammonia production though the gasification of three different feedstocks. The first case used black liquor, and in the other two cases pulp sludge and waste sludge are co-gasified with black liquor. The all of three cases process model in field of mass and energy balance were used to estimate the equipment size and estimate costs. The results indicated that ammonia production in all three cases cost decrease 10% competitive with current ammonia prices, there ranges from 743 to 748\$/ton. The result of techno-economic assessment show that the cost of production is most sensitive to the capital cost, discount rate, electricity price and plant lifetime (Akbari, 2018).

Dong Xiang, Yunpeng Zhou (2018) studied a new design and technoeconomic performance of hydrogen and ammonia co-generation by coke-oven gaspressure swing adsorption technology integrated with chemical looping hydrogen process. This concept design process has two extreme configurations to produce hydrogen or ammonia only. The optimization of coke-oven gas utilization and maximize hydrogen and subsequent ammonia production desire the analysis of key operational parameters of system. The maximal ammonia and hydrogen productions are 4,784 and 7,126 kmol/h of 5,532 kmol/h coke–oven gas consumption for the extreme configurations, respectively. In this concept design process, switching between ammonia and hydrogen production have 68.5-73.6 % exergy efficiency and about 100% direct CO₂ efficiency. They also include the economic and sensitive analyses of this novel process in the studied (Xiang and Zhou, 2018).

2.4 The Market of Ammonia and Urea

In current, the demand in global market for fertilizer is rising modestly. In 2018, Asia-Pacific is the majority in ammonia market, accounting for more than half of the consumption globally. With the increasing population in countries such as China and India, increased agricultural activity has resulted in increased ammonia fertilizer usage, which will drive the market. China was the major consumer of ammonia in both the Asia-Pacific region and in the global market in 2018. Overall, the market for ammonia in Asia-Pacific region is anticipated to increasing significantly in the future (Intelligence, 2018).

Ammonia Market - Growth Rate by Region, 2019-2024



Figure 2.3 Ammonia Market – Growth Rate by Region, 2019-2024 (Mordor Intelligence, 2018).

From figure 2.3 that illustrate the growth rate of ammonia market by region. The forecast period is during 2019-2024 which have 3 regional growth rates.

Global production rates

Ammonia production has become one of the most important industries in the world. From figure 2.4, ammonia production has increased steadily since 1946 and it is estimated that the annual production of ammonia is worth more than \$100 billion, with some plants producing more than 3,000 million ton per day of NH₃.

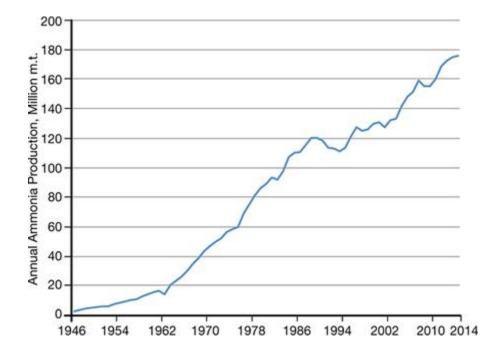


Figure 2.4 Worldwide ammonia production has continued increased from 1946 to 2014. (AlChE The Global Home of Chemical Engineers, 2016).

Patricia M. Glibert at al., (2006) reported the escalating worldwide use of urea and global contributing to coastal eutrophication. The review has shown in field of demand that global rates of urea-base fertilizer usage have increased rapidly, so that more urea is now used than any other nitrogen fertilizer. Global urea usage extends beyond applications; urea is also used extensively in animal feeds and in manufacturing processes. The use of urea around the world is expected to continue with the potential to increase coastal waters pollution world-wind (Glibert, 2006). Patricia Carneiro dos Santos, Alexandre S. Szklo (2016) researched about urea imports in Brazil and the increasing demand pressure from the biofuels industry and the role of domestic natural gas for the country's urea production growth. Brazil is a major producer of liquid biofuels. These high production level require to use of fertilizer, and to put the pressure on the nitrogen fertilizer domestic market. This contributes to increasing level of imports and trade shortage in the chemical industry. The findings show that Brazil will stay a major importer of urea. Urea associated with the production of biofuels has sufficient magnitude to justify an expansion of production capacity through a greenfield facility. this study estimated the associated urea demand for energy crops. The data shown average import prices for ammonia and urea in Brazil, 511.83 and 315.113 US\$ FOB/ton, respectively. However, the analysis of natural gas breakeven price to a greenfield urea project indicates that the project is not feasible (dos Santos and Szklo, 2016).

A Valera-Medina at al., (2018) reviewed highlights previous influential studies and ongoing research to use ammonia as a viable energy vector for power applications. The review shown that ammonia can be produced using renewable sources which not only contributes to reducing greenhouse emission, but also offers flexibility its utilization, allows fuel cells to be run effectively (using smaller, safer and economically viable configurations), enable combustion systems has the potential of operating at high power whilst producing tolerable levels of emissions, and enable advanced propulsion systems to be developed with smaller tanks. Thus, the ease of storages, transportation and use of ammonia make it an attractive candidate to act as the energy vector between sustainable energy harvesting and mobile and static energy demands (Valera-Medina, 2018).

2.5 Ammonia and Urea Production

Several processes of ammonia and urea have been invented for optimum production rate and product specification including energy conservation. A HEN optimization is a network to minimize the energy requirement of a conceptual ammonia/urea plants. Therefore, this work is focused not only on the energy consumption analysis but also economic feasibility of processes. The capacity of conceptual ammonia and urea plant is 3,264 and 2,000 ton per day (TPD), respectively. The methane from natural gas is used as feedstock of the production. The overall production design is shown in figure 2.5.

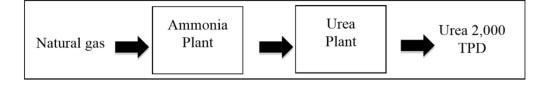


Figure 2.5 Overall production process for ammonia and urea plants.

2.6 Ammonia Manufacturing Process

Ammonia is synthesized from hydrogen (from natural gas) and nitrogen (from the air). The operating condition is operated with high temperature about 450-500 °C and high pressure about 80-90 bar. The reaction mixture is cooled so that the ammonia liquefied and can be removed. The remaining nitrogen and hydrogen are recycled. Ammonia synthesis reaction is reversible. The overall reactions of ammonia production are shown as following equations.

 $N_2(g) + 3H_2(g) \rightleftharpoons 2NH_3(g) \text{ (reversible)}; \Delta H_{298} = -92.43 \text{ kJ/mol}$ (1)

(Modak, 2002)

Desulfurization unit: to remove sulfur content. Natural gas contains some sulfurous compounds which damage the catalysts used in this process. These are removed by reacting them with zinc oxide, e.g.

$$ZnO + H_2S \rightarrow ZnS + H_2O ; \Delta H_{298} = 76.9 \text{ kJ/mol}$$
(2)
(Giuffrida, 2010)

Primary reforming unit: methane (sweet dry gas) is converted to hydrogen and carbon dioxide, the reactions are:

CH₄ + H₂O \Leftrightarrow 3H₂ + CO (synthesis gas); Δ H₂₉₈ = 206.30 kJ/mol (3)

 $CH_4 + 2H_2O \rightleftharpoons 4H_2 + CO_2; \Delta H_{298} = 165.0 \text{ kJ/mol}$ (4)

(Ochoa-Fernández, 2005)

Secondary reforming unit: hot air is added, the reactions are:

$$CO + H_2O \iff CO_2 + H_2 \text{ (synthesis gas) ; } \Delta H_{298} = -41.15 \text{ kJ/mol}$$
(5)

$$2CH_4 + O_2 \rightarrow 2CO + 4H_2; \quad \Delta H_{298} = -71 \text{ kJ/mol}$$
(6)

$$2O_2 + CH_4 \rightarrow 2H_2O + CO_2 ; \Delta H_{298} = -802.5 \text{ kJ/mol}$$
 (7)

(Azzaro-Pantel, 2018)

Shift conversion unit: carbon monoxide is removed by water gas shift reaction. Carbon monoxide is converted to carbon dioxide.

$$CO + H_2O \rightleftharpoons CO_2 + H_2 ; \Delta H_{298} = -41.33 \text{ kJ/mol}$$
(8)

(Lin and Wu, 2020)

Methanation unit: all carbon oxides are converted to methane by following equations:

$$CO + 3H_2 \rightleftharpoons CH_4 + H_2O; \Delta H_{298} = -206.30 \text{ kJ/mol}$$
 (9)

$$CO_2 + 4H_2 \rightleftharpoons CH_4 + 2H_2O$$
; $\Delta H_{298} = -164.90 \text{ kJ/mol}$ (10)

(Lin and Wu, 2020)

Ammonia synthesis unit: to produce final ammonia product

$$N_2 + 3H_2 \rightleftharpoons 2NH_3$$
; $\Delta H_{298} = -46.14 \text{ kJ/mol}$ (11)

(Modak, 2002)

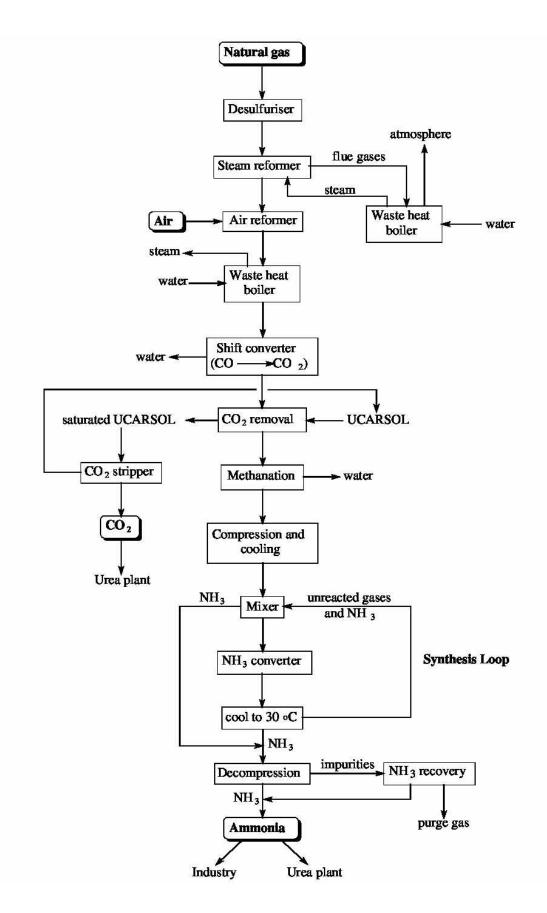


Figure 2.6 Schematic representation of the ammonia synthesis process (Copplestone and Kirk, 2008).

The ammonia manufacturing process is shown schematically in figure 2.6.

Schematic description

Step 1 - Hydrogen production: Hydrogen is produced by the reaction of methane with water. However, before this can be carried through, all sulfurous compounds must be removed from the natural gas to prevent catalyst damaging. These are removed by heating the gas to 400°C and reacting it with zinc oxide. The gas is sent to the primary reformer for steam reforming, where superheated steam is fed into the reformer with the methane. The gas mixture heated with natural gas and purge gas to 770°C in the presence of a nickel catalyst. The reaction converting the methane to hydrogen, carbon dioxide and small amount of carbon monoxide. This gaseous mixture is known as synthesis gas.

Step 2 - Nitrogen addition: The synthesis gas is cooled slightly to 735°C. It then flows to the secondary reformer where it is mixed with a calculated amount of air. The highly exothermic reaction between oxygen and methane produces more hydrogen. In addition, the necessary nitrogen is added in the secondary reformer.

Step 3 - Removal of carbon monoxide: Here the carbon monoxide is converted to carbon dioxide (which is used later in the synthesis of urea) in a reaction known as the water gas shift. This is achieved in two steps. Firstly, the gas stream is passed over a Cr/Fe3O4 catalyst at 360°C and then over a Cu/ZnO/Cr catalyst at 210°C. The same reaction occurs in both steps but using the two steps maximizes conversion.

Step 4 - Water removal: The gas mixture is further cooled to 40°C, at which temperature the water condenses out and is removed.

Step 5 - Removal of carbon dioxides: The gases are then pumped up through a counter-current of UCARSOLTM solution. Carbon dioxide is highly soluble in this solution, and more than 99.9% of the CO₂ in the mixture dissolves in it. The remaining CO₂ is converted to methane (methanation) using a Ni/Al₂O₃ catalyst at 325° C. The water which is produced in these reactions is removed by condensation at 40°C as above. The carbon dioxide is stripped from the UCARSOL and used in urea manufacture. The UCARSOL is cooled and reused for carbon dioxide removal.

Step 6 - Synthesis of ammonia: The gas mixture is now cooled, compressed and fed into the ammonia synthesis loop. A mixture of ammonia and unreacted gases which have already been around the loop are mixed with the incoming gas stream and cooled to 5°C. The ammonia present is removed, and the unreacted gases heated to 400°C at a pressure of 330 barg and passed over an iron catalyst. The outlet gas from the ammonia converter is cooled from 220°C to 30°C. This cooling process condenses more the half the ammonia, which is then separated out.

2.6.1 Ammonia Plant Design

Haldor-topsoe process is the process which depart form Haber's process. The residual gas of this process is wasted to atmosphere.

The advantages of this process are:

- It has a greater compactness, simplicity in case of converter design since under high-pressure gases have a smaller volume.
- This process is to eliminate expensive heat exchangers that are needed in processes that operate at low pressure.
- This process is removal of ammonia with water cooling alone.

The disadvantages of this process are:

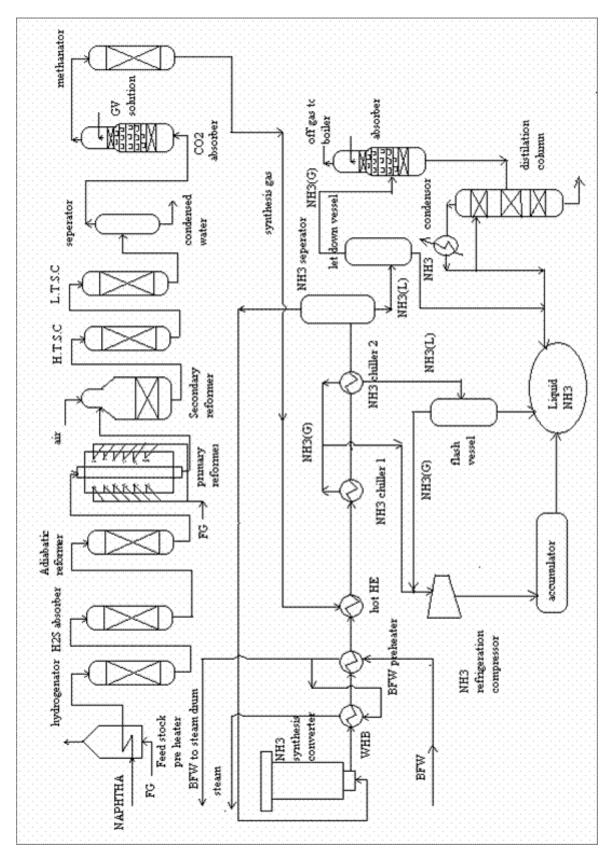
- This process has a Shorter life of converters.
- High maintenance equipment in the high-pressure operation.
- There are about 20 % loss of gas production which is unconverted.

Haldor Topsoe process flow sheet of ammonia production is shown in figure 2.7

Process important sections:

- 1. Desulphurization Section
- 2. Reforming Section
- 3. CO Conversion Section
- 4. CO₂ Conversion Section
- 5. Methanation
- 6. Ammonia Synthesis Section
- 7. Refrigeration Section
- 8. Ammonia Absorption Section







Most of the global production of ammonia are produced from steam reforming of natural gas, significant quantities are produced by coal gasification; most of the gasification plants are in China.

The first commercial ammonia plant based on the Haber-Bosch process was built by BASF at Oppau, Germany with a production capacity of 30 million ton per day. The flow sheet of the first commercial ammonia plant by BASF is illustrated in figure 2.8.

2.6.2 Modern Production Processes

The demand for ammonia has increased considerably during the years 1950-1980, allowing plants to grow larger and save more energy.

In the mid-1960s, the American Oil Co. installed a single-converter ammonia plant engineered by M.W. Kellogg (MWK) at Texas City, TX, with a capacity of 544 million ton per day. The single-train design concept is illustrated in the figure 2.9. Important differences between the MWK process and the processes used in previous ammonia plants included:

- using a centrifugal compressor as part of the synthesis gas compression
- maximizing the recovery of waste heat from the process
- generating steam from the waste heat for use in steam turbine drivers

- using the refrigeration compressor for rundown and atmospheric refrigeration. Combined forms that use to balanced energy, energy production, equipment size and catalyst volume are combined throughout the plant.

2.6.3 Plant Designs in the 21st Century

During the first few years of the 21st century, there were many improvements in ammonia technology that helped existing plants increase production rates and new plants to be built with larger and greater capabilities.

Most of the ammonia plants recently designed by KBR utilize its Purifier process (figure 2.10), which combines low-severity reforming in the primary reformer, a liquid N₂ wash purifier downstream of the methanator to remove impurities and adjust the H₂:N₂ ratio, a proprietary waste-heat boiler design, a unitized chiller, and a horizontal ammonia synthesis converter. The energy consumption of this plant can be as low as 28 GJ per million ton. The primary reformer can be smaller than in conventional designs because the secondary reformer uses excess air.

The syngas generation section of a Haldor Topsøe-designed plant is quite traditional except for its proprietary side-fired reformer, which uses radiant burners to supply heat for the reforming reaction. More recent developments include the S-300 and S-350 converter designs. The S-300 converter is a three-bed radial-flow configuration with internal heat exchangers, while the S-350 design combines an S-300 converter with an S-50 single-bed design with waste-heat recovery between converters to maximize ammonia conversion. The Haldor Topsøe-designed plant is illustrated in figure 2.11.

The Linde Ammonia Concept (LAC) is an established technology process scheme with over 25 years of operating experience in plants with capacities from 200 million ton per day to over 1,750 million ton per day. The LAC process scheme, as shown in figure 2.12, replaces the expensive and complex front end of a conventional ammonia plant with two well-proven, dependable process units:

- production of ultra-high-purity hydrogen from a steam-methane reformer with PSA purification
- production of ultra-high-purity nitrogen by a cryogenic nitrogen generation unit, also known as an air separation unit (ASU).



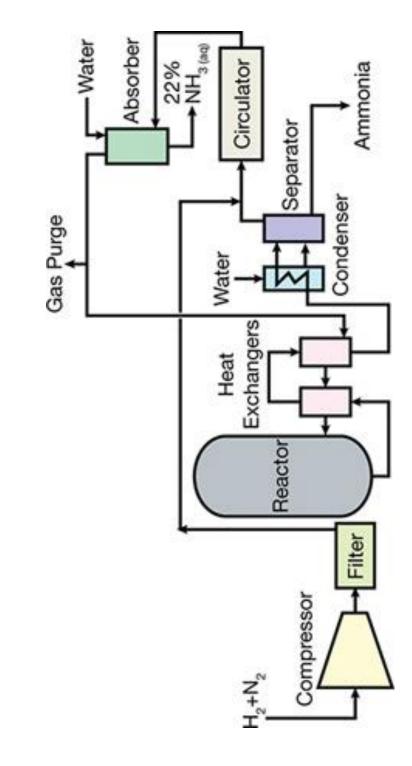
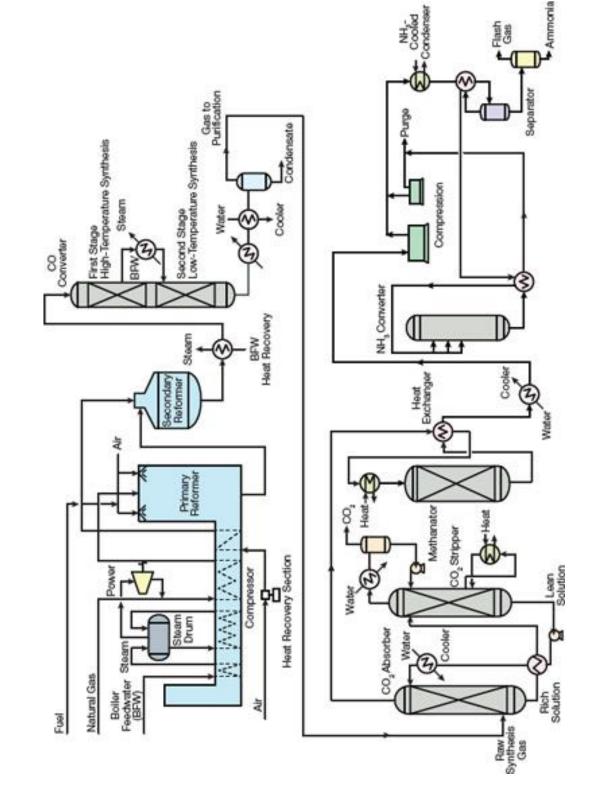
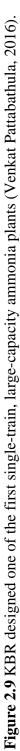
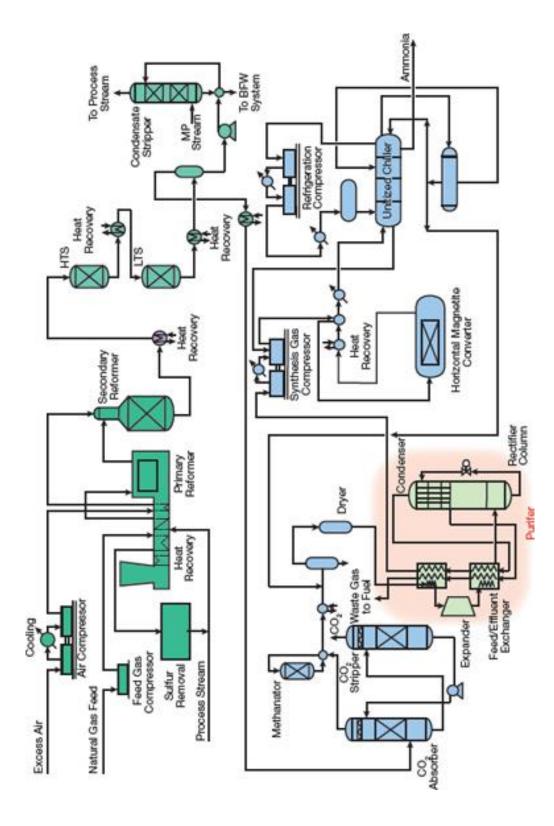


Figure 2.8 A simplified flowsheet of the first commercial ammonia plant by BASF (Venkat Pattabathula, 2016).











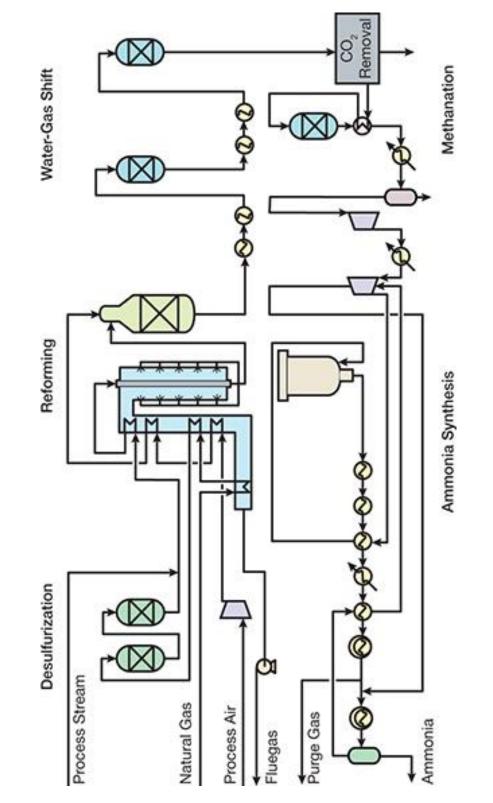
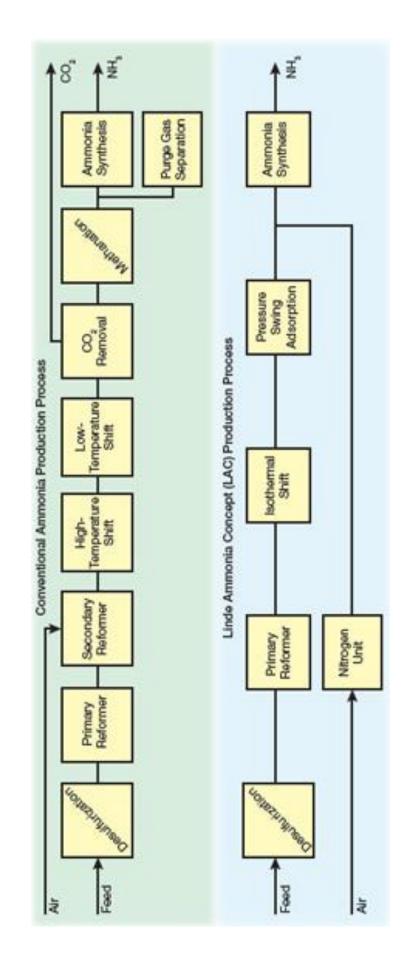
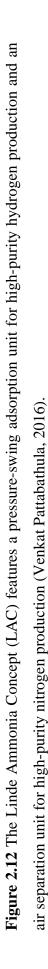


Figure 2.11 Haldor Topsøe offers an ammonia plant design that has a proprietary side-fired reformer in which radiant burners supply heat for the reforming reaction (Venkat Pattabathula, 2016).





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27

2.7 Urea Manufacturing Process

As mentioned above, most of the ammonia is used on site in the production of urea. The remainder is sold domestically for use in industrial refrigeration systems and other applications that require anhydrous ammonia. The urea is used as a nitrogen-rich fertilizer, and as such is of great importance in agriculture, one of world's major industries. There are two main equilibrium reactions in the urea synthesis. The first reaction is highly fast exothermic in which ammonia and carbon dioxide are converted to ammonia carbamide. The second reaction is slow endothermic. The operating condition is operated at high pressure 20-25 bar with temperature 150-220 °C. Urea is produced from ammonia and carbon dioxide in two equilibrium reactions:

$$2NH_3(aq) + CO_2(g) \Leftrightarrow NH_2COONH_4(aq); \Delta H = -72.32 \text{ kJ/mol}$$
 (12)

$$NH_2COONH_4 \rightleftharpoons NH_2CONH_2 (urea) + H_2O; \Delta H = 15.5 \text{ kJ/mol}$$
 (13)

The urea manufacturing process, shown schematically in Figure 2.13, is designed to maximize these reactions while inhibiting biuret formation:

$$2NH_2CONH_2 \iff NH_2CONHCONH_2 (biuret) + NH_3$$
(14)

This reaction is undesirable, not only because it lowers the yield of urea, but because biuret burns the leaves of plants. This means that urea which contains high levels of biuret is unsuitable for use as a fertilizer.

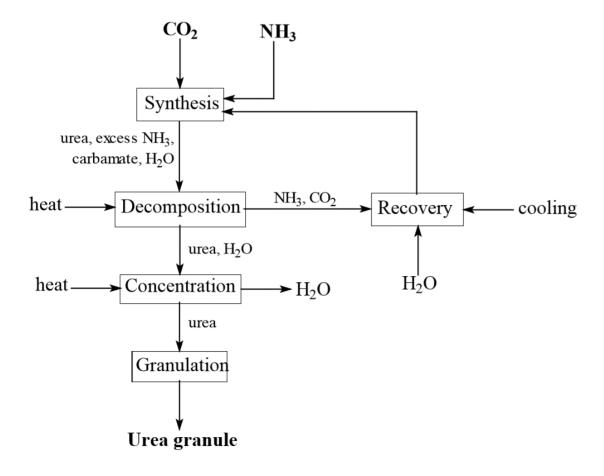


Figure 2.13 Schematic representation of urea synthesis (Copplestone and Kirk, 2008).

This reaction is undesirable, not only because it lowers the yield of urea, but because biuret burns the leaves of plants. This means that urea which contains high levels of biuret is unsuitable for use as a fertilizer.

Schematic description

Step 1 – Synthesis: A mixture of compressed CO_2 and ammonia at 240 barg is reacted to form ammonium carbamate. This is an exothermic reaction, and heat is recovered by a boiler which produces steam. The first reactor achieves 78% conversion of the carbon dioxide to urea and the liquid is then purified. The second reactor receives the gas from the first reactor and recycle solution. Conversion of carbon dioxide to urea is approximately 60% at a pressure of 50 barg.

Step 2 – **Purification**: The major impurities in the mixture at this stage are water from the urea production reaction and unconsumed reactants (ammonia, carbon dioxide and ammonium carbamate). The unconsumed reactants are removed in three stages. Firstly, the pressure is reduced from 240 to 17 barg and the solution is heated, which causes the ammonium carbamate to decompose to ammonia and carbon dioxide:

$$NH_2COONH_4 \rightleftharpoons 2NH_3 + CO_2$$

At the same time, some of the ammonia and carbon dioxide flash off. The pressure is then reduced to 2.0 barg and finally to -0.35 barg, with more ammonia and carbon dioxide being lost at each stage. By the time the mixture is at -0.35 barg a solution of urea dissolved in water and free of other impurities remains. At each stage the unconsumed reactants are absorbed into a water solution which is recycled to the secondary reactor. The excess ammonia is purified and used as feedstock to the primary reactor.

Step 3 – Concentration: 75% of the urea solution is heated under vacuum, which evaporates off some of the water, increasing the urea concentration. At this stage some urea crystals also form. The solution is then heated from 80 to 110°C to dissolve these crystals prior to evaporation. In the evaporation stage molten urea (99% w/w) is produced at 140°C. The remaining 25% of the 68% w/w urea solution is processed under vacuum at 135°C in a two series evaporator-separator arrangement.

Step 4 – **Granulation**: Urea is sold for fertilizer as 2 - 4 mm diameter granules. These granules are formed by spraying molten urea onto seed granules which are supported on a bed of air. This occurs in a granulator which receives the seed granules at one end and discharges enlarged granules at the other as molten urea is sprayed through nozzles. Dry, cool granules are classified using screens. Oversized granules are crushed and combined with undersized ones for use as seed. All dust and air from the granulator are removed by a fan into a dust scrubber, which removes the urea with a water solution then discharges the air to the atmosphere. The final product is cooled in air, weighed and conveyed to bulk storage ready for sale (Copplestone and Kirk, 2008).



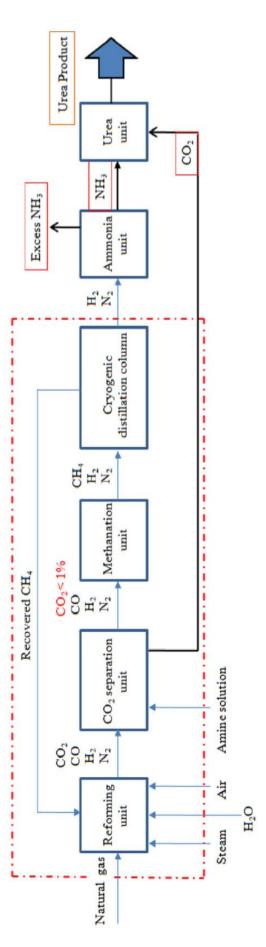
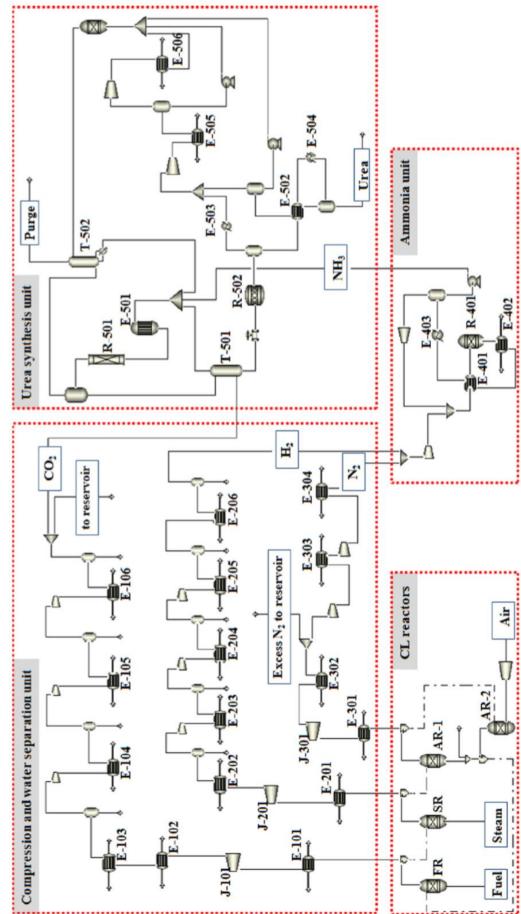


Figure 2.14 Scheme of the conventional process for urea production from natural gas (Edrisi, 2016).

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32

2.8 Techno-Economic Analysis (TEA)

Techno-Economic model is an integration of technological research and commercial development involves engineering process design with economic feasibility. Also, it is a key of financial evaluation to provide investment and marketing. In this work is focused on 2 main parts. First part is simulation since production route until material and process validation. Second part is economic analysis which mainly represents the capital expenditure, the operating expenditure, net present value, and payback period. The overall hierarchical approach that used as a base-case model to design and to develops the final production is shown in figure 2.16.

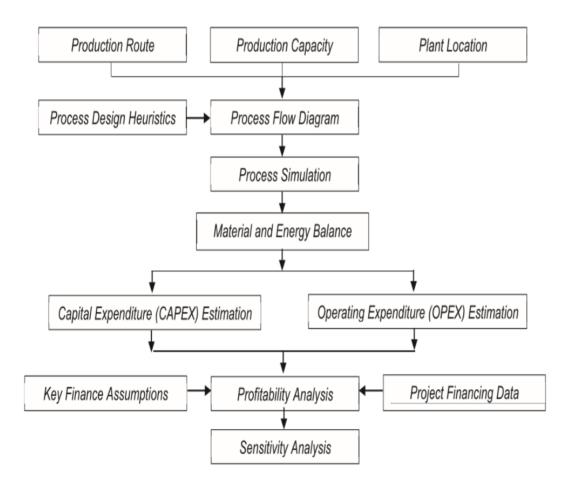


Figure 2.16 Overall methodology approach for techno-economic analysis (Cheah, 2017).

2.8.1 Capital Expenditure (CAPEX) Estimation

Capital expenditure represents a property, plant, equipment, and services that will be used for more than one year. This cost includes mainly purchasing process equipment, hardware purchases, vehicles and associates with constructing the plant includes investing activities.

2.8.2 Operating Expenditure (OPEX) Estimation

Operating expenditure represents a necessary expense of a business which incurs through its normal operations to keep the business running on a daily basis. This cost includes rent, utilities, salaries, equipment, inventory costs, marketing, general, & administrative expenses, property taxes, payroll, insurance, research expenses, and development.

2.8.3 Profitability Analysis

Profitability analysis is used to determine the amount of profit earned due to the efficiency of any operation. This technique helps in a financial decision, marketing and product management for a company.

2.8.4 Sensitivity Analysis

In this work, a definition of sensitivity analysis is a technique used to identify a differently independent variables which impacts to the main dependent variables. For example; production rate, stream/methane ratio, feed temperature/pressure of each reactors, synthesis loop pressure, and conversion percentage. For ammonia and urea processes, these variables are used to consider on the plant feasibility. For cost index is used the most common one which is from IHS CERA index. The equipment costs were estimated using a guide to chemical engineering process design and economics book as shown below

Present cost = (capital cost index in 2019/capital cost index in 2000) x previous cost

2.8.5 Equipment Design and Cost Estimation

Calculation of equipment cost is based on material and energy balance, operation condition, material handling. Estimating equipment costs are represented as the following equations.

2.8.5.1 Reactor

In this simulation work, Reactor is based on residence time of 60 s. The purchased cost formulation is shown as the following equations (Seider, 2004)

$$V_R = 1.25T_R \times Q$$
 (15)

$$C_{\text{reactor}} = 14000 + 15400 V_{\text{R}}^{0.7} \tag{16}$$

 $\label{eq:Where V_R} Where \ V_R \ is the \ reactor \ volume \ in \ m^3, \ Q \ is \ the \ volumetric \ flow \ rate \ in \ m^3/s \ and \ T_R \ is \ residence \ time \ in \ s.$

2.8.5.2 Flash Drum

The purchased cost of flash drum is formulated as the following equations (Seider, 2004)

$$V_F = QT_F \tag{17}$$

$$C_{\rm F} = 12685 V_{\rm F}^{0.3641} \tag{18}$$

Where V_F is the flash drum volume in m³, Q is the volumetric flow rate in m³/s and T_F is the fixed residence time in s.

The purchased cost of distillation column is calculated as the following equations (Seider, 2004)

$$A_n = 0.5 V_m (\rho_v)^{0.5}$$
(19)

$$D_{\rm c} = (4A_{\rm n})^{0.5} (0.88\pi)^{-0.5}$$
(20)

$$H_c = 1.2(N-1)Ts$$
 (21)

$$C_{DC} = 4555 \text{ H}_{c}^{0.81} - D_{c}^{1.05}$$
(22)

Where H_c is height of the column in m, D_c is diameter of the column in m, N is the number of trays, Ts is the tray spacing in m (assume 1 m), A_n is the net activate area, ρ_v is the vapor mass density, and V_m is the vapor mass flow rate.

2.8.5.4 Centrifugal Pump

The purchased cost of Centrifugal Pump is calculated as the following equations (Seider, 2004)

$$S = Q(H)^{0.5}$$
 (23)

$$C_p^{0} = 5.4 \exp(9.7171 - 0.6019[\text{Ln}(S)] + 0.0519[\text{Ln}(S)]^2)$$
 (24)

Where Q is the volumetric flow rate in the range of 0.2-500 L/s, H is the pump head in feet of fluid flowing.

2.8.5.5 Compressor

The purchased cost of carbon-steel centrifugal compressors are calculated by using following equation (Seider, 2004)

$$C_{\rm com}^{0} = 8400 + 3100 \, {\rm P}^{0.6} \tag{25}$$

Where P in driver power ranges from 132 to 29,000 kW.

2.8.5.6 Fired Heater

The purchased cost of stainless-steel fired heater with maximum heat pressure of 5000 KPa can be calculated by using following equation (Seider, 2004)

$$C_{\rm FH}^{0} = 184967 \text{ HD}^{0.7636} \tag{26}$$

Where HD is the heat duty in MW

2.9 Stochastic Model

Stochastic analysis is a basic tool in much of modern probability theory and is used in many applied areas from biology to physics, especially statistical mechanics. It has become particularly well known via the Black-Scholes formula as a way of modelling financial markets and strategies. Stochastic programming model also be used in logistics network design under uncertainty. One of the most important and strategic issues in supply chain management is the configuration of the logistics network that has a significant effect on the total performance of the supply chain.

Mir Saman Pishvaee at el. (2009). They developed a stochastic and optimization model for integrated forward and reverse logistics network design under uncertainty. This study proposes a scenario-based stochastic optimization model. The model used hybrid distribution, collection facilities that offer cost savings and pollution reduction because of sharing material handling equipment and infrastructure. The uncertainty in the quality of returned products is modeled by considering the share of recoverable and scrapped products in the returns as a stochastic parameter. Computational results showed that the stochastic model could handle data uncertainty with a reasonable increase in total costs compared with the deterministic model.

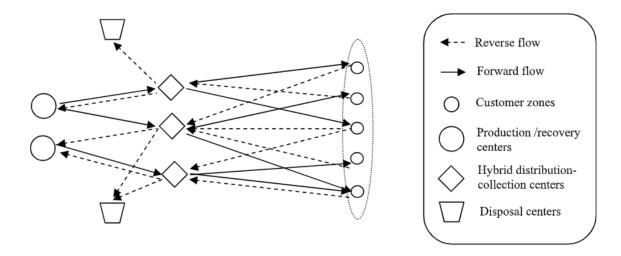


Figure 2.17 Structure of integrated forward/reverse logistics network (Pishvaee, 2009).

Figure 2.17 demonstrates the structure of integrated logistics network. With this strategy, excessive transportation of returned products (especially scrapped products) is prevented and the returned products can be shipped directly to the appropriate facilities (Pishvaee, 2009).

CHAPTER 3

EXPERIMENTAL

3.1 Materials and Equipment

3.1.1 Equipment

a. Computer Desktop model : ASUSTek Computer Inc. Intel® Core™ i7 6700K CPU @4.0GHz, 32 GB of RAM, Windows 10 ©2018 Microsoft Corporation. (64-bit Operating system)

b. Computer laptop model : ASUS TUF fx505GE Intel® Core™ i7-8750H CPU @2.2GHz, 8GB of RAM, Windows 10 ©2018 Microsoft Corporation. (64-bit Operating system)

3.1.2 Softwares

a. Simsci Pro II Version 10.0

b. GAMS

c. Microsoft office excel

3.2 Objectives and Scope of Research Work

3.2.1 Objectives

a. To design conceptual process of ammonia and urea plant with maximum capacity from 1,930 TPD of natural gas feed.

b. To analyze energy consumption of the process and economic feasibility for industrial case.

c. To estimate capital expenditure (CAPEX) and operating expenditure (OPEX) of ammonia and urea plants.

d. To optimize supply chain of ammonia and urea from uncertainty data of markets' demand with stochastic model analysis.

3.2.2 Scope of Research Work

a. This research is focused on assessment of the energy consumption and economic feasibility to achieve the optimum condition with the capacity of 3,000 TPD of ammonia plant and 5,000 TPD of urea plant.

b. The feedstock of the ammonia plant is considered only methane from natural gas.

c. The simulation software Pro II was determined the results in this experiment.

d. The stochastic optimization for supply chain of ammonia and urea will be done.

3.3 Methodology

3.3.1 Simulation for Ammonia and Urea Manufacturing Processes

a. Input flow rate, temperature, pressure, reactions of all streams into process by using Pro II software.

b. Apply more utility units design by Pro II software.

c. Analysis of total energy consumption and economic feasibility for industrial case.

3.3.2 Investment Expenditures of Ammonia and Urea Plants Assessment

a. Calculate capital expenditure (CAPEX) and operating expenditure (OPEX).

b. Calculate net present value and payback period.

c. Profitability analysis.

d. Sensitivity analysis.

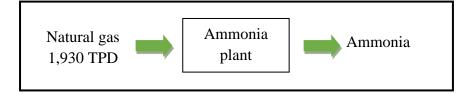
3.3.3 Case Studies

a. Simulation and energy assessment part, there are two cases: 1. Ammonia plant and 2. Urea plant.

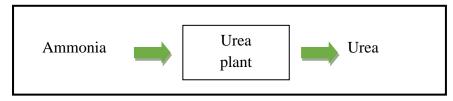
b. Economic feasibility part, there are three cases: 1. ammonia plant, 2. urea plant, and 3. Combination case (ammonia and urea plants).

c. Optimization for transportation part, there are two cases: c1. The stochastic analysis for the supply chain with fixed production rate of ammonia and urea. c2. The stochastic analysis for the supply chain with varied production rate of Ammonia and Urea.

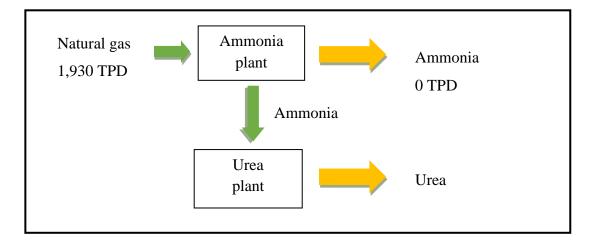
Case 1: Ammonia plant. (Maximum production capacity of ammonia from 1,930 TPD natural gas feed).

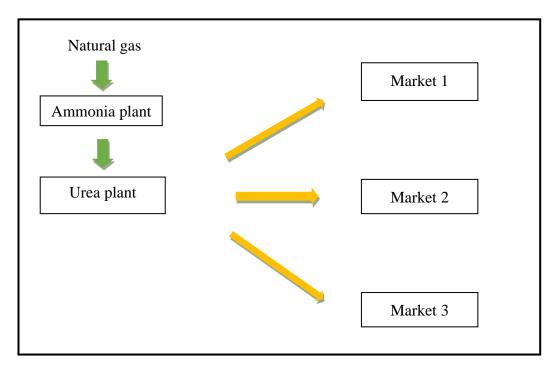


Case 2: Urea plant. (Maximum production capacity of urea from feed of ammonia product in case1)



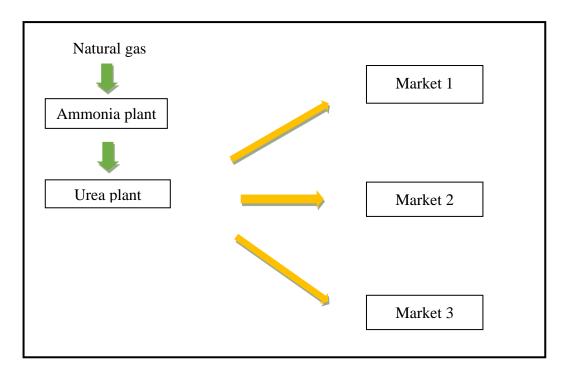
Case 3: Combination case (Maximum production capacity of urea from 1,930 TPD of natural gas feed).





Case c1: Ammonia and Urea plant with improved deterministic and stochastic supply chain optimization under fixed production rate of ammonia and urea.

Case c2: Ammonia and Urea plant with improved deterministic and stochastic supply chain optimization varied production rate of ammonia and urea.



CHAPTER 4 RESULTS AND DISCUSSION

4.1 Properties and Specification for Simulation Processes – Ammonia Plant

This research proposes the ammonia and urea synthesis process by the PROII software to simulate workflow and estimate the energy consumption. The main feedstock of the process is 1,930 ton per day of natural gas. The ammonia production of the conceptual process is 3,870 ton per day. The carbon dioxide eliminated from gas sweetening process is about 5,202 ton per day and consumed in the urea synthesis process about 4,986 ton per day. The properties and specification of natural gas feedstock, steam feed, air feed, and water make up are shown in the table 6.1, 6.2, 6.3, and 6.4, respectively. The ammonia product specifications are shown in the table 6.5. The input data of the conceptual ammonia manufacturing are shown in the table 6.6.

Table 4.1 Compositions of natural gas feed

Natural gas feed		
Component	% mole	
Carbon dioxide	0.028496	
Nitrogen	2.105208	
Methane	97.471142	
Ethane	0.394549	
Propane	0.000605	
Flow rate (ton/day)	1,930	

Condition: Temperature 15.556°C, Pressure 340 psia and Flow rate of 1,930 TPD

Table 4.2 Properties of steam feed

Condition: Temperature 510°C, Pressure 334 psia and Flow rate of 3,224 TPD

	Steam feed
Component	% mole
H ₂ O	100
Flow rate (ton/day)	3,224

Table 4.3 Properties of air feed

Condition: Temperature 25°C, Pressure 180 psia and Flow rate of 7,517 TPD

Air feed		
Component	% mole	
Oxygen	21	
Nitrogen	78.1	
Argon	1	
Flow rate (ton/day)	7,517	

Table 4.4 Properties of water make up

Condition: Temperature 25°C, Pressure 15 psia and Flow rate of 2,852 TPD

Water make up		
Component	% mole	
H ₂ O	100	
Flow rate (ton/day)	3,224	

Table 4.5 Ammonia production specification

	Ammonia product
Ammonia purity (% mole)	99.3%
Flow rate (ton/day)	3,870
Temperature (°C)	-27.04
Pressure (psia)	4,450

Reaction Name	Desulfurization		
Reaction type	Isotl	Isothermal	
Reaction	$ZnO + H_2S \rightarrow ZnS + H_2O$; $\Delta H = -206.30 \text{ kJ/mol}$		
Basis	Flash drum	DESULFER	
Temperature = 393.33 °C	Reaction phases	Vapor	
Pressure = 334 psia	Pressure drop	2 psi	
Reaction Name	Primary	Primary Reforming	
Reaction type	Gibbs	Reactor	
Reaction	$CH_4 + 2H_2O \ \rightarrow \ 4H_2 \ +$	CO ₂ ; $\Delta H = -165.0 \text{ kJ/mol}$	
Basis Reactor No.RX1	Base component	Methane	
Temperature = 880 °C	Reaction phases	Vapor phase	
Pressure = 334 psia			
Reaction Name	Primary Reforming		
Reaction type	Gibbs	Reactor	
Reaction	$CH_4 + H_2O \iff 3H_2 +$	CO; $\Delta H = +206.30 \text{ kJ/mol}$	
Basis Reactor NO.RX1	Base component	Methane	
Temperature = 880 °C	Reaction phases	Vapor phase	
Pressure = 334 psia			
Reaction Name	Secondary Reforming		
Reaction type	Gibbs Reactor		
Reaction	$CO + H_2O \iff CO_2 + H_2; \Delta H = -41.15 \text{ kJ/mol}$		
Basis Reactor No.RX2	Base component	Methane	
Temperature = 1,340 °C	Reaction phases	Vapor phase	
Pressure = 180 psia			

Reaction Name	Secondary Reforming	
Reaction type	Gibbs Reactor	
Reaction	$O_2 + 2CH_4 \rightarrow 2CO + 4H_2$; $\Delta H = -35.98 \text{ kJ/mol}$
Basis Reactor No.RX2	Base component	Methane
Temperature = 1,340 °C	Reaction phases	Vapor phase
Pressure = 180 psia		

High Temperature Shift Conversion	
Equilibrium Reactor	
$CO + H_2O \rightleftharpoons CO_2 + H_2$; $\Delta H = -41.33 \text{ kJ/mol}$	
Base component	Carbon monoxide
Reaction phases	Vapor phase
	$Equilibriu$ $CO + H_2O \Leftrightarrow CO_2 + H_2$ $Base component$

Reaction Name	Low Temperature Shift Conversion		
Reaction type	Equilibrium Reactor		
Reaction	$CO + H_2O \rightleftharpoons CO_2 + H_2$; $\Delta H = -41.33 \text{ kJ/mol}$		
Basis Reactor No. LTSR	Base component	Carbon monoxide	
Temperature = 80 °C	Reaction phases	Vapor phase	
Pressure = 176 psia			

Reaction Name	Ammonia Conversion		
Reaction type	Equilibrium Reactor		
Reaction	$N_2 + 3H_2 \iff 2NH_3$; $\Delta H = -92 \text{ kJ/mol}$		
Basis Reactor No. RX3	Base component	Hydrogen	
Temperature = 336 °C	Reaction phases	Vapor phase	
Pressure = 4,470 psia	Equilibrium data	A = -32.975	
		B = 22930.4	
		(Pro II data base)	

4.2 Process Flow Diagram – Case 1 Ammonia Manufacturing Process

Natural gas, temperature 15°C pressure 340 psia and flow rate of 1,930 ton per day, was fed into the process simulation. The ammonia manufacturing process from the software has 3,870 ton per day productivity of Ammonia. The process is divided into 4 stage: 1. Catalytic reforming stage, 2. Shift conversion and sweetening stage, 3. Compression stage, and 4. Conversion stage. The product specifications are temperature -27 °C, pressure 4,470 psia and purity of 99.90 %. This simulation had been developed by Commercial software Pro II program version 10.0 which was used in ammonia manufacturing process. SRK thermodynamic model was used to achieve the ammonia specification product more accurately.

4.2.1 <u>A Conceptual Design of Ammonia Production – Stage 1 Catalytic</u> <u>Reforming</u>

Catalytic reforming is a chemical synthesis for product syngas (hydrogen and carbon monoxide) from natural gas and steam. The purpose of catalytic reforming is to produce hydrogen. The catalytic reforming in the simulation has consist of 2 main reaction; primary reforming and secondary reforming. The primary reformer, methane is combined with steam to be reformed to hydrogen and carbon monoxide including carbon dioxide is occurred. In the secondary stream reformer, hot air is added. The catalytic reforming stage is illustrated in Figure 4.1.

4.2.2 <u>A Conceptual Design of Ammonia Production – Stage 2 Shift</u> <u>Conversion and Gas Sweetening</u>

Shift conversion or water gas shift reaction is a reaction of carbon monoxide and water vapor to from hydrogen and carbon dioxide. Shift conversion has 2 section; High temperature shift reaction (HTSR) and Low temperature shift reaction (LTSR). Afterward, these gases are sent to sweetening section to remove carbon dioxide from the stream. In the sweetening section, AMINE01 thermodynamic model from the software was used to achieve the specification product more accurately. The specification of this section is to control operating condition to reach 0.2-0.5mol% CO and 0.005-0.2% CO₂. The removal carbon dioxide then be sent to the Urea

manufacturing process. The shift conversion and gas sweetening stage is shown in Figure 4.2.

4.2.3 <u>A Conceptual Design of Ammonia Production - Stage 3 Compression</u>

The purified synthesis gas is compressed in a three stages unit to achieve the proper pressure to produce ammonia in the next stage. Very high pressure, about 4,400 psia, is required to produce ammonia. The aftercooler is installed to control raising temperature from compression stage. The compression stage is represented in Figure 4.3.

4.2.4 A Conceptual Design of Ammonia Production - Stage 4 Conversion

The conversion stage is a reaction of hydrogen and nitrogen with high pressure to from ammonia. From stoichiometry, 3 mole of hydrogen and 1 mole of nitrogen are mixed to from 2 mole of ammonia. The specifications of the product from simulation are 3,870 ton per day of flow rate with 99.90 % purity, -27 °C of temperature, and 4,450 psia of pressure. The ammonia conversion stage is represented in Figure 4.4.



49

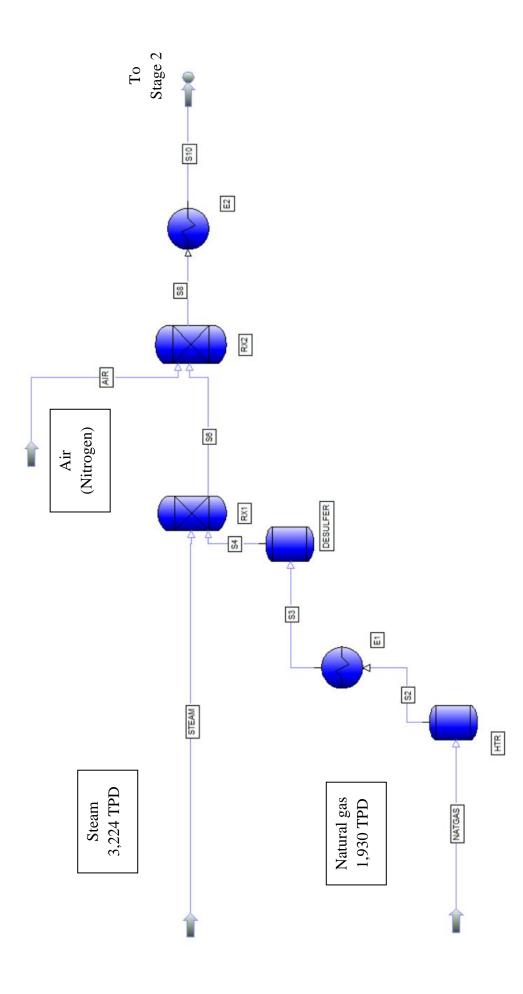


Figure 4.1 The simulation of ammonia production – stage 1 Catalytic reforming.

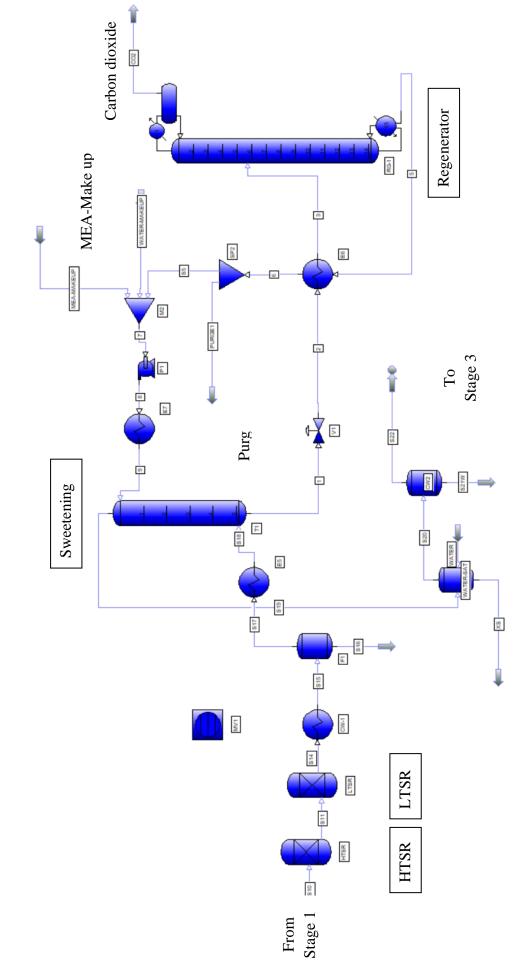


Figure 4.2 The simulation of ammonia production – stage 2 shift conversion and gas sweetening.

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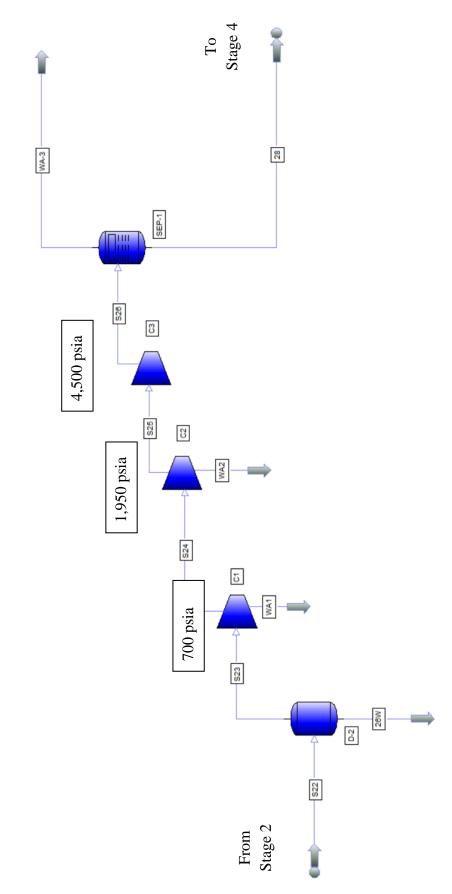
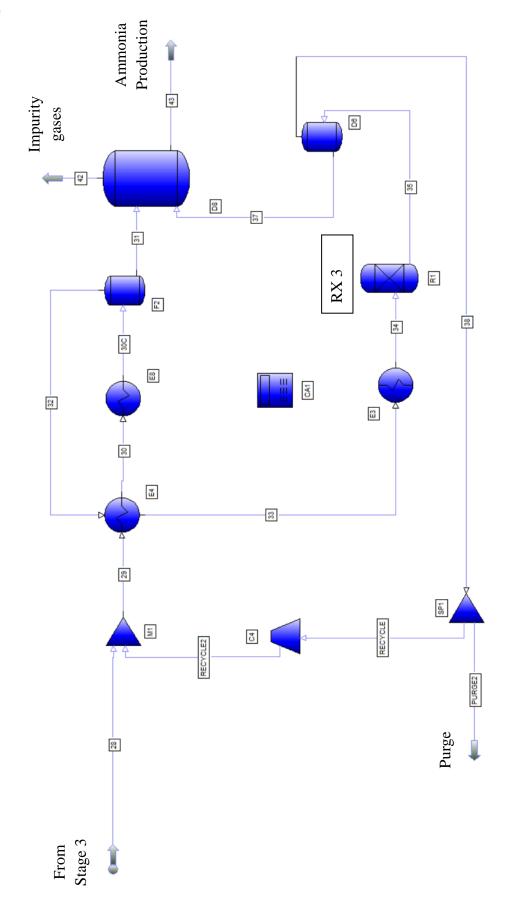


Figure 4.3 The simulation of ammonia production – stage 3 compression.





52

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4.3 Energy Consumption Analysis – Ammonia Manufacturing Process

The ammonia manufacturing process, stage 1 is Catalytic reforming. This stage consists of 5 units. The hot utility consumes energy about 8.7184 x 10^7 kJ/hr. The cold utilities consume energy of 1.0504 x 10⁹ kJ/hr. Stage 2 is Catalytic shift and gas sweetening. This stage consists of 15 units. The hot utilities consume energy about 1.9088 x 10^9 kJ/hr. The cold utilities consume energy about 2.1646 x 10^9 kJ/hr. Stage 3 is Compression. This stage consists of 5 units and there is no energy consumption of hot utilities. The cold utilities consume energy about 3.4445×10^8 kJ/hr. The shaft work from compressor is about 9.49 x 10⁴ kW. Stage 4 is Ammonia conversion. This stage consists of 10 units. The hot utilities consume energy about 2.4292 x 10^8 kJ/hr. The refrigerant utilities consume energy about 9.2539 x 10^8 kJ/hr. The Urea synthesis process consists of 21 units. The hot utilities consume energy of 3.6204×10^8 kJ/hr. The cold utilities consume energy about 4.6607×10^8 kJ/hr. The shaft work is about 8.49 x 10⁴ kW. For ammonia manufacturing process, total energy consumption in stage 1 catalytic reforming, stage 2 shift conversion and gas sweetening, stage 3 compression, and stage 4 ammonia conversion are shown in the figure 29, 30, 31, and 32 respectively.

Table 4.7 Overall energy consumption for ammonia manufacturing process

Stage	Energy Consumption (MMKJ/HR)
Stage-1 Catalytic Reforming	1137.647
Stage-2 Shift conversion and gas sweetening	934.57
Stage-3 Compression	344.45
Stage-4 Ammonia Conversion	1168.31
Summary	3584.977



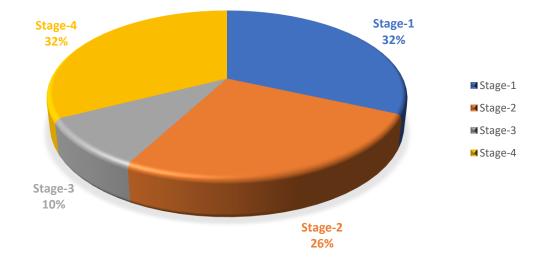


Figure 4.5 Overall energy consumption of ammonia manufacturing process.

Unit	Hot (MMKJ/HR)	Cold (MMKJ/HR)
Flash Drum 'HTR'	1.6881	
UNIT 8, 'E1'	85.496	
Flash Drum 'DESULFER'		1.53926
UNIT 1, 'RX1', 'Primary		
Reformer'		
UNIT 11, 'RX2', 'Sec	9.21E-09	
Reformer'		
UNIT 12, 'E2', 'Cool Reformed		1048.924
Gas'		
Summery	87.1841	1050.463

Table 4.8 Energy consumption of ammonia production in stage 1

ENERGY CONSUMPTION OF AMMONIA PRODUCTION IN STAGE 1

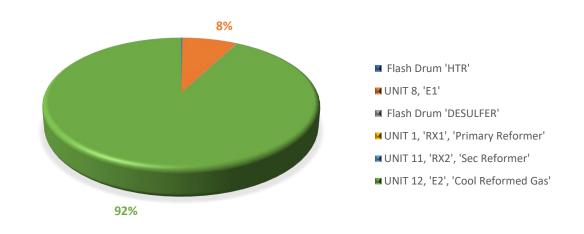


Figure 4.6 Energy consumption of ammonia process in stage 1.

Unit	Hot (MMKJ/HR)	Cold (MMKJ/HR)
UNIT 2, 'Hight Temp Shift RX'		369.3353
UNIT 5, 'Low Temp Shift RX'		108.838

 Table 4.9 Energy consumption of ammonia production in stage 2

UNIT 2, 'Hight Temp Shift RX'		369.3353
UNIT 5, 'Low Temp Shift RX'		108.838
UNIT 10, 'CW-1'		100.286
UNIT 6, 'E5'	7.359	
UNIT 31, 'E6'	247.78	
Rigorous Column 'RG-1',	165.37	104.47
'Regenerator'		
Pump 'P1'	Shaft work	Shaft work
UNIT 36, 'E7'		541.423
Summery	420.509	1224.352

ENERGY CONSUMPTION OF AMMONIA PROCESS IN STAGE 2

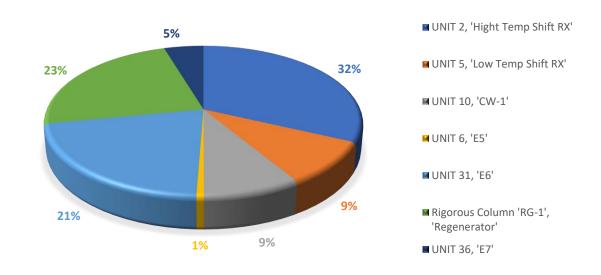


Figure 4.7 Energy consumption of ammonia process in stage 2.

Table 4.10 Energy	consumption of ammonia	production in stage 3
		F

Unit	Cold (MMKJ/HR)	Shaft work (HP)
UNIT 16, 'C1'	198.29	73049.46
UNIT 19, 'C2'	80.57	29426.79
UNIT 20, 'C3'	65.59	24837.57
Summary	344.45	127313.8

ENERGY CONSUMPTION OF AMMONIA PROCESS IN STAGE 3

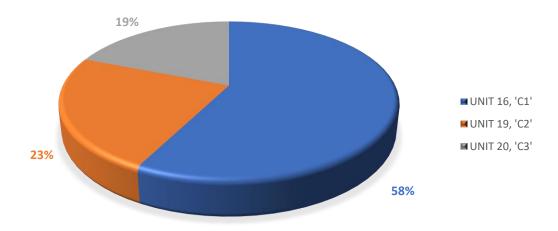


Figure 4.8 Energy consumption of ammonia process in stage 3.

Unit	Hot (MMKJ/HR)	Cold Refrigerant (MMKJ/HR)
UNIT 22, 'E4'	13.31	
UNIT 38, 'E8		2.416
UNIT 26, 'E3'	229.601	
UNIT 29, 'RX3'	4.35E-03	
Flash Drum 'D6', 'Pri Sep'		922.9744
UNIT 27, 'C4'	Shaft work	Shaft work
Summery	242.9154	925.3904

 Table 4.11 Energy consumption of ammonia production in stage 4

ENERGY CONSUMPTION OF AMMONIA PROCESS IN STAGE 4

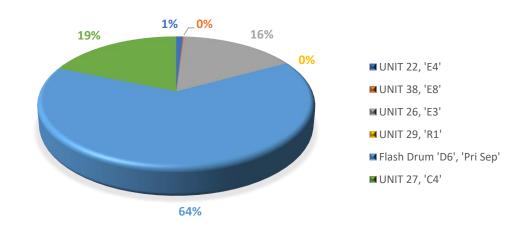


Figure 4.9 Energy consumption of ammonia process in stage 4.

4.4 Properties and Specification for Simulation Processes – Urea Plant

For case 2 – Urea manufacturing process, the urea production of the conceptual process is 3,870 ton per day. The carbon dioxide that be eliminated from gas sweetening process is 5,202 ton per day and will be consumed in this process about 5,046 ton per day. The properties and specification of ammonia and carbon dioxide feedstock are shown in the table 1 and 2. The urea product specifications are shown in the table 5. The input data of the conceptual urea manufacturing are shown in the table 6.

 Table 4.12 Ammonia feed for urea manufacturing process

Ammonia feed sto	ck specification	
Ammonia purity (% mole)	99.90%	
Flow rate (ton/day)	3,870	
Temperature (°C)	-33.33	
Pressure (psia)	320	

Table 4.13 Carbon dioxide feed for urea manufacturing process

Carbon dioxide feed stor	ck specification	
Carbon dioxide purity (% mole)	100%	
Flow rate (ton/day)	5,046	
Temperature (°C)	37.78	
Pressure (psia)	300	

Urea produ	ct specification
Urea purity (% mole)	99.90%
Flow rate (ton/day)	5,472
Temperature (°C)	93.33
Pressure (psia)	-

Table 4.15 Input data of urea process

Reaction Name	Urea s	ynthesis 1
Reaction type	Con	version
Reaction	$8NH_3 + 4CO_2 \rightleftharpoons 3 CH4N$	$2O2+ 3H_2O + NH_2COONH_4$
Basis Reactor No. RX4	Base component	Carbon dioxide
Temperature = 180 °C	Reaction phases	Vapor phase
Pressure = 15 psia		
Reaction Name	High pressu	re decomposer
Reaction type	Con	version
Reaction	$NH_2COONH_4 \rightleftharpoons 2NH_3 + C$	CO_2
Basis Reactor No. RX5	Base component	Ammonium Carbamate
Temperature = 180 °C	Reaction phases	Vapor phase
Pressure = 600 psia	Reaction phases vapor phase	
Reaction Name	Low pressu	re decomposer
Reaction type	Low pressure decomposer Conversion	
Reaction	$NH_2COONH_4 \rightleftharpoons 2NH_3 + C$	
Basis Reactor No. RX6	Base component	Ammonium Carbamate
Temperature = 120 °C	Reaction phases	Vapor phase
Pressure = 300 psia		

4.5 Process Flow Diagram – Case 2 Urea Manufacturing Process

Ammonia, temperature -33°C pressure 320 psia and flow rate of 3,870 ton per day, was fed into the process simulation to mix with Carbon dioxide, temperature 37°C pressure 300 psia and flow rate of 5,046 ton per day. The urea manufacturing process from the software has 5,472 ton per day productivity of urea. The product specifications are temperature 93°C, Solid state and purity of 99.90%. This simulation had been developed by Commercial software Pro II program version 10.0 which was used in urea manufacturing process. NRTL01 thermodynamic model was used to achieve the urea specification product more accurately.

The urea plants are capable of processing 5,472 ton per day. There have 3 main reactors in the process simulation: Urea synthesis reactor, high-pressure decomposer, and low-pressure decomposer. This process is to convert carbon dioxide and synthetic ammonia with high pressure reacted to form into urea which is shown in Figure 4.10.

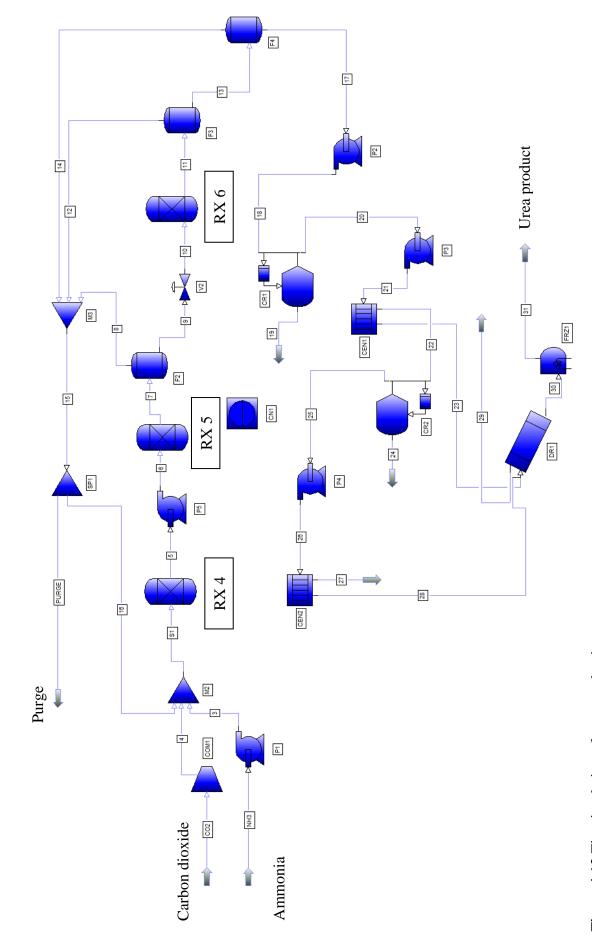


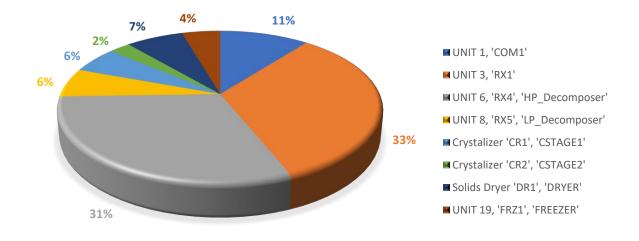
Figure 4.10 The simulation of urea production.

4.6 Energy Consumption Analysis – Urea Manufacturing Process

The Urea synthesis process consists of 21 units. The hot utilities consume energy about 4.28 x 10^8 kJ/hr. The cold utilities consume energy about 4.93 x 10^8 kJ/hr. The shaft work is about 8.49 x 10^4 kW.

Table 4.16 Energy consumption of urea production

Unit	Hot (MMKJ/HR)	Cold (MMKJ/HR)	Shaft work (HP)
UNIT 1, 'COM1'		113.07	4,2120.6
Pump 'P1'			2,238.42
UNIT 3, 'RX4'		295.3946	
Pump 'P5'			8,3334.51
UNIT 6, 'RX4', 'HP_Decomposer'	288.4287		
UNIT 8, 'RX5', 'LP_Decomposer'		41.1598	
Pump 'P2', 'PUMP2'			4.11
Crystalizer 'CR1', 'CSTAGE1'	55.9019		
Pump 'P3', 'PUMP3'			3.2
Crystalizer 'CR2', 'CSTAGE2'	18.2524		
Pump 'P4', 'PUMP4'			1.29
Solids Dryer 'DR1', 'DRYER'	65.16		
UNIT 19, 'FRZ1', 'FREEZER'		43.3824	
Summery	427.743	493.0068	127702



ENERGY CONSUMPTION OF UREA MANUFACTURING PROCESS

Figure 4.11 Energy consumption of urea process.

4.7 Techno Economic Analysis of the Manufacturing Process

Techno Economic Analysis is to estimate cost of investment and the profitability of project. This cost assessment technique represents the capital expenditure, the operating expenditure, net present value, pay-back period, and return of investment. There are 3 main parts to estimate total investment cost of the project which are

4.7.1 Fixed Capital Cost

This cost includes mainly purchasing process equipment. This cost associates with constructing the plant and includes the raw material costs.

4.7.1.1 Direct Manufacturing Expenditure

Manufacturing fixed capital investment consisted of site preparation, piping, instrument, process equipment, raw material cost, auxiliary facilities, admin office, warehouses, lab, transportation, shipping, utilities, waste disposal facilities.

4.7.1.2 Indirect Manufacturing Expenditure

Expenses which are not directly involved with material and labour e.g. engineering, supervision, legal expenses, maintenance and repair, local taxes, and insurance.

4.7.2 Working Capital Investment

This cost includes mainly raw materials and supplies, finished product in stock, operating expenses, and taxes. It can be calculated by 15% of fixed capital cost.

4.7.3 Depreciable Investment

Generally, this cost includes all property (Physical facilities, including design and engineering, shipping, and field erection except land) with a limited useful life of more than 1 year. It can be calculated by 10% of fixed capital cost.

66

Typical process utilities including process steam, electricity, refrigerants, compression air, cooling water, hot oil, process water. For preliminary cost estimation can be treated like utility expense. The two-factor utility cost equation are needed such as the following: and the utilities cost coefficients are represented in table 4.17

$$C_{s,u} = a (CEPCI) + b (C_{s,f})$$
(6.1)

Where $C_{s,u}$ is the price of the utility, a and b are utility cost coefficients $C_{s,f}$ is the price of fuel in \$/GJ, and CEPCI is an inflation parameter for projects in the U.S.^{*} * Evaluated monthly by the staff of Chemical Engineering

Utility type	Cost coef	ficient
	a	b
Onsite power charged to grass-	1.1×10^{-4}	0.010
roots plant		
Hot water for process steam (Qh	$6.0 \times 10^{-7} \mathrm{Qh}^{-0.9} \mathrm{(T)}^{0.5}$	$6.0 \times 10^{-8} \mathrm{T}^{0.5}$
is total heat capacity in kJ/s, T is		
absolute temperature)		
Cooling Water (q is water	$0.00007 + 2.5 \times 10^{-5} q^{-1}$	0.003
capacity in m ³ /s)		
Refrigerant (Qc is total cooling	$0.5Qc^{-0.9}(T^{-3})$	$1.1 \times 10^{6} \mathrm{T}^{-5}$
capacity in kJ/s, T is absolute		
temperature)		

Table 4.17 Utility co	st coefficient with 470) of CEPCI and 7.2 of $C_{s,f}$
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4.7.4 Expenditure Assessment for Ammonia and Urea Processes

The ammonia manufacturing process or detail on total expenditure are consist of 3 main of utilities cost: 1. Hot water for heat transfer media in the process, 2. Cooling water for cooling temperature of each equipment, and 3. Refrigerant for liquefy ammonia in the process. The details are represented in Table 4.18 2619937106 CU iThesis 6173002063 thesis / recv: 20072563 10:48:08 / seq: 18

Table 4.18 Expenditure assessment for ammonia manufacturing process

Unit		Energy C	Energy Consumption type		Cost (\$/year)
	Hot (MM kJ/hr)	Cool (MM kj/hr)	Shaft work (HP)	Refrigerant (MM kJ/hr)	
Stage-1 Catalytic Reforming					
Flash Drum 'HTR'	1.6881	1			157,105
UNIT 8, 'E1'	85.496	1	1		7,956,763
Flash Drum 'DESULFER'	ı	1.53926	1		7,043
UNIT 11, 'RX2', 'Sec Reformer'	9.21E-09	1			8.57E-04
UNIT 12, 'E2', 'Cool Reformed Gas'	ı	1048.924	1		4,799,657
Stage-2 Shift Conversion					
UNIT 2, 'Hight Temp Shift RX'	I	369.3353	ı	ı	1,690,001
UNIT 5, 'Low Temp Shift RX'	I	108.838	ı	1	498,020
UNIT 10, 'CW-1'	ı	100.286			458,888
UNIT 6, 'E5'	7.359	1			684,872
UNIT 31, 'E6'	24.78	1			2,330,446
Rigorous Column 'RG-1',	165.37	104.47		1	16,031,241
Pump 'P1'			37.722	,	30,481
UNIT 36, 'E7'	I	54.142	I	1	247,744

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 Table 4.18 Expenditure assessment for Ammonia manufacturing process (Continue)

Unit		Energy Co	Energy Consumption type		Cost (\$/year)
	Hot (MM kJ/hr)	Cool (MM kj/hr)	Shaft work (HP)	Refrigerant (MM kJ/hr)	
Stage-3 Compression					
UNIT 16, 'C1'	1	198.29	73049.46	1	59,027,567
UNIT 19, 'C2'	1	80.57	29426.79	1	23,778,298
UNIT 20, 'C3'	1	65.59	24837.57	1	20,069,982
Stage-4 Ammonia Conversion					
UNIT 22, 'E4'	13.31	1	1	1	1,238,707
UNIT 38, 'E8'	1	1	1	2.416	186,064
UNIT 26, 'E3'	229.601	1	I	1	21,368,025
UNIT 29, 'R1'	4.35E-03	1	1	1	405
Flash Drum 'D6', 'Pri Sep'	1	1	1	922.9744	71,081,132
UNIT 27, 'C4'	1	1	269.4	1	217,688
Summarizes					231,860,129
	7				

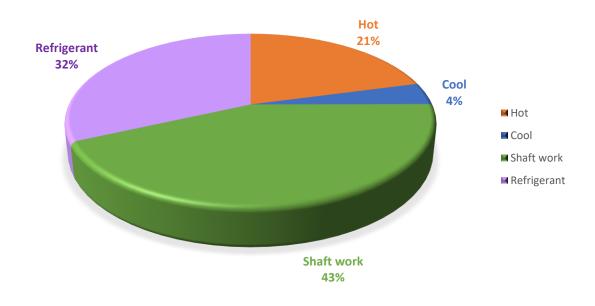
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Table 4.19 Expenditure assessment for urea manufacturing process from 3,870 TPD ammonia feed

Unit		Energy Co	Energy Consumption type		Cost (\$/year)
	Hot (MM kJ/hr)	Cool (MM kj/hr)	Shaft work (HP)	Refrigerant (MM kJ/hr)	
Urea conversion					
UNIT 1, 'COM1'	1	113.07	42120.6		34,552,907
Pump 'P1'	1	1	2283.42		1,845,116
UNIT 3, 'RX1'	1	295.3946	1		1,351,664
Pump 'P5'	-	1	83334.51		67,338,395
UNIT 6, 'RX4', 'HP_Decomposer'	288.4287	1	1	1	26,842,879
UNIT 8, 'RX3', 'LP_Decomposer'	1	41.1598	1	1	188,339
Pump 'P2', 'PUMP2'	1	1	4.11		3,321
Crystalizer 'CR1', 'CSTAGE1'	65.4908	1	ı	1	6,094,961
Pump 'P3', 'PUMP3'	1	1	3.2	1	2,586
Crystallizer 'CR2', 'CSTAGE2'	18.2524	1	ı		1,698,676
Pump 'P4', 'PUMP4'		1	1.29		1,042
Solids Dryer 'DR1', 'DRYER'	65.16	1	ı		6,064,174
UNIT 19, 'FRZ1', 'FREEZER'		43.3824			198,509
Summarizes					146,182,569
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69



EXPENDITURE OF AMMONIA PROCESS UTILITIES (\$/YEAR)

Figure 4.12 Expenditure of ammonia process divided by utility type.

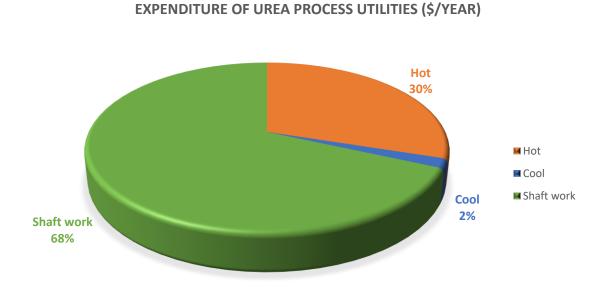


Figure 4. 13 Expenditure of urea process divided by utility type.

Unit	Purchased Cost (\$)
Reactors (10)	15,991,253
Flash drum (11)	1,432,874
Distillation column (2)	38,854
Centrifugal Pump (6)	79,536
Centrifugal Compressor (5)	6,180,612
Fired Heated	19,013,389.14
Summarizes	42,736,518.3

Table 4.21 Detail total expenditure for ammonia and urea manufacturing

Components	%	Cost (\$)
Direct cost	I I	
Purchased equipment installation	47	20,086,164
Instrumentation (installed)	12	5,128,382
Piping (installed)	66	28,206,102
Electrical (installed)	11	4,701,017
Building (including Service)	18	7,692,573
Yard improvement	10	4,273,652
Service facilities	70	29,915,563
Land	6	2,564,191
Total direct cost		145,304,162
Indirect cost		
Engineering and supervision	33	14,103,051
Construction Expenses	41	17,521,973
Total Indirect Cost		31,625,024
Total Direct & Indirect Cost		176,929,186
Contractor's fee	5	8,846,459
Contingency	10	17,692,919
Fixed Capital Investment		203,468,564
Working Capital investment	15	30,520,285
Total Capital Investment (CAPEX)		233,988,848

Base year	2019
Plant lifetime	10 years
Operating hour per year (h)	8760
Annual Ammonia Capacity (ton)	1,412,550
Ammonia price (\$/ton)	206
Annual Urea Capacity (ton)	1,997,280
Urea price (\$/ton)	288
CAPEX (\$)	233,988,848
Interest rate (%)	10
Payback period (y)	5.4
Net present value (\$)	197,175,232

 Table 4.22 Key assumptions used to develop the techno-economic model

Ammonia product from the case-1 can be as the substrate for the urea process by mixing with carbon dioxide and react at high temperature. The expenditure of urea process be varied with the energy consumption that be changed with the amount of feedstock. For being economical, correlation between ammonia and urea manufacturing process will be considered. The maximum capacity of ammonia manufacturing is 3,870 TPD which feed for substrate in urea process. It can be distributed into 11 operating scenarios by 10 % reducing amount of ammonia feed to urea process as shown in table 4.23.

 Table 4.23 Correlation between ammonia feed to urea product

Scenario	Ammonia Feed	Urea	Ammonia	Urea
No.	to urea process	Production	Production	Expenditure
	(Ton/day)	(Ton/day)	(Ton/day)	(\$/day)
1	3,870	5,472	0	400,500
2	3,483	4,925	387	360,435
3	3,096	4,378	774	320,390
4	2,707	3,831	1,161	280,339
5	2,322	3,283	1,548	240,293
6	1,935	2,736	1,935	200,243
7	1,548	2,189	2,322	160,193
8	1,161	1,642	2,707	120,145
9	774	1,094	3,096	80,097
10	387	547	3,483	40,048
11	0	0	3,870	0

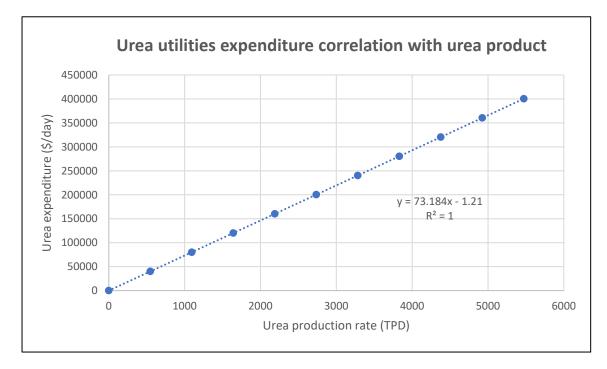


Figure 4.15 Urea utilities expenditure correlation with urea product.

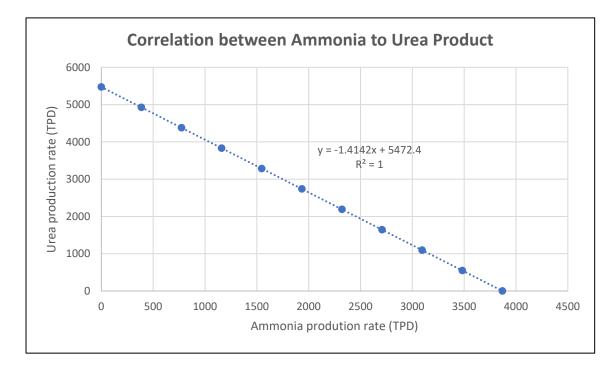


Figure 4.14 Correlation between ammonia to urea product.

4.8 Investigation on Optimization of Market Demand (with Fixed Production Capacity of Ammonia and Urea)

The supply chain can be defined as the flow of materials or information from basic commodities or raw materials to final products for end-customer through many processes that are linked together to chain. In this first case study, the network has with 2 echelons; Plant (i) with 2 products (ammonia and urea), and Market (j) with 2 products (ammonia and urea). The mathematical model for designing the network is expressed as show below.

$$Max Z = Price_{Amm} * \Sigma_i \Sigma_j X_{ij} + Price_{Urea} \Sigma_i \Sigma_j Y_{ij} - [Cost1 + Cost2 + Cost3]$$
(6.1)

Subject to constraints,

$$\Sigma_{j}X_{ij} = \text{LimCapAmm}_{i} \tag{6.2}$$

$$\Sigma_{j} Y_{ij} = \text{LimCapUrea}_{i}$$
(6.3)

$$\Sigma_{i}X_{j} + \Sigma_{i}PenaltyAmm_{ij} - PPAmm_{j} = LimAmm_{j} (Demand)$$
(6.4)

$$\Sigma_i Y_{ij} + \Sigma_i Penalty Urea_{ij} - PPUrea_j = LimUrea_j (Demand)$$
 (6.5)

$$Cost1 = 795470$$
 (6.6)

$$Cost2 = (\Sigma_i \Sigma_j X_{ij} + \Sigma_i \Sigma_j Y_{ij})^* \text{ transportcost}$$
(6.7)

$$Cost3 = \Sigma_i \Sigma_j PenaltyAmm_{ij} * PAmmCost + \Sigma_i \Sigma_j PPAmm_j * PPAmmCost +$$

 $\Sigma_i \Sigma_j$ PenaltyUrea_{ij} * PUreaCost + $\Sigma_i \Sigma_j$ PPUrea_j * PPUreaCost (6.8)

Where

 X_{ij} = Ammonia transportation amount (TPD)

 Y_{ij} = Urea transportation amount (TPD)

LimCapAmm_i = Ammonia production capacity of plant i in cases (TPD) LimCapUrea_i = Urea production capacity of plant i in cases (TPD) PenaltyAmm_{ij} = Ammonia amount which less than demand of market (TPD) PenaltyUrea_{ij} = Urea amount which less than demand of market (TPD) PPAmm_j = Ammonia amount which greater than demand of market (TPD) PPUrea_j = Urea amount which greater than demand of market (TPD)
$$\begin{split} \text{LimAmm}_{j} (\text{Demand}) &= \text{Ammonia demand of market j in cases (TPD)} \\ \text{LimUrea}_{j} (\text{Demand}) &= \text{Urea demand of market j in cases (TPD)} \\ \text{Opportunity loss cost} &= \Sigma_{i}\Sigma_{j} \text{PenaltyAmm}_{ij} * \text{PAmmCost ($/day)} \\ \text{Surplus Production cost} &= \Sigma_{i}\Sigma_{j} \text{PPAmm }_{j} * \text{PPAmmCost ($/day)} \\ \text{Cost1} &= \text{Ammonia and urea production cost at urea production rate 2,322 TPD} \\ & ($/day) \\ \text{Cost2} &= \text{transportation cost ($/day)} \\ \text{Cost3} &= \text{Penalty cost ($/day)} \end{split}$$

The main objective of this model is to maximize profit from sale products. The objective function is expressed into 3 parts; revenue, transportation cost, and penalty cost as shown in equation 6.1. The penalty cost is opportunity loss that the products are lower than demand of the market and cannot be sold. Equation 6.2 and 6.3 are deal with maximum capacity of plant in ammonia product and urea product, respectively. Equation 6.4 and 6.5 are deal with minimum demand of the market in ammonia product and urea product, respectively. The market's demand data was assumed as a historical for optimized programming by using normal distribution of mean and standard derivation as shown in figure 4.18.

The case study for deterministic and stochastic models use historical demand data of 30 days. The simple supply chain network with 2 echelons; Plant (i) and Market (j) with 2 products (ammonia and urea) is shown in figure 4.16.

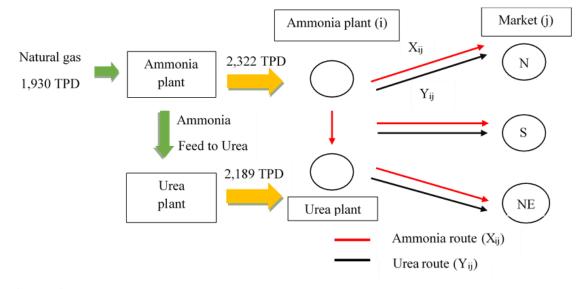
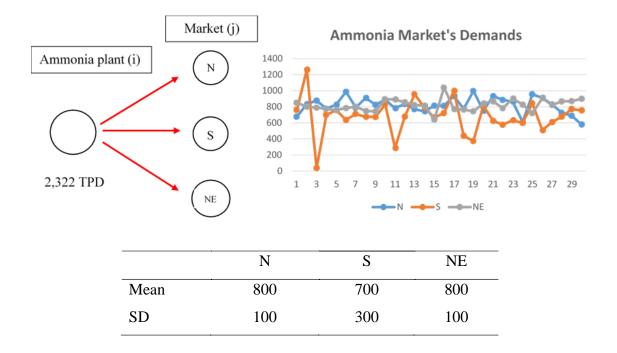


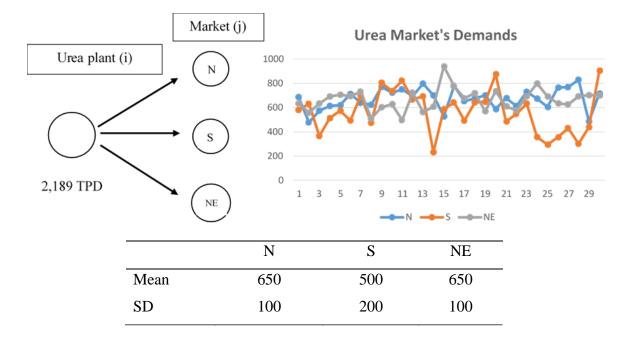
Figure 4.16 The simple supply chain network diagram.

Table 4.24 The data related to the network

Market	Distance (miles)				
N	531				
S	684				
NE	208				
Product sale price*	(\$/ton)				
Ammonia	206 (Yuzhny)				
Urea	288 (granular Indonesia/Malaysia)				
Transportation cost (\$/ton/miles)	0.05				
Opportunity loss (\$/unit)	50% of product selling price				
Surplus Production Cost (\$/unit)	25% of product selling price				
*Source; AfricaFertilizer.org FOB International Fertilizer Prices – updated at					

December 2019 (price data from Jul-19)





Ammonia and urea capacity are from correlation function: y = -1.4142x + 5472.4

Figure 4. 17 Ammonia and urea demands of each market.

Table 4.25 The result of supply chains model network – fixed production capacity of ammonia and urea

Supply chain No.X	Market (j) (TPD)		Penalty	Transportation	Profit Z	
using product demand of	N (j1)	S (j2)	NE (j3)	cost (\$)	cost (\$)	cost (\$)
No.1 using demand of day 1				22,312	100,906	190,076
Ammonia Demand	677	762	851			
Ammonia shipping amount (x)	677	762	801	1,648	53,218	
Urea Demand	687	581	634			
Urea shipping amount (y)	687	581	921	20,664	47,688	
No.2 using demand of day 2				96,737	99,495	117,062
Ammonia Demand	834	1,262	801			
Ammonia shipping amount (x)	834	687	801	59,225	53,969	
Urea Demand	478	632	558			
Urea shipping amount (y)	478	632	1,079	37,512	45,527	
No.3 using demand of day 3				75,932	79,996	157,366
Ammonia Demand	878	38	790			
Ammonia shipping amount (x)	878	38	1,406	31,724	39,233	
Urea Demand	575	366	634			
Urea shipping amount (y)	575	366	1,248	44,208	40,763	
No.4 using demand of day 4				30,348	98,248	184,698
Ammonia Demand	777	700	773			
Ammonia shipping amount (x)	777	700	845	3,708	53,357	
Urea Demand	614	513	692			
Urea shipping amount (y)	614	513	1,062	26,640	44,891	
No.5 using demand of day 5				23,033	101,494	188,767
Ammonia Demand	828	758	759			
Ammonia shipping amount (x)	828	735	759	2,369	55,014	
Urea Demand	621	575	706			
Urea shipping amount (y)	621	575	993	20,664	46,480	

Table 4.25 The result of supply chains model network – fixed production capacity of ammonia and urea (Continue)

Supply chain No.X	Ma	rket (j) (TPD)	Penalty	Transportation	Profit Z
using product demand of	N (j1)	S (j2)	NE (j3)	cost (\$)	cost (\$)	(\$)
No.6 using demand of day 6				29,594	99,224	184,476
Ammonia Demand	987	637	784			
Ammonia shipping amount (x)	987	551	784	8,858	53,203	
Urea Demand	712	494	695			
Urea shipping amount (y)	712	494	983	20,736	46,022	
No.7 using demand of day 7				9,382	103,638	200,274
Ammonia Demand	790	711	801			
Ammonia shipping amount (x)	790	711	821	1,030	53,829	
Urea Demand	640	702	731			
Urea shipping amount (y)	640	702	847	8,352	49,809	
No.8 using demand of day 8				42,996	98,773	171,525
Ammonia Demand	911	675	748			
Ammonia shipping amount (x)	911	663	748	1,236	54,641	
Urea Demand	623	475	511			
Urea shipping amount (y)	623	475	1,091	41,760	44,132	
No.9 using demand of day 9				4,768	107,890	200,636
Ammonia Demand	825	674	743			
Ammonia shipping amount (x)	825	674	823	4,120	53,514	
Urea Demand	771	805	604			
Urea shipping amount (y)	771	805	613	648	54,376	
No.10 using demand of day 10				37,142	103,301	172,851
Ammonia Demand	888	829	895			
Ammonia shipping amount (x)	888	539	895	29,870	51,318	
Urea Demand	723	737	628			
Urea shipping amount (y)	723	737	729	7,272	51,983	

Table 4.25 The result of supply chains model network – fixed production capacity of ammonia and urea (Continue)

Supply chain No.X	Ma	rket (j) (TPD)	Penalty	Transportation	Profit Z
using product demand of	N (j1)	S (j2)	NE (j3)	cost (\$)	cost (\$)	(\$)
No.11 using demand of day 11				27,160	98,098	188,037
Ammonia Demand	782	288	891			
Ammonia shipping amount (x)	782	288	1,252	18,592	43,633	
Urea Demand	750	823	497			
Urea shipping amount (y)	750	823	616	8,568	54,466	
No.12 using demand of day 12				12,741	102,469	198,084
Ammonia Demand	836	680	857			
Ammonia shipping amount (x)	836	680	857	5,253	52,620	
Urea Demand	694	667	724			
Urea shipping amount (y)	694	667	828	7,488	49,848	
No.13 using demand of day 13				32,926	106,105	174,263
Ammonia Demand	770	956	822			
Ammonia shipping amount (x)	770	730	822	23,278	53,958	
Urea Demand	798	693	564			
Urea shipping amount (y)	798	693	698	9,648	52,147	
No.14 using demand of day 14				49,612	93,916	169,766
Ammonia Demand	743	791	816			
Ammonia shipping amount (x)	743	763	816	2,884	54,308	
Urea Demand	701	232	607			
Urea shipping amount (y)	701	232	1,256	46,728	39,608	
No.15 using demand of day 15				19,773	98,473	195,048
Ammonia Demand	815	667	642			
Ammonia shipping amount (x)	815	667	840	10,197	53,186	
Urea Demand	528	588	940			
Urea shipping amount (y)	528	588	1,073	9,576	45,287	

Table 4.25 The result of supply chains model network – fixed production capacity of ammonia and urea (Continue)

Supply chain No.X	Ma	rket (j) (TPD)	Penalty	Transportation	Profit Z
using product demand of	N (j1)	S (j2)	NE (j3)	cost (\$)	cost (\$)	(\$)
No.16 using demand of day 16				27,396	98,860	187,038
Ammonia Demand	812	722	1,040			
Ammonia shipping amount (x)	812	470	1,040	25,956	48,449	
Urea Demand	779	643	777			
Urea shipping amount (y)	779	633	777	1,440	50,412	
No.17 using demand of day 17				65,729	98,955	148,610
Ammonia Demand	935	999	771			
Ammonia shipping amount (x)	935	616	771	39,449	53,910	
Urea Demand	653	493	678			
Urea shipping amount (y)	653	493	1,043	26,280	45,045	
No.18 using demand of day 18				28,362	96,140	188,793
Ammonia Demand	776	439	766			
Ammonia shipping amount (x)	776	439	1,107	17,562	47,129	
Urea Demand	676	644	719			
Urea shipping amount (y)	676	644	869	10,800	49,010	
No.19 using demand of day 19				30,101	98,685	184,509
Ammonia Demand	997	375	743			
Ammonia shipping amount (x)	997	375	950	10,661	49,175	
Urea Demand	701	648	570			
Urea shipping amount (y)	701	648	840	19,440	49,509	
No.20 using demand of day 20				10,442	106,476	196,376
Ammonia Demand	751	815	842			
Ammonia shipping amount (x)	751	729	842	8,858	53,628	
Urea Demand	588	876	736			
Urea shipping amount (y)	588	865	736	1,584	52,849	

Table 4.25 The result of supply chains model network – fixed production capacity of ammonia and urea (Continue)

Supply chain No.X	Ma	:ket (j) ('	ГPD)	Penalty	Transportation	Profit Z
using product demand of	N (j1)	S (j2)	NE (j3)	cost (\$)	cost (\$)	(\$)
No.21 using demand of day 21				40,417	96,922	175,955
Ammonia Demand	932	625	868			
Ammonia shipping amount (x)	932	578	868	10,609	51,624	
Urea Demand	679	486	610			
Urea shipping amount (y)	679	486	1,024	29,808	45,298	
No.22 using demand of day 22				36,211	97,938	179,145
Ammonia Demand	887	578	783			
Ammonia shipping amount (x)	887	578	857	3,811	52,230	
Urea Demand	613	548	578			
Urea shipping amount (y)	613	548	1,028	32,400	45,708	
No.23 using demand of day 23				17,713	100,924	194,657
Ammonia Demand	864	633	904			
Ammonia shipping amount (x)	864	554	904	8,137	51,288	
Urea Demand	731	633	692			
Urea shipping amount (y)	731	633	825	9,576	49,637	
No.24 using demand of day 24				40,474	90,436	182,384
Ammonia Demand	612	599	827			
Ammonia shipping amount (x)	612	599	1,111	14,626	48,289	
Urea Demand	674	357	799			
Urea shipping amount (y)	674	357	1,158	25,848	42,147	
No.25 using demand of day 25				63,378	94,504	155,412
Ammonia Demand	955	844	721			
Ammonia shipping amount (x)	955	646	721	20,394	54,947	
Urea Demand	605	295	692			
Urea shipping amount (y)	605	295	1,289	42,984	39,557	

Table 4.25 The result of supply chains model network – fixed production capacity of ammonia and urea (Continue)

Supply chain No.X		Market	(j)	Penalty	Transportation	Profit Z
using product demand of	N (j1)	S (j2)	NE (j3)	cost (\$)	cost (\$)	(\$)
No.26 using demand of day 26				32,072	94,403	186,819
Ammonia Demand	913	509	908			
Ammonia shipping amount (x)	913	501	908	824	50,818	
Urea Demand	766	355	634			
Urea shipping amount (y)	766	355	1068	31,248	43,586	
No.27 using demand of day 27				39,609	94,236	179,450
Ammonia Demand	627	610	822			
Ammonia shipping amount (x)	627	610	1,085	13,545	48,793	
Urea Demand	769	431	627			
Urea shipping amount (y)	769	431	989	26,064	45,443	
No.28 using demand of day 28				38,136	95,368	179,791
Ammonia Demand	726	677	686			
Ammonia shipping amount (x)	726	677	919	12,000	51,986	
Urea Demand	830	303	693			
Urea shipping amount (y)	830	303	1,056	26,136	43,382	
No.29 using demand of day 29				41,669	94,427	177,198
Ammonia Demand	690	772	871			
Ammonia shipping amount (x)	690	761	871	1,133	53,404	
Urea Demand	485	438	703			
Urea shipping amount (y)	485	438	1,266	40,536	41,023	
No.30 using demand of day 30				23,386	104,211	185,697
Ammonia Demand	580	756	901			
Ammonia shipping amount (x)	580	756	986	4,378	51,509	
Urea Demand	716	904	701			
Urea shipping amount (y)	716	772	701	19,008	52,703	

Table 4.25 The result of supply chains model network – fixed production capacity of ammonia and urea (Continue)

Supply chain No.X		Market (j)		Penalty	Transportation	Profit Z
using product demand of	N (j1)	S (j2)	NE (j3)	cost (\$)	cost (\$)	(\$)
Deterministic using average				21,488	100,521	191,286
demand						
Ammonia Demand	813	679	814			
Ammonia shipping amount (x)	813	679	830	824	53,439	
Urea Demand	673	565	664			
Urea shipping amount (y)	673	565	951	20,664	47,082	

* The amounts of transportation are assumed to be sold all of product in day (not accumulate)

From Table 4.25, The optimal ammonia shipping amount (x) and urea shipping amount (y) are represented for 30 days. There are 30 supply chains both ammonia and urea. The products shipping amount both ammonia and urea (x and y) that are transported greater than demand of the market (j) or oversupply product will be sold with cheaper selling price about 25% of product selling price. The products which are transported lower than demand of the market (j) or lacked product will have penalty cost about 50% of product selling price. The transportation cost is from the distance between plant and market and amount of product which transported to the market. The distance between plant and markets N(j1), S(j2), and NE(j3) are assumed as 531, 684, 208 miles, respectively. The transportation cost is 0.05 \$/tons/miles as shown in the table 4.24. These conditions are made for programming optimization. In this part, 6.8 Investigation on Optimization of Market Demand (with Fixed Production Capacity of Ammonia and Urea), The capacity of ammonia and urea are fixed with 2,322 and 2,189 TPD, respectively. These productions capacities are from amount of natural gas feed stock of 1,930 TPD and the correlation between ammonia and urea production capacity.

For deterministic optimization method, the average demand of the market in 30 days are considered for optimal ammonia and urea transportation for maximizing profit. The average of ammonia demands in 3 markets N(j1), S(j2), and NE(j3) are 813, 679, and 814 TPD, respectively. The average of urea demands in 3 markets N(j1), S(j2), and NE(j3) are 673, 565, and 664 TPD, respectively. The optimization programming for deterministic method were carried out to determine the appropriate amount of ammonia and urea transported to each market that make the highest profit for 30 days. The average demands are representative for the data set to program assessment. The optimal value of ammonia and urea transportation are used for products transportation further all 30 days. The summation of profit in 30 days for the deterministic method is \$ 4,417,229 as shown in table 4.26. From deterministic method, profit and transported products amount were limited to deterministic values of all economic parameters represents only current average demand of the markets, its do not represent the range of profit. However, stochastic analysis method as a probabilistic approach can provide more accurate and dependable result considering effect of uncertainty demand of market according to randomness in input variable.

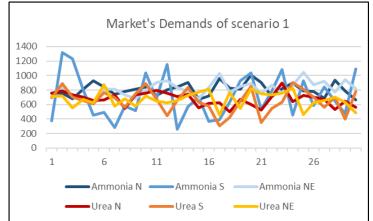
For stochastic optimization method, the demands of market in 30 days are considered for optimal the ammonia and urea transportation amount for maximizing profit as the previous part. To deal with uncertainties occurred due to randomness, stochastic optimization method was conducted. The demands of produces each day were considered for programming optimization. In stochastic method, there are 30 supply chains with 30 optimal values of ammonia and urea transporting amount for each day in 30 days. These values of each supply chains are used for products transportation all 30 days and assessment summation profit of each supply chains. The ammonia and urea transportation amount and summation profit of each supply chains are represented in table 4.26. The difference of profit in 30 days of each supply chains are from differential amount of products transportation and the transported products which not satisfy market's demand of each day. From supply chain No.12 and No.13 give the optimal value for all 30 days which higher profit compare with other supply chains.

Supply chain	An	nmonia (ГPD)	L	Jrea (TPI	D)	
No.	N(j1)	S(j2)	NE(j3)	N(j1)	S(j2)	NE(j3)	ΣProfit in 30 days (\$)
1	677	762	883	687	581	921	4,261,121
2	834	687	801	478	632	1,079	3,612,559
3	878	38	1,406	575	366	1,248	1,272,161
4	777	700	845	614	513	1,062	4,024,657
5	828	735	759	621	575	993	4,163,854
6	987	551	784	712	494	983	3,967,235
7	790	711	821	640	702	847	4,482,196
8	911	663	748	623	475	1,091	3,803,846
9	825	674	823	771	805	613	4,396,103
10	888	539	895	723	737	729	4,491,968
11	782	288	1,252	750	823	616	3,194,335
12	836	629	857	694	667	828	4,619,053
13	770	730	822	798	693	698	4,622,681
14	743	763	816	701	232	1,256	2,920,295
15	815	667	840	528	588	1,073	3,811,853
16	812	470	1,040	779	633	777	4,194,749
17	935	616	771	653	493	1,043	3,961,130
18	776	439	1,107	676	644	869	3,905,657
19	997	375	950	701	648	840	3,924,620
20	751	729	842	588	865	736	4,168,108
21	932	522	868	679	486	1,024	3,939,965
22	887	578	857	613	548	1,028	4,032,835
23	864	554	904	731	633	825	4,497,610
24	612	599	1,111	674	357	1,158	2,901,301
25	955	646	721	605	295	1,289	2,750,758
26	913	501	908	766	355	1,068	3,470,858
27	627	610	1,085	769	431	989	3,476,222
28	726	677	919	830	303	1,056	3,349,787
29	690	761	871	485	438	1,266	2,884,286
30	580	756	986	716	772	701	4,064,320
Deterministic	813	679	830	673	565	951	4,417,229

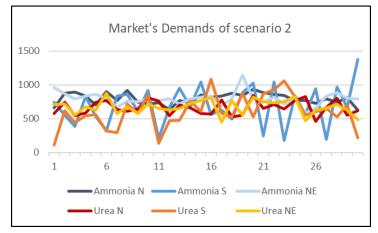
Table 4.26 The optimal value of ammonia and urea transportation for 30 days(historical)

The uncertainty demands of ammonia and urea for 30 days evaluated in previous part are assumed as historical data for the optimal programming. After optimal value of ammonia and urea transported for each market are estimated, the validation part is essential for reach more precise of optimal programming.

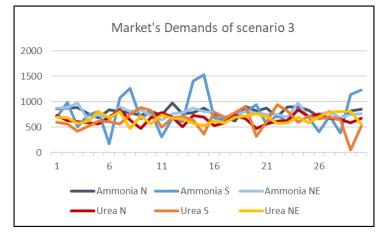
The validation part is created from new set of uncertainty demands of ammonia and urea by using the same statistic values of mean and standard deviation as the historical data as shown in figure 4.19. The mean of ammonia demand of 3 markets N(j1), S(j2), and NE(j3) are 800, 700, and 800 TPD and the standard deviation are 100, 300, and 100, respectively. The mean of urea demand of 3 markets N(j1), S(j2), and NE(j3) are 650, 500, and 650 TPD and the standard deviation are 100, 200, and 100, respectively. In validation part, the new set of market's demands are divided into 12 scenarios, 30 days per scenarios (all 360 days of various data).



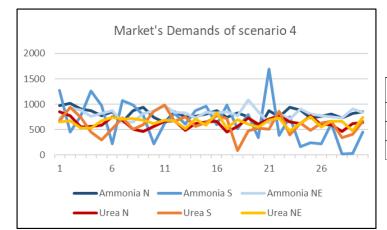
Supply chain	ΣProfit in 30 days (\$)
No.12	4,434,405
No.13	4,374,110
Deterministic	4,029,897



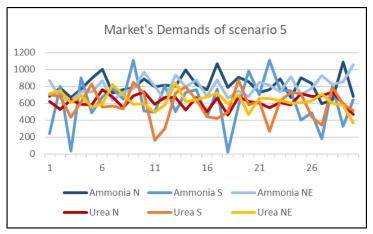
Supply chain	ΣProfit in 30 days (\$)
No.12	4,159,928
No.13	4,258,861
Deterministic	3,953,018



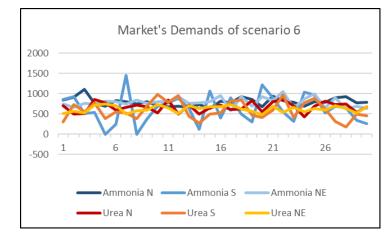
Supply chain	ΣProfit in 30 days (\$)
No.12	4,349,241
No.13	4,358,452
Deterministic	4,065,812



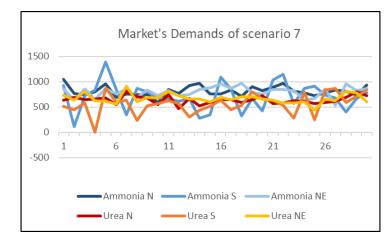
Supply chain	ΣProfit in 30 days (\$)
No.12	4,156,064
No.13	4,116,949
Deterministic	3,861,718



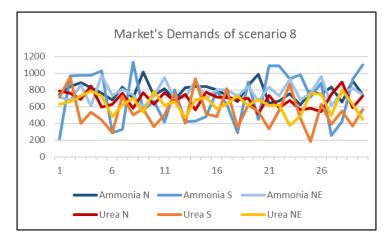
Supply chain	ΣProfit in 30 days (\$)
No.12	4,412,096
No.13	4,344,521
Deterministic	4,176,433



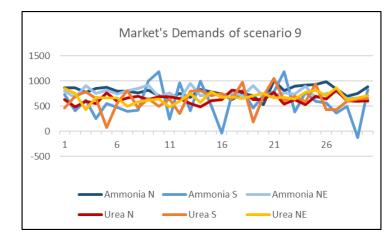
Supply chain	ΣProfit in 30 days (\$)
No.12	3,956,282
No.13	4,078,928
Deterministic	3,723,418



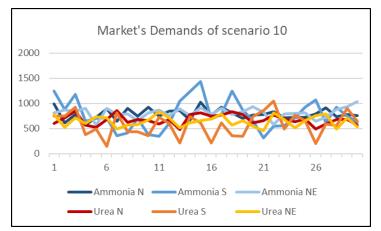
Supply chain	ΣProfit in 30 days (\$)
No.12	4,401,392
No.13	4,326,011
Deterministic	4,247,703



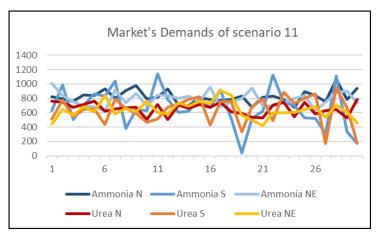
Supply chain	Σ Profit in 30 days (\$)
No.12	4,096,421
No.13	4,191,370
Deterministic	3,958,085



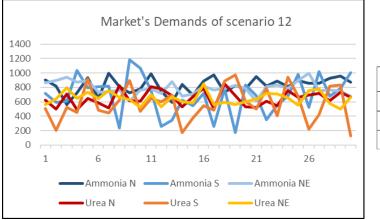
Supply chain	ΣProfit in 30 days (\$)
No.12	4,388,921
No.13	4,287,785
Deterministic	4,057,015



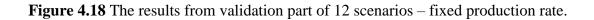
Supply chain	ΣProfit in 30 days (\$)
No.12	4,104,520
No.13	4,169,793
Deterministic	3,852,227

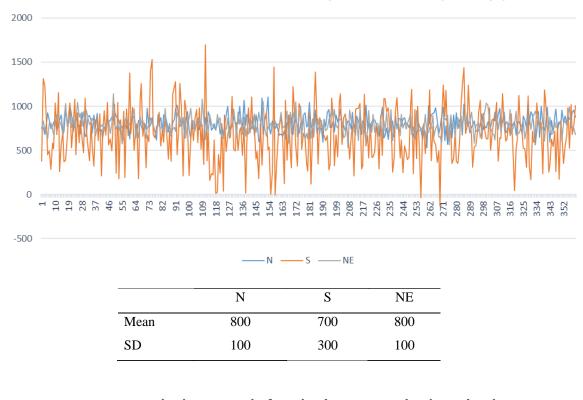


Supply chain	ΣProfit in 30 days (\$)
No.12	4,412,883
No.13	4,350,937
Deterministic	4,055,404



Supply chain	ΣProfit in 30 days (\$)
No.12	4,193,688
No.13	4,184,211
Deterministic	3,987,759







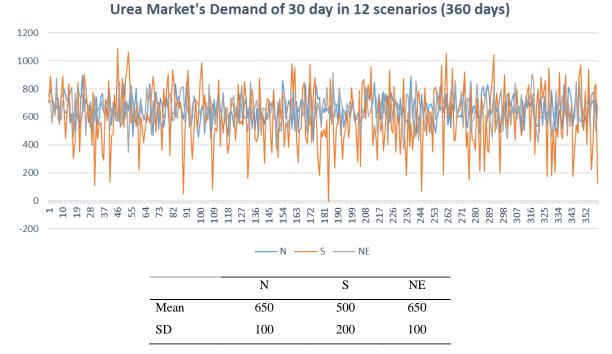


Figure 4.19 The new set of uncertainty market's demands of ammonia and urea in 12 scenarios, 30 days per scenarios (360 days) for validation part.

The optimized value of both ammonia and urea transportation of supply chain No.12 and No.13 in previous part are validated with new set of market's demands in 12 scenarios, 30 days per scenario. The summation of profit in 30 days of each scenarios were converted to profit cumulative frequency curve for evaluated the probability and upper limit profit of each supply chains as shown in figure 4.20

According to the profit cumulative frequency curve in figure 4.20a, at the targeted profit of \$ 4,000,000, the stochastic supply chain No.12 has 8.33 % risk giving profit less than targeted profit and its upper limit of profit is \$ 4,435,000. For figure 4.20b, the stochastic supply chain No.13 has 0 % risk giving profit less than targeted profit and its upper limit of profit is \$ 4,375,000 while the deterministic supply chain has higher risk of 50 % giving profit less than targeted profit and its upper limit of profit less than targeted profit less than targeted profit less than targeted profit less targeted pr

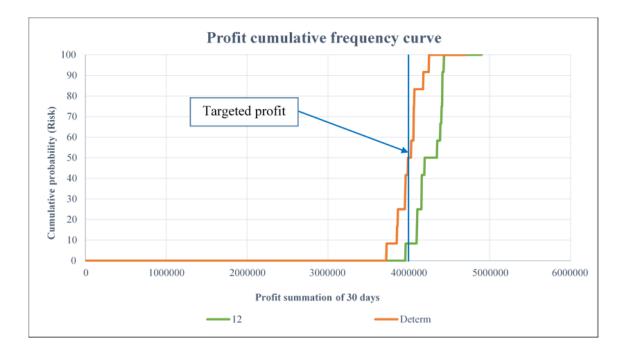


Figure 4.20a profit cumulative frequency curve for supply chain No.12 and deterministic one.

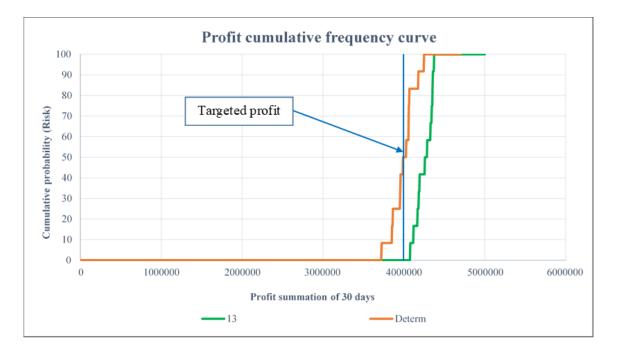


Figure 4.20b profit cumulative frequency curve for supply chain No.13 and deterministic one.

4.9 Investigation on Optimization of Market Demand (with Varied Production Capacity of Ammonia and Urea)

The optimization programming from part 4.8 is assumed to be fixed production capacity of ammonia and urea at 2,322 and 2,189 TPD, respectively. The penalty cost from opportunity loss and surplus production cost are presented from amount of products transportation that satisfy demanding of the markets. To improve the optimization programing, the ammonia/urea production capacity and urea production cost are adjusted to appropriate demand of markets. The mathematical model for designing the network is expressed as show below.

$$Max Z = Price_{Amm} * \Sigma_i \Sigma_j X_{ij} + Price_{Urea} \Sigma_i \Sigma_j Y_{ij} - [Cost1 + Cost2 + Cost3]$$
(6.1)

Subject to constraints,

$$LimCapAmm_{i} = AmmIn_{i} - AmmFeed_{i}$$
(6.8)

$$LimCapUrea_i = 1.4142*AmmFeed_i - 0.014$$
(6.9)

$$\Sigma_{j}X_{ij} = \text{LimCapAmm}_{i} \tag{6.10}$$

$$\Sigma_{j} Y_{ij} = \text{LimCapUrea}_{i} \tag{6.11}$$

$$\Sigma_{i}X_{j} + \Sigma_{i}PenaltyAmm_{ij} - PPAmm_{j} = LimAmm_{j} (Demand)$$
(6.12)

$$\Sigma_i Y_{ij} + \Sigma_i PenaltyUrea_{ij} - PPUrea_j = LimUrea_j (Demand)$$
 (6.13)

$$Cost1 = 635233 + \Sigma_i LimCapUrea_i *73.184 - 1.21$$
(6.14)

$$Cost2 = (\Sigma_i \Sigma_j X_{ij} + \Sigma_i \Sigma_j Y_{ij})^* \text{ transportcost}$$
(6.15)

 $Cost3 = \Sigma_i \Sigma_j PenaltyAmm_{ij} * PAmmCost + \Sigma_i \Sigma_j PPAmm_j * PPAmmCost +$

 $\Sigma_i \Sigma_j$ PenaltyUrea_{ij} * PUreaCost + $\Sigma_i \Sigma_j$ PPUrea_j * PPUreaCost (6.16)

Where

 X_{ij} = Ammonia transportation amount (TPD) Y_{ij} = Urea transportation amount (TPD) LimCapAmm_i = Ammonia production capacity of plant i in cases (TPD) LimCapUrea_i = Urea production capacity of plant i in cases (TPD) AmmIn_i = Maximum ammonia production capacity of plant i in cases (TPD) AmmFeed_i = Ammonia amount which feed to produce urea (TPD) PenaltyAmm_{ij} = Ammonia amount which less than demand of market (TPD) PenaltyUrea_{ij} = Urea amount which less than demand of market (TPD) PPAmm_i = Ammonia amount which greater than demand of market (TPD) PPUrea_i = Urea amount which greater than demand of market (TPD) LimAmm_i (Demand) = Ammonia demand of market j in cases (TPD) LimUrea_j (Demand) = Urea demand of market j in cases (TPD) Opportunity loss cost = $\Sigma_i \Sigma_j$ PenaltyAmm_{ij} * PAmmCost (\$/day) Surplus Production cost = $\sum_i \sum_j PPAmm_j * PPAmmCost (\$/day)$ Cost1 = Ammonia and urea production cost (\$/day)Cost2= Transportation cost (\$/day) Cost3 = Penalty cost (\$/day)

The main objective of this model is to maximize profit from sale products. The objective function is expressed into 3 parts; revenue, transportation cost, and penalty cost as shown in equation 6.1. Equation 6.8 and 6.9 are deal with maximum capacity of plant in ammonia product and urea product, respectively. The urea capacity is from correlation between ammonia to urea product. Cost1, Production cost, is from ammonia which produced form natural gas feed 1,930 ton per day and urea production cost from urea utilities expenditure correlation with urea production function. The case study for deterministic and stochastic model for varied urea production can be divided into 30 days. The simple network with 2 echelons; Plant (i) and Market (j) with 2 products (ammonia and urea) is shown in figure 4.22 for varied production capacity.

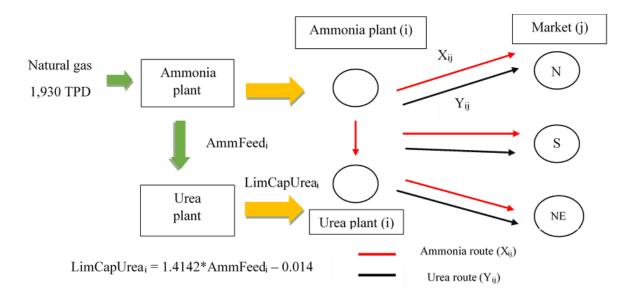


Figure 4.21 The simple network diagram for varied production capacity of ammonia and urea.

Table 4.27 The result of supply chains model network – varied production capacity of ammonia and urea

Supply chain No.X	Ma	rket (j) (TPD)	Penalty	Transportation	Profit Z
using product demand of	N (j1)	S (j2)	NE (j3)	cost (\$)	cost (\$)	(\$)
No.1 using demand of day 1				27,600	101,575	198,259
Ammonia Demand	677	762	851			
Ammonia shipping amount (x)	677	762	851	0	52,885	
Urea Demand	687	581	634			
Urea shipping amount (y)	687	581	1,017	27,600	48,690	
No.2 using demand of day 2				17,559	107,912	159,275
Ammonia Demand	834	1,262	801			
Ammonia shipping amount (x)	834	1,092	801	17,559	67,803	
Urea Demand	478	632	558			
Urea shipping amount (y)	478	632	558	0	40,109	
No.3 using demand of day 3				110,608	83,180	190,757
Ammonia Demand	878	38	790			
Ammonia shipping amount (x)	878	38	790	0	32,827	
Urea Demand	575	366	634			
Urea shipping amount (y)	575	366	2,170	110,608	50,354	
No.4 using demand of day 4				37,649	99,090	194,607
Ammonia Demand	777	700	773			
Ammonia shipping amount (x)	777	700	773	0	52,609	
Urea Demand	614	513	692			
Urea shipping amount (y)	614	513	1,215	37,649	46,481	
No.5 using demand of day 5				22,000	46,673	197,583
Ammonia Demand	828	758	759			
Ammonia shipping amount (x)	828	758	759	0	55,801	
Urea Demand	621	575	706			
Urea shipping amount (y)	621	575	1,012	22,000	46,673	

Table 4.27 The result of supply chains model network – varied production capacity of ammonia and urea (continue)

Supply chain No.X	Ma	rket (j) (TPD)	Penalty	Transportation	Profit Z
using product demand of	N (j1)	S (j2)	NE (j3)	cost (\$)	cost (\$)	(\$)
No.6 using demand of day 6				15,657	101,432	198,806
Ammonia Demand	987	637	784			
Ammonia shipping amount (x)	987	637	784	0	56,144	
Urea Demand	712	494	695			
Urea shipping amount (y)	712	494	912	15,657	45,288	
No.7 using demand of day 7				14,066	104,256	207,939
Ammonia Demand	790	711	801			
Ammonia shipping amount (x)	790	711	801	0	53,621	
Urea Demand	640	702	731			
Urea shipping amount (y)	640	702	926	14,066	50,635	
No.8 using demand of day 8				44,216	99,538	179,378
Ammonia Demand	911	675	748			
Ammonia shipping amount (x)	911	675	748	0	55,051	
Urea Demand	623	475	511			
Urea shipping amount (y)	623	475	1,125	44,216	44,487	
No.9 using demand of day 9				12,471	108,766	210,891
Ammonia Demand	825	674	743			
Ammonia shipping amount (x)	825	674	743	0	52,682	
Urea Demand	771	805	604			
Urea shipping amount (y)	771	805	777	12,471	56,084	
No.10 using demand of day 10				18,794	105,928	189,067
Ammonia Demand	888	829	895			
Ammonia shipping amount (x)	888	647	895	18,794	54,996	
Urea Demand	723	737	628			
Urea shipping amount (y)	723	737	628	0	50,932	

Supply chain No.X Market (j) (TPD) Penalty Transportation Profit Z using product demand of S (j2) NE (j3) cost(\$)cost(\$)(\$) N (j1) 49,004 210,420 No.11 using demand of day 11 100,184 Ammonia Demand 782 288 891 Ammonia shipping amount (x) 782 288 891 0 39,878 Urea Demand 750 823 497 Urea shipping amount (y) 750 823 49,004 60,306 1,178 No.12 using demand of day 12 5.973 103,994 209,351 Ammonia Demand 836 680 857 0 Ammonia shipping amount (x) 836 680 857 54,365 Urea Demand 694 667 724 Urea shipping amount (y) 694 667 807 5,973 49,629 No.13 using demand of day 13 9,798 109,187 192,521 Ammonia Demand 770 956 822 Ammonia shipping amount (x) 770 861 822 9,798 58,434 798 693 Urea Demand 564 798 0 Urea shipping amount (y) 693 564 50,753 47,555 94,993 179,019 No.14 using demand of day 14 Ammonia Demand 743 791 816 Ammonia shipping amount (x) 743 791 816 0 55,265 701 232 Urea Demand 607 701 Urea shipping amount (y) 232 1,267 47,555 39,728 No.15 using demand of day 15 33,414 99,857 210,396 Ammonia Demand 815 667 642 667 642 0 Ammonia shipping amount (x) 815 51,126 Urea Demand 528 588 940 588 Urea shipping amount (y) 528 1,404 33,414 48,731

 Table 4.27 The result of the supply chains model network – varied production

 capacity of ammonia and urea (continue)

Supply chain No.X Market (j) (TPD) Penalty Transportation Profit Z using product demand of S (j2) NE (j3) cost(\$)cost (\$) (\$) N (j1) 198,304 No.16 using demand of day 16 22,964 100,196 722 Ammonia Demand 812 1040 Ammonia shipping amount (x) 812 499 1040 22,964 49,442 Urea Demand 779 643 777 Urea shipping amount (y) 779 643 777 0 50,754 9,145 No.17 using demand of day 17 105,221 181,167 999 Ammonia Demand 935 771 910 Ammonia shipping amount (x) 935 771 9,145 63,972 Urea Demand 653 493 678 Urea shipping amount (y) 653 493 678 0 41,249 No.18 using demand of day 18 49,199 98,140 210,313 Ammonia Demand 776 439 766 0 Ammonia shipping amount (x) 776 439 766 43,583 676 644 Urea Demand 719 Urea shipping amount (y) 676 644 1,402 49,199 54,557 No.19 using demand of day 19 44,195 100,107 200,246 Ammonia Demand 997 375 743 Ammonia shipping amount (x) 997 375 743 0 47,023 701 Urea Demand 648 570 701 Urea shipping amount (y) 648 1,184 44,195 53,085 No.20 using demand of day 20 5,939 107,822 207,773 Ammonia Demand 751 815 842 751 757 842 Ammonia shipping amount (x) 5,939 54,597 Urea Demand 588 876 736 876 Urea shipping amount (y) 588 736 0 53,225

 Table 4.27 The result of the supply chains model network – varied production

 capacity of ammonia and urea (continue)

Supply chain No.X Market (j) (TPD) Penalty Transportation Profit Z using product demand of S (j2) NE (j3) cost(\$)cost(\$)(\$) N (j1) 191,773 No.21 using demand of day 21 22,998 99,461 Ammonia Demand 932 625 868 Ammonia shipping amount (x) 932 625 868 0 55,147 486 Urea Demand 679 610 Urea shipping amount (y) 679 486 929 22,998 44,315 No.22 using demand of day 22 43,613 98,788 189,141 Ammonia Demand 887 578 783 887 578 0 Ammonia shipping amount (x) 783 51,461 Urea Demand 613 548 578 Urea shipping amount (y) 613 548 1,184 43,613 47,328 No.23 using demand of day 23 5,210 102,995 208,374 Ammonia Demand 864 633 904 0 Ammonia shipping amount (x) 864 633 904 53,989 731 Urea Demand 633 692 Urea shipping amount (y) 731 633 764 5,210 49,006 58,443 92,191 201,444 No.24 using demand of day 24 Ammonia Demand 612 599 827 Ammonia shipping amount (x) 612 599 827 0 45,335

357

357

844

844

295

295

674

674

955

955

605

605

799

1,611

721

721

692

1,060

58,443

26,501

0

26,501

46,856

98,895

61,718

37,176

179,546

 Table 4.27 The result of the supply chains model network – varied production

 capacity of ammonia and urea (continue)

Urea Demand

Urea Demand

Urea shipping amount (y)

Ammonia Demand

No.25 using demand of day 25

Ammonia shipping amount (x)

Urea shipping amount (y)

Supply chain No.X Market (j) (TPD) Penalty Transportation Profit Z using product demand of S (j2) NE (j3) cost(\$)cost(\$)N (j1) (\$) 194,321 No.26 using demand of day 26 34,111 95,090 509 Ammonia Demand 913 908 Ammonia shipping amount (x) 913 509 908 0 51,091 Urea Demand 766 355 634 Urea shipping amount (y) 766 355 1,108 34,111 43,999 No.27 using demand of day 27 56,521 95,900 197,604 Ammonia Demand 627 610 822 0 610 Ammonia shipping amount (x) 627 822 46,058 Urea Demand 769 431 627 Urea shipping amount (y) 769 431 1,412 56,521 49,842 No.28 using demand of day 28 53,538 96,903 196,650 Ammonia Demand 726 677 686 0 Ammonia shipping amount (x) 726 677 686 49,563 830 303 Urea Demand 693 Urea shipping amount (y) 830 303 1,437 53,538 47,340 No.29 using demand of day 29 43,094 95,172 184,963 Ammonia Demand 690 772 871 Ammonia shipping amount (x) 690 772 871 0 53,780 438 Urea Demand 485 703 Urea shipping amount (y) 485 438 1,302 43,094 41,392 No.30 using demand of day 30 2,829 108,250 221,539 Ammonia Demand 580 756 901 580 756 901 0 Ammonia shipping amount (x) 50,625 Urea Demand 716 904 701 904 740 Urea shipping amount (y) 716 2,829 57,626

 Table 4.27 The result of the supply chains model network – varied production

 capacity of ammonia and urea (continue)

 Table 4.27 The result of the supply chains model network – varied production

 capacity of ammonia and urea (continue)

Supply chain No.X	Market (j) (TPD)		Penalty	Transportation	Profit Z	
using product demand of	N (j1)	S (j2)	NE (j3)	cost (\$)	cost (\$)	(\$)
Deterministic using average				25,971	101,121	188,795
demand						
Ammonia Demand	813	679	814			
Ammonia shipping amount (x)	813	679	814	0	53,273	
Urea Demand	673	565	664			
Urea shipping amount (y)	673	565	1,025	25,971	47,848	

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18

From Table 4.27, The optimal ammonia shipping amount (x) and urea shipping amount (y) are represented for 30 days. There are 30 supply chains both ammonia and urea. The products shipping amount both ammonia and urea (x and y) which are transported greater than demand of the market (j) or oversupply will be sold with cheaper selling price about 25% of product selling price. The products which are transported lower than demand of the market (j) or lacked product will have penalty cost about 50% of product selling price. The transportation cost is from the distance between plant and market and amount of product which transported to the market. The distance between plant and markets N(j1), S(j2), and NE(j3) are assumed as 531, 684, 208 miles, respectively. The transportation cost is 0.05\$/tons/miles as shown in table 4.24. These conditions are made for programming optimization. In this part, 6.9 Investigation on Optimization of Market Demand (with Varied Production Capacity of Ammonia and Urea), The capacity of ammonia has maximum with 3,870 TPD from natural gas feedstock of 1,930 TPD. The correlation between ammonia feed to urea production capacity is LimCapUrea_i = 1.4142*AmmFeed_i - 0.014 as shown in equation (6.9). The adjustable of product capacity both ammonia and urea can increase optimal values in terms of products transportation meet the specification of market's demand and can increasing profit of plant.

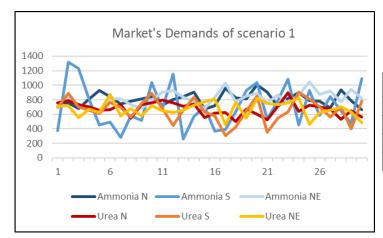
For deterministic optimization method, the average demand of market in 30 days are considered for optimal ammonia and urea transportation for maximizing profit. The average of ammonia demands in 3 markets N(j1), S(j2), NE(j3) are 813, 679, and 814 TPD, respectively. The average of urea demands in 3 markets N(j1), S(j2) and NE(j3) are 673, 565, and 664 TPD, respectively. The demands and average of each market are represented in Table 4.27. The summation of profit in 30 days for deterministic optimization method is \$ 4,610,028 as shown in table 4.28.

Supply chain		Ammoni	a		Urea		
No.	N(j1)	S(j2)	NE(j3)	N(j1)	S(j2)	NE(j3)	ΣProfit in 30 days
1	677	762	851	687	581	1,017	4,474,415
2	834	1,092	801	478	632	558	2,582,525
3	878	38	790	575	366	2,170	2,075,029
4	777	700	773	614	513	1,215	4,155,399
5	828	758	759	621	575	1,012	4,398,067
6	987	637	784	712	494	912	4,303,131
7	790	711	801	640	702	926	4,683,721
8	911	675	748	623	475	1125	4,017,636
9	825	674	743	771	805	777	4,850,215
10	888	647	895	723	737	628	4,581,932
11	782	288	891	750	823	1,178	4,246,215
12	836	680	857	694	667	807	4,863,511
13	770	861	822	798	693	564	4,141,595
14	743	791	816	701	232	1,267	3,099,781
15	815	667	642	528	588	1,404	3,564,999
16	812	499	1040	779	643	777	4,473,759
17	935	910	771	653	493	678	3,843,946
18	776	439	766	676	644	1,402	4,293,763
19	997	375	743	701	648	1,184	4,074,405
20	751	757	842	588	876	736	4,360,092
21	932	625	868	679	486	929	4,319,067
22	887	578	783	613	548	1,184	4,179,456
23	864	633	904	731	633	764	4,806,255
24	612	599	827	674	357	1,611	3,360,171
25	955	844	721	605	295	1,060	2,880,120
26	913	509	908	766	355	1,108	3,690,985
27	627	610	822	769	431	1,412	3,898,627
28	726	677	686	830	303	1,437	3,273,245
29	690	772	871	485	438	1,302	3,080,003
30	580	756	901	716	904	740	4,388,508
Deterministic	813	679	814	673	565	1,025	4,610,028

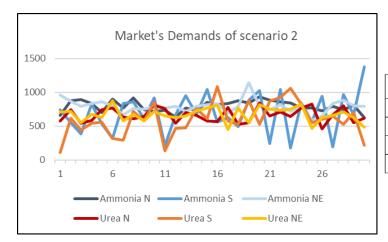
Table 4.28 The optimal value of Ammonia and Urea for 30 days – varied ammoniaand urea production rate (historical)

For stochastic optimization method, the demands of the market in 30 days are considered for optimal ammonia and urea transportation amount for maximizing profit as the previous part. To deal with uncertainties occurred due to randomness, stochastic optimization method was conducted. The demands of produces each day were considered for programming optimization. In stochastic method, there are 30 supply chains with 30 optimal values of ammonia and urea transporting amount for each day in 30 days. These values of each supply chains are used for products transportation all 30 days and assessment summation profit of each supply chains. The ammonia and urea transportation amount and profit summation of each supply chains are represented in table 4.28. The difference of profit in 30 days of each supply chains are from differential amount of products transportation and the transported products which not satisfy market's demand of each day. From supply chain No.9, No 12, and No.23 give the optimal values for all 30 days which higher profit compare with other supply chains.

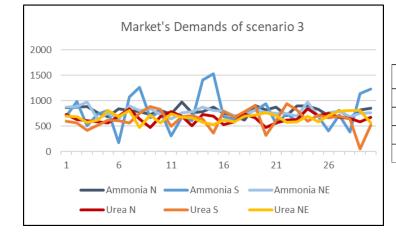
The validation part is created from new set of uncertainty demands of ammonia and urea by using the same statistic value of mean and standard deviation as the historical data as shown in the figure 4.19. The mean of ammonia demand of 3 markets N(j1), S(j2), and NE (j3) are 800, 700, and 800 TPD and the standard deviation are 100, 300, and 100, respectively. The mean of urea demand of 3 markets N(j1), S(j2), and NE(j3) are 650, 500, and 650 TPD and the standard deviation are 100, 200, and 100, respectively. In validation part, the new set of market's demands are divided into 12 scenarios, 30 days per scenarios (all 360 days of various data) as same as part 6.8.



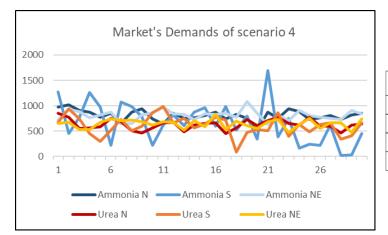
Supply chain	ΣProfit in 30 days (\$)
No.9	4,752,336
No.12	4,636,669
No.23	4,544,178
Deterministic	4,217,781



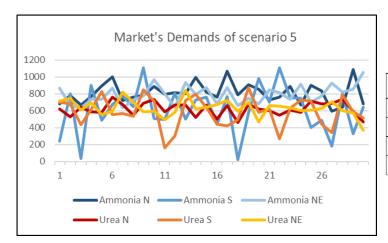
Supply chain	ΣProfit in 30 days (\$)
No.9	4,542,493
No.12	4,385,549
No.23	4,309,481
Deterministic	4,155,869



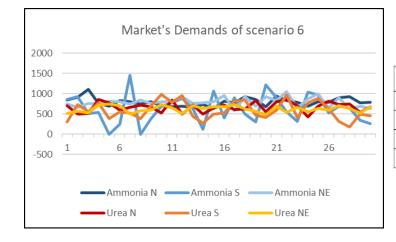
Supply chain	ΣProfit in 30 days (\$)
No.9	4,739,650
No.12	4,610,258
No.23	4,432,352
Deterministic	4,271,919



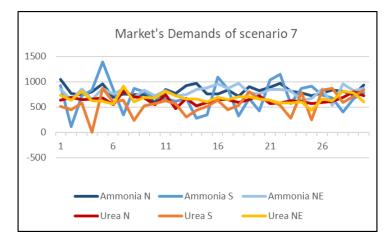
Supply chain	ΣProfit in 30 days (\$)
No.9	4,349,496
No.12	4,362,289
No.23	4,289,086
Deterministic	4,046,277



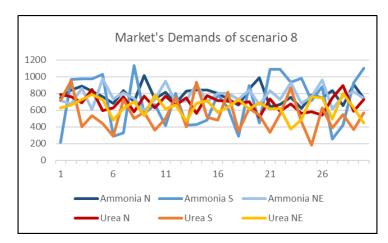
Supply chain	ΣProfit in 30 days (\$)
No.9	4,622,828
No.12	4,628,223
No.23	4,519,803
Deterministic	4,371,670



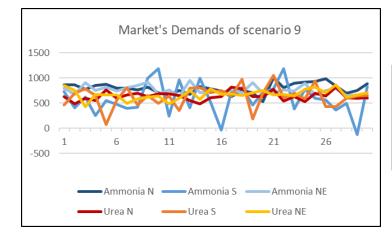
Supply chain	ΣProfit in 30 days (\$)
No.9	4,373,627
No.12	4,162,503
No.23	4,148,803
Deterministic	3,923,030



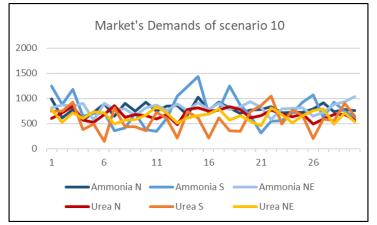
Supply chain	ΣProfit in 30 days (\$)
No.9	4,572,972
No.12	4,652,777
No.23	4,503,266
Deterministic	4,429,242



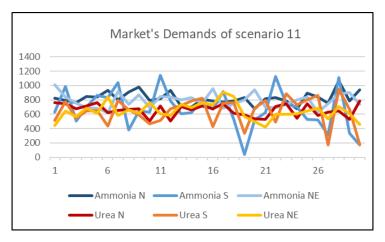
Supply chain	ΣProfit in 30 days (\$)
No.9	4,487,103
No.12	4,328,850
No.23	4,292,671
Deterministic	4,160,601



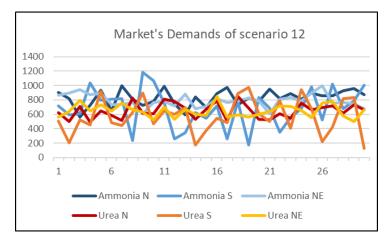
Supply chain	ΣProfit in 30 days (\$)
No.9	4,738,893
No.12	4,571,620
No.23	4,451,390
Deterministic	4,265,565



Supply chain	ΣProfit in 30 days (\$)
No.9	4,417,995
No.12	4,347,503
No.23	4,246,138
Deterministic	4,041,861



Supply chain	ΣProfit in 30 days (\$)
No.9	4,816,588
No.12	4,612,233
No.23	4,494,434
Deterministic	4,249,583



Supply chain	ΣProfit in 30 days (\$)
No.9	4,545,867
No.12	4,430,984
No.23	4,358,699
Deterministic	4,186,478

Figure 4.22 The results from validation part of 12 scenarios – varied production rate.

The optimized value of both ammonia and urea transportation of supply chain No.9, No.12, and No.23 in part 6.9 are validated with new set of market's demands in 12 scenarios, 30 days per scenarios. The summation of profit in 30 days of each scenarios were converted to profit cumulative frequency curve for evaluated the probability and upper limit profit of each supply chains as shown in figure 4.23.

According to the profit cumulative frequency curve in figure 4.23a, at targeted profit of \$ 4,400,000, the stochastic supply chain No.9 has 16.67 % risk giving profit less than targeted profit and its upper limit profit is \$ 4,820,000 . According to the profit cumulative frequency curve in figure 4.23b, the stochastic supply chain No.12 has 41.67 % risk giving profit less than targeted profit and its upper limit profit is \$ 4,655,000 . According to the profit cumulative frequency curve in figure 4.23c, the stochastic supply chain No.23 has 50 % risk giving profit less than targeted profit and its upper limit profit and its upper limit profit and its upper limit profit is \$ 4,545,000 while the deterministic supply chain has higher risk of 91.67 % giving profit less than targeted profit and its upper limit of profit is \$ 4,430,000 lower than stochastic supply chains.

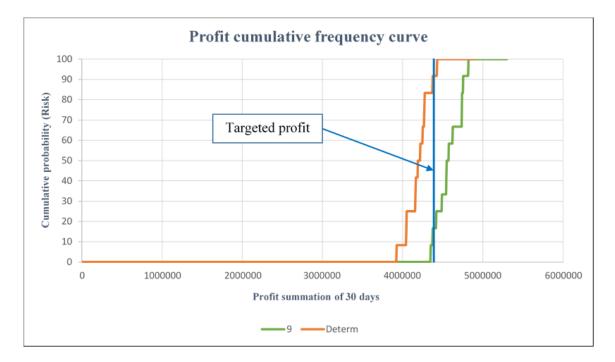


Figure 4.23 Profit cumulative frequency curve for stochastic supply chains No.9 and deterministic one – varied production capacity.

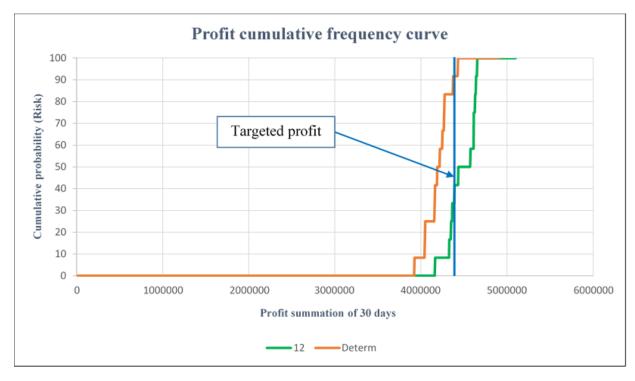


Figure 4.23b Profit cumulative frequency curve for stochastic supply chains No.12 and deterministic one – varied production capacity.

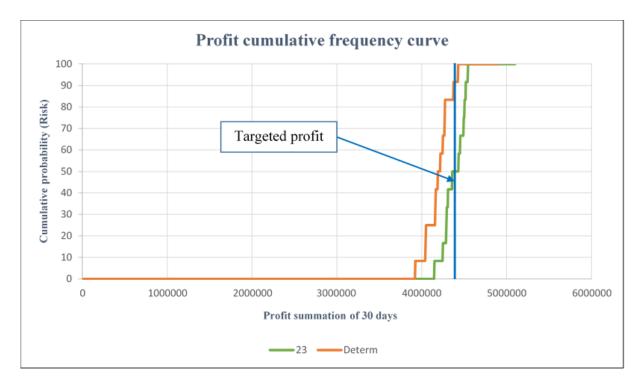


Figure 4.23c Profit cumulative frequency curve for stochastic supply chains No.23 and deterministic one – varied production capacity.

According to the result, the adjusting of ammonia and urea production rate can give higher profit in both of deterministic and stochastic method compared with fixed products production rate as a result of products satisfy market's demands and can decreasing excess costs from product transportation, lacked product penalty cost, and oversupply product sold with cheaper selling price. From the deterministic method, the optimization of ammonia and urea transportation are using single fixed value of average from markets demands in 30 days. To provide the upper and lower limit of profit, scenario analysis is performed with various demand from each market. Stochastic analysis method is dealing with uncertain market's demands, in this research assume to be the historical data. For all studied cases, it was also found that the optimization with stochastic analysis method give the optimal value or higher profit compared with deterministic analysis using the same data.

CHAPTER 5 CONCLUSION

According to the results of this research, ammonia and urea manufacturing process are done by Pro II simulation programming. Ammonia production is a significant material used in a production of urea by reacting with CO₂. This conceptual plant applied ammonia and urea processes can be more efficient in the production of urea, where by-products of each process can be used to produce more urea and reduce CO₂ emission. From 1,930 t/d of natural gas feed, the production capacity of the ammonia process is 3,870 TPD and the production capacity of the urea process is 5,472 TPD. From energy consumption and economic assessment, the capital expenditure (CAPEX) of overall process is 233,988,848 \$. The most operating expenditure of overall process is 45 % from electricity. Improving this section can highly effect on economic of the process. The operating expenditure of urea process can be varied with energy consumption changed due to amount of ammonia feed and urea production rate. Therefore, the correlation between urea production and ammonia feed is essentially considered. For case of varied ammonia and urea production rate, the maximum 30-days profit of \$4,863,511 from stochastic supply chain No.12 and 30-days profit of \$4,610,028 from deterministic supply chain are higher than the ones from case of fixed ammonia and urea production rate, where the maximum 30-days profit of \$ 4,622,681 from stochastic supply chain No.13 and 30-days profit of \$ 4,417,229 from deterministic supply chain. According to the results of supply chains optimization, the adjusting of ammonia and urea production rate give higher profit in both of stochastic and deterministic method compared with fixed production rate as a result of products satisfy market's demands. For stochastic analysis, the validation part approves that optimization with stochastic method provided optimal value compared with deterministic method using identical data. The profit cumulative curve show that stochastic method provides supply chain with a lower risk to achieve profit less the targeted one than deterministic method at same targeted profit. However, consideration of both deterministic and stochastic analyses can provide more effective results.

No.	Description	results							
	Ammonia manufacturin	g process							
1	Ammonia capacity	3,870 TPD							
2	Raw materials	Hydrogen from Natural gas,							
		Nitrogen from Air							
3	Process Units	22 units							
4	Overall Energy Consumption	3,585 MMKJ/hr.							
		$9.49 \times 10^4 \mathrm{kW}$							
5	Annual Operating Expenditure (OPEX)	231,860,129 \$							
6	Product specifications	Ammonia purity 99.90 %							
		Temperature -33.3 °C							
		Pressure 320 psia							
	Urea manufacturing p	process							
7	Urea capacity	5,472 TPD							
8	Raw materials	Ammonia, Carbon dioxide							
9	Process Units	21 units							
10	Overall Energy Consumption	Hot utilities 427 MMKJ/hr.							
		Cold utilities 493 MMKJ/hr.							
		Shaft work 9.52×10^4 kW							
11	Annual Operating Expenditure (OPEX)	146,182,569 \$							
12	Product specifications	Granulated urea purity 99.90 %							
		Temperature 93.33 °C							
	Techno economic assessment	1							
13	Plant lifetime	10 years							
14	Overall Capital Expenditure (CAPEX)	233,988,848 \$							
15	Products price	Ammonia 206 \$/ton							
		Urea 288 \$/ton							
16	Payback period	5.4 year (at 10 % interest)							
17	Net present value	197,175,232 \$							

Table 5.1 Concluded information and key parameters of manufacturing process

	Amn	nonia	(t/d)	U	rea (t/	′d)	Ammonia	Urea	Σ Profit in		
	(j1)	(j2)	(j3)	(j1)	(j2)	(j3)	production rate	production	30 days (\$)		
							(t/d)	rate (t/d)			
Average	813	679	814	673	565	664					
Mean	800	700	800	650	500	650					
SD	100	300	100	100	200	100					
				Fixe	ed pro	ductio	on rate				
Deterministic	813	679	830	673	565 951 2.		2,322	2,189	4,417,229		
Stochastic No.12	836	629	857	694	667	828	2,322	2,189	4,619,053		
Stochastic No.13	770	730	822	798	693	698	2,322	2,189	4,622,681		
	1			Vari	ed pro	oduction	on rate				
Deterministic	813	679	814	673	565	1,025	2,306	2,263	4,610,028		
Stochastic No.9	825	674	743	771	805	777	2,242	2,353	4,850,215		
Stochastic No.12	836	680	857	694	667	807	2,373	2,168	4,863,511		
Stochastic No.23	864	633	904	731	633	764	2,401	2,128	4,806,255		

Table 5.2 Concluded information and key parameters of supply chain optimization

77 VARIABLE x.L Ammonia sale product j1 j2 jЗ **i**1 813.000 679.000 830.000 77 VARIABLE y.L Urea sale product ____ j1 j2 jЗ 673.000 565.000 951.000 **i**1 77 VARIABLE z.L 191285.500 Profit = 100520.500 logistic cost VARIABLE cost2.L = VARIABLE cost3.L 21488.000 Penalty cost 77 VARIABLE PAmm.L lack Ammonia (ALL 0.000) 77 VARIABLE PPAmm.L Waste Ammonia ____ j3 16.000 77 VARIABLE PUr.L lack Urea ____ (ALL 0.000) 77 VARIABLE PPUr.L Waste Urea j3 287.000

Figure A GAMS programing of ammonia and urea plant with improved deterministic supply chain under fixed production rate.

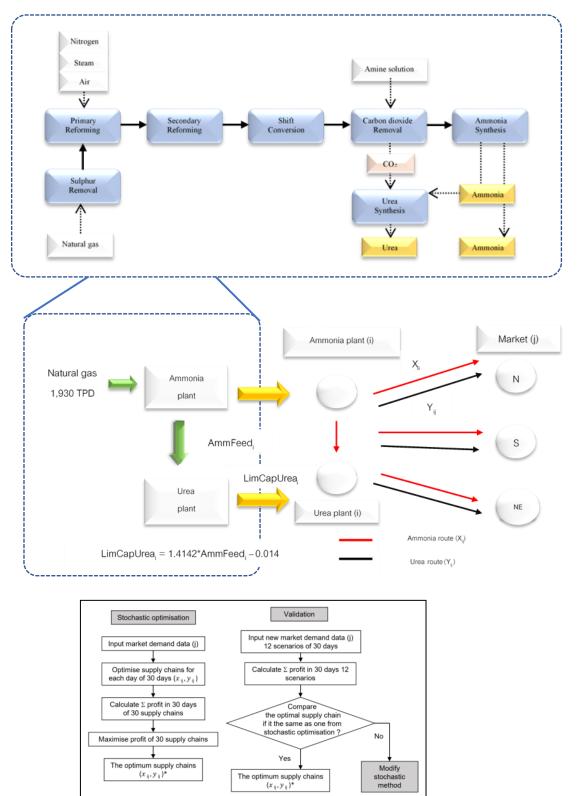
```
93 VARIABLE limcapam.L capacity of plant i in cases
 il 2306.000
          93 VARIABLE limcapur.L capacity of plant i in cases
 ----
 il 2262.706
          93 VARIABLE x.L Ammonia transported product (sale)
             j1
                         j2
                                     j3
 i1
        813.000
                    679.000
                                814.000
          93 VARIABLE y.L Urea transported product (sale)
             jl
                         j2
                                     jЗ
 i1
        673.000
                    565.000
                              1024.706
          93 VARIABLE z.L
                                            = 198778.188 Profit
 _
             VARIABLE cost2.L
                                           = 101120.642 logistic cost
                                           = 25970.832 Penalty cost
= 165592.666 Urea production cost
             VARIABLE cost3.L
             VARIABLE cost4.L
          93 VARIABLE PAmm.L lack Ammonia
                       ( ALL
                                   0.000)
          93 VARIABLE PPAmm.L Waste Ammonia
                       ( ALL
                                   0.000)
          93 VARIABLE PUr.L lack Urea
                                   0.000)
                       ( ALL
          93 VARIABLE PPUr.L Waste Urea
  ----
 j3 360.706
          93 VARIABLE A2U.L Ammonia Feed to produce urea
 ----
 il 1600.000
<
```

Figure B GAMS programing ammonia and urea plant with improved deterministic supply chain under varied production rate.

APPENDICES / APPENDIX

Appendix A

GRAPHICAL ABSTRACT



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Appendix B Aaaaa Aaaaaa Aaaaaa

GAMS programing of ammonia and urea plant with improved deterministic supply chain under varied production rate

```
Sets
                  / il /
         plants
     i
         markets / j1, j2,j3 / ;
     j
Parameters
   limam(j) demand at market j in cases
         j1=813, j2=679, j3=814 /
     1
   limur(j) demand at market j in cases
          j1=673, j2=565, j3=664 / ;
     /
Table d(i,j) distance in miles
              j1
                           j2
                                         j3
    i1
             531
                           684
                                        208
                                                ;
Scalar f freight in dollars per case per thousand miles /0.05/;
Scalar AmmOrigin capacity of plant i in cases /3906/;
Scalar costl
                        Ammonia production cost /635233/;
Scalar Ammprice
                        Ammonia sale price /206/;
Scalar PAmmcost
                        production cost /103/;
Scalar PPAmmcost
                        production cost /51.5/;
Scalar Urprice
                        Urea sale price /288/;
Scalar PUrcost
                       production cost /144/;
                       production cost /72/;
Scalar PPUrcost
Parameter c(i,j) transport cost in dollars per case ;
          c(i,j) = f * d(i,j) ;
variables
         limcapam(i) capacity of plant i in cases
         limcapur(i) capacity of plant i in cases
                        Ammonia Feed to produce urea
         A2U(i)
         x(i,j) Ammonia transported product (sale)
         y(i,j) Urea transported product (sale)
                logistic cost
         cost2
                Penalty cost
         cost3
                Urea production cost
         cost4
         PAmm(i,j) lack Ammonia
         PPAmm(j) Waste Ammonia
         PUr(i,j) lack Urea
         PPUr(j)
                  Waste Urea
                   Profit ;
         z
```

```
positive variables limcapam, limcapur, A2U, x, y, PAmm, PPAmm, PUr, PPUr;
equation conl(i) Ammonia Correlation;
conl(i).. limcapam(i)=e= AmmOrigin-A2U(i);
equation con2(i) Urea Correlation;
con2(i).. limcapur(i) =e= 1.4142*A2U(i)-0.014 ;
equation con3(i);
con3(i).. sum(j, x(i,j)) =e= limcapam(i);
equation con4(i);
con4(i).. sum(j, y(i,j)) =e= limcapur(i) ;
equation con5(j);
con5(j).. sum(i,x(i,j)) + sum(i,PAmm(i,j)) - PPAmm(j) =e= limam(j);
equation con6(j);
con6(j).. sum(i,y(i,j))+ sum(i,PUr(i,j))-PPUr(j) =e= limur(j);
equation con7 logistic cost;
con7 .. cost2 =e= sum((i,j),c(i,j)*(x(i,j)))+ sum((i,j),c(i,j)*(y(i,j)));
equation con8 Penalty cost;
con8 .. cost3 =e= sum ((i,j), PAmmcost*PAmm(i,j))+sum ((i,j), PPAmmcost*PPAmm(j))+
                 sum((i,j),PUrcost*PUr(i,j))+sum((i,j),PPUrcost*PPUr(j));
equation con9 Urea production cost;
con9 .. cost4 === sum((i),73.184*limcapur(i)-1.21);
equation objective;
objective .. z =e= sum((i,j),Ammprice*x(i,j)) + sum((i,j),Urprice*y(i,j)) -
(cost1+cost2+cost3+cost4) ;
```

Model amm /all/; Solve amm using lp maximizing z; Display limcapam.l, limcapur.l, x.l, y.l, z.l, cost2.l, cost3.l, cost4.l, FAmm.l, PPamm.l, PUr.l, PPUr.l, A2U.l ;

Appendix C Aaaaa Aaaaaaa Aaaaaa

Excel programing results of ammonia and urea plant with improved stochastic supply chain under fixed production rate (XY 1-6 of 30)

XY1		Ammonia			Urea						Penalty cost	t				Tran	sportation	Cost		
Day	N	S	NE	N	S	NE	N	S	NE	N	S	NE	Amm	Urea	Sum	Amm	Urea	Sum	Sale	Profit
1	677	762	851	687	581	634	0	0	1648	0	0	20664	1648	20664	22312	53218	47688	100906	1108764	190076
2	834	1262	801	478	632	558	16171	51500	4223	15048	7344	26136	71894	48528	120422	53218	47688	100906	1108764	91966
3	878	38	790	575	366	634	20703	37286	4790	8064	15480	20664	62779	44208	106987	53218	47688	100906	1108764	105401
4	777	700	773	614	513	692	10300	3193	5665	5256	4896	16488	19158	26640	45798	53218	47688	100906	1108764	166590
5	828	758	759	621	575	706	15553	206	6386	4752	432	15480	22145	20664	42809	53218	47688	100906	1108764	169579
6	987	637	784	712	494	695	31930	6438	5099	3600	6264	16272	43466	26136	69602	53218	47688	100906	1108764	142786
7	790	711	801	640	702	731	11639	2627	4223	3384	17424	13680	18489	34488	52977	53218	47688	100906	1108764	159411
8	911	675	748	623	475	511	24102	4481	6953	4608	7632	29520	35535	41760	77295	53218	47688	100906	1108764	135093
9 10	825 888	674 829	743 895	771 723	805 737	604 628	15244 21733	4532 6901	7210 1236	12096 5184	32256 22464	22824 21096	26986 29870	67176 48744	94162 78614	53218 53218	47688 47688	100906 100906	1108764 1108764	118226 133774
10	782	288	891	750	823	497	10815	24411	824	9072	34848	30528	36050	74448	110498	53218	47688	100906	1108764	101890
12	836	680	857	694	667	724	16377	4223	1339	1008	12384	14184	21939	27576	49515	53218	47688	100906	1108764	162873
13	770	956	822	798	693	564	9579	19982	3142	15984	16128	25704	32703	57816	90519	53218	47688	100906	1108764	121869
14	743	791	816	701	232	607	6798	2987	3451	2016	25128	22608	13236	49752	62988	53218	47688	100906	1108764	149400
15	815	667	642	528	588	940	14214	4893	12412	11448	1008	2736	31518	15192	46710	53218	47688	100906	1108764	165678
16	812	722	1040	779	643	777	13905	2060	16171	13248	8928	10368	32136	32544	64680	53218	47688	100906	1108764	147708
17	935	999	771	653	493	678	26574	24411	5768	2448	6336	17496	56753	26280	83033	53218	47688	100906	1108764	129355
18	776	439	766	676	644	719	10197	16635	6026	792	9072 9648	14544	32857	24408	57265	53218	47688	100906	1108764	155123
19 20	997 751	375 815	743 842	701 588	648 876	570 736	32960 7622	19931 5459	7210 2112	2016 7128	42480	25272 13320	60101 15193	62928	97037 78121	53218 53218	47688 47688	100906 100906	1108764 1108764	115351 134267
20	932	625	868	679	486	610	26265	7056	773	576	6840	22392	34093	29808	63901	53218	47688	100906	1108764	148487
22	887	578	783	613	548	578	21630	9476	5150	5328	2376	24696	36256	32400	68656	53218	47688	100906	1108764	143732
23	864	633	904	731	633	692	19261	6644	2163	6336	7488	16488	28068	30312	58380	53218	47688	100906	1108764	154008
24	612	599	827	674	357	799	3348	8395	2884	936	16128	8784	14626	25848	40474	53218	47688	100906	1108764	171914
25	955	844	721	605	295	692	28634	8446	8343	5904	20592	16488	45423	42984	88407	53218	47688	100906	1108764	123981
26	913	509	908	766	355	634	24308	13030	2575	11376	16272	20664	39913	48312	88225	53218	47688	100906	1108764	124163
27	627	610	822	769	431	627	2575	7828	3142	11808	10800	21168	13545	43776	57321	53218	47688	100906	1108764	155067
28	726	677	686	830	303	693	5047	4378	10146	20592	20016	16416	19570	57024	76594	53218	47688	100906	1108764	135794
29	690	772	871	485	438	703	1339	1030	618	14544	10296	15696	2987	40536	43523	53218	47688	100906	1108764	168865
30 Sum	580	756	901	716	904	701	4996	309	1854	4176	46512	15840	7159	66528	73687	53218	47688	100906	1108764	138701 4261121
															-		_			4201121
XY2	N	Ammonia	NE	AL	Urea	NE	N	6	NE		Penalty cos		A	Lines	C.u.		sportation		Col	Prof
Day 1	N 677	S 762	NE 851	N 687	S 581	NE 634	N 8086	S 7725	NE 5150	N 30096	S 3672	NE 32040	Amm 20961	Urea 65808	Sum 86769	Amm 53969	Urea 45527	Sum 99495	Sale 1108764	Profit 127030
2	834	1262	851	687 478	632	634 558	8086	59225	0	30096	3672	32040	20961 59225	37512	96737	53969	45527	99495 99495	1108764	127030
3	878	38	790	575	366	634	4532	33424	567	13968	19152	32040	38522	65160	103682	53969	45527	99495	1108764	11/062
4	777	700	790	614	513	692	2936	1339	1442	19584	8568	27864	5717	56016	61733	53969	45527	99495	1108764	152066
5	828	758	759	621	575	706	309	7313	2163	20592	4104	26856	9785	51552	61337	53969	45527	99495	1108764	152462
6	987	637	784	712	494	695	15759	2575	876	33696	9936	27648	19210	71280	90490	53969	45527	99495	1108764	123309
7	790	711	801	640	702	731	2266	2472	0	23328	10080	25056	4738	58464	63202	53969	45527	99495	1108764	150597
8	911	675	748	623	475	511	7931	618	2730	20880	11304	40896	11279	73080	84359	53969	45527	99495	1108764	129440
9	825	674	743	771	805	604	464	670	2987	42192	24912	34200	4120	101304	105424	53969	45527	99495	1108764	108375
10	888	829	895	723	737	628	5562	14626	9682	35280	15120	32472	29870	82872	112742	53969	45527	99495	1108764	101057
11	782	288	891	750	823	497	2678	20549	9270	39168	27504	41904	32497	108576	141073	53969	45527	99495	1108764	72726
12	836 770	680 956	857 822	694 798	667 693	724 564	206 3296	361 27707	5768 2163	31104 46080	5040 8784	25560 37080	6335 33166	61704 91944	68039 125110	53969 53969	45527 45527	99495 99495	1108764 1108764	145760 88689
13	743	791	822	798	232	607	4687	10712	1545	32112	28800	33984	16944	91944	111840	53969	45527	99495	1108764	101959
14	815	667	642	528	588	940	979	10712	8189	7200	3168	10008	10197	20376	30573	53969	45527	99495	1108764	183226
16	812	722	1040	779	643	777	1133	3605	24617	43344	1584	21744	29355	66672	96027	53969	45527	99495	1108764	117772
17	935	999	771	653	493	678	10403	32136	1545	25200	10008	28872	44084	64080	108164	53969	45527	99495	1108764	105635
18	776	439	766	676	644	719	2987	12772	1803	28512	1728	25920	17562	56160	73722	53969	45527	99495	1108764	140077
19	997	375	743	701	648	570	16789	16068	2987	32112	2304	36648	35844	71064	106908	53969	45527	99495	1108764	106891
20	751	815	842	588	876	736	4275	13184	4223	15840	35136	24696	21682	75672	97354	53969	45527	99495	1108764	116445
21			868	679	486	610	10094	3193	6901	28944	10512	33768	20188	73224	93412	53969	45527	99495	1108764	120387
	932	625					5459	5614	927	19440	6048	36072	12000	61560	73560	53969	45527 45527	99495	1108764	140239
22	932 887	578	783	613	548	578						27864	16480	64440	80920	53969				132879
22 23	932 887 864	578 633	783 904	731	633	692	3090	2781	10609	36432	144		400.40			52050		99495	1108764	
22 23 24	932 887 864 612	578 633 599	783 904 827	731 674	633 357	692 799	3090 11433	2781 4532	2678	28224	19800	20160	18643	68184	86827	53969	45527	99495	1108764	126972
22 23 24 25	932 887 864 612 955	578 633 599 844	783 904 827 721	731 674 605	633 357 295	692 799 692	3090 11433 12463	2781 4532 16171	2678 4120	28224 18288	19800 24264	20160 27864	32754	70416	103170	53969	45527 45527	99495 99495	1108764 1108764	126972 110629
22 23 24 25 26	932 887 864 612 955 913	578 633 599 844 509	783 904 827 721 908	731 674 605 766	633 357 295 355	692 799 692 634	3090 11433 12463 8137	2781 4532 16171 9167	2678 4120 11021	28224 18288 41472	19800	20160 27864 32040	32754 28325	70416 93456	103170 121781	53969 53969	45527 45527 45527	99495 99495 99495	1108764 1108764 1108764	126972 110629 92018
22 23 24 25	932 887 864 612 955	578 633 599 844	783 904 827 721	731 674 605	633 357 295	692 799 692	3090 11433 12463	2781 4532 16171	2678 4120	28224 18288	19800 24264 19944	20160 27864	32754	70416	103170	53969	45527 45527	99495 99495	1108764 1108764	126972 110629
22 23 24 25 26 27	932 887 864 612 955 913 627	578 633 599 844 509 610	783 904 827 721 908 822	731 674 605 766 769	633 357 295 355 431	692 799 692 634 627	3090 11433 12463 8137 10661	2781 4532 16171 9167 3966	2678 4120 11021 2163	28224 18288 41472 41904	19800 24264 19944 14472	20160 27864 32040 32544	32754 28325 16789	70416 93456 88920	103170 121781 105709	53969 53969 53969	45527 45527 45527 45527	99495 99495 99495 99495	1108764 1108764 1108764 1108764	126972 110629 92018 108090
22 23 24 25 26 27 28	932 887 864 612 955 913 627 726	578 633 599 844 509 610 677	783 904 827 721 908 822 686	731 674 605 766 769 830	633 357 295 355 431 303	692 799 692 634 627 693	3090 11433 12463 8137 10661 5562	2781 4532 16171 9167 3966 515	2678 4120 11021 2163 5923	28224 18288 41472 41904 50688	19800 24264 19944 14472 23688	20160 27864 32040 32544 27792	32754 28325 16789 12000	70416 93456 88920 102168	103170 121781 105709 114168	53969 53969 53969 53969	45527 45527 45527 45527 45527	99495 99495 99495 99495 99495	1108764 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631
22 23 24 25 26 27 28 29	932 887 864 612 955 913 627 726 690	578 633 599 844 509 610 677 772	783 904 827 721 908 822 686 871	731 674 605 766 769 830 485	633 357 295 355 431 303 438	692 799 692 634 627 693 703	3090 11433 12463 8137 10661 5562 7416	2781 4532 16171 9167 3966 515 8755	2678 4120 11021 2163 5923 7210	28224 18288 41472 41904 50688 1008	19800 24264 19944 14472 23688 13968	20160 27864 32040 32544 27792 27072	32754 28325 16789 12000 23381	70416 93456 88920 102168 42048	103170 121781 105709 114168 65429	53969 53969 53969 53969 53969	45527 45527 45527 45527 45527 45527	99495 99495 99495 99495 99495 99495 99495	1108764 1108764 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631 148370
22 23 24 25 26 27 28 29 30	932 887 864 612 955 913 627 726 690	578 633 599 844 509 610 677 772	783 904 827 721 908 822 686 871	731 674 605 766 769 830 485	633 357 295 355 431 303 438	692 799 692 634 627 693 703	3090 11433 12463 8137 10661 5562 7416	2781 4532 16171 9167 3966 515 8755	2678 4120 11021 2163 5923 7210	28224 18288 41472 41904 50688 1008 34272	19800 24264 19944 14472 23688 13968	20160 27864 32040 32544 27792 27072 27216	32754 28325 16789 12000 23381	70416 93456 88920 102168 42048	103170 121781 105709 114168 65429	53969 53969 53969 53969 53969 53969 53969	45527 45527 45527 45527 45527 45527	99495 99495 99495 99495 99495 99495 99495 99495	1108764 1108764 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631 148370 82655
22 23 24 25 26 27 28 29 30 Sum	932 887 864 612 955 913 627 726 690	578 633 599 844 509 610 677 772 756	783 904 827 721 908 822 686 871	731 674 605 766 769 830 485	633 357 295 355 431 303 438 904	692 799 692 634 627 693 703	3090 11433 12463 8137 10661 5562 7416	2781 4532 16171 9167 3966 515 8755	2678 4120 11021 2163 5923 7210	28224 18288 41472 41904 50688 1008 34272	19800 24264 19944 14472 23688 13968 39168	20160 27864 32040 32544 27792 27072 27216	32754 28325 16789 12000 23381	70416 93456 88920 102168 42048	103170 121781 105709 114168 65429	53969 53969 53969 53969 53969 53969 53969	45527 45527 45527 45527 45527 45527 45527	99495 99495 99495 99495 99495 99495 99495 99495	1108764 1108764 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631 148370 82655
22 23 24 25 26 27 28 29 30 5um XY3 Day 1	932 887 864 612 955 913 627 726 690 580 580	578 633 599 844 509 610 677 772 756 Ammonia S 762	783 904 827 721 908 822 686 871 901 	731 674 605 766 830 485 716 N 687	633 357 295 355 431 303 438 904 Urea S 581	692 799 692 634 627 693 703 701 NE 634	3090 11433 12463 8137 10661 5562 7416 13081 N 10352	2781 4532 16171 9167 3966 515 8755 7107 	2678 4120 11021 2163 5923 7210 10300 NE 28583	28224 18288 41472 41904 50688 1008 34272 N 16128	19800 24264 19944 14472 23688 13968 39168 39168 Penalty cost 5 30960	20160 27864 32040 32544 27792 27072 27216 t t NE 44208	32754 28325 16789 12000 23381 30488 Amm 113506	70416 93456 88920 102168 42048 100656 Urea 91296	103170 121781 105709 114168 65429 131144 <u>Sum</u> 204802	53969 53969 53969 53969 53969 53969 53969 Tran Amm 39233	45527 45527 45527 45527 45527 45527 45527 45527 sportation Urea 40763	99495 99495 99495 99495 99495 99495 99495 99495 99495 Cost	1108764 1108764 1108764 1108764 1108764 1108764 1108764 Sale 1108764	126972 110629 92018 108090 99631 148370 82655 3612559 Profit 28496
22 23 24 25 26 27 28 29 30 5um Xr3 Day 1 2	932 887 864 612 955 913 627 726 690 580 80 80 80 80 80 80 80 80 80 80 80 80 8	578 633 599 844 509 610 677 772 756 Ammonia S 762 1262	783 904 827 721 908 822 686 871 901 	731 674 605 766 769 830 485 716 N 687 478	633 357 295 355 431 303 438 904 Urea S 581 632	692 799 692 634 627 693 703 701 800 701 800 800 800 800 800 800 800 800 800 8	3090 11433 12463 8137 10661 5562 7416 13081 N 10352 2266	2781 4532 16171 9167 3966 515 8755 7107 \$ 74572 126072	2678 4120 11021 2163 5923 7210 10300 NE 28583 31158	28224 18288 41472 41904 50688 1008 34272 N 16128 6984	19800 24264 19944 14472 23688 39168 99168 Penalty cos 5 30960 38304	20160 27864 32040 32544 27792 27072 27072 27216 	32754 28325 16789 12000 23381 30488 Mmm 113506 159496	70416 93456 88920 102168 42048 100656 Urea 91296 94968	103170 121781 105709 114168 65429 131144 Sum 204802 254464	53969 53969 53969 53969 53969 53969 53969 Tran Amm 39233 39233	45527 45577 45577 45577 45577 45577 45577 45577 45577 455777 455777 455777 45577777 45577777777	99495 99495 99495 99495 99495 99495 99495 Cost Cost 79996 79996	1108764 1108764 1108764 1108764 1108764 1108764 1108764 Sale 1108764 1108764	126972 110629 92018 108090 99631 148370 82655 3612559 Profit 28496 -21165
22 23 24 25 26 27 28 29 30 5um XY3 Day 1 2 2 3	932 887 864 612 955 913 627 726 690 580 580 N 677 834	578 633 599 844 509 610 677 772 772 775 775 776 776 776 776 776 776 776 776	783 904 827 721 908 822 686 871 901 901 871 801 790	731 674 605 766 769 830 485 716 N 687 478 575	633 357 295 355 431 303 438 904 Urea S 581 632 366	692 799 692 634 627 693 703 701 701 NE 634 558 634	3090 11433 12463 8137 10661 5562 7416 13081 N 10352 2266 0	2781 4532 16171 9167 3966 515 8755 7107 \$ 74572 126072 0	2678 4120 11021 2163 5923 7210 10300 NE 28583 31158 31724	28224 18288 41472 41904 50688 1008 34272 N 16128 6984 0	19800 24264 19944 14472 23688 39168 99168 99068 30960 38304 0	20160 27864 32040 32544 27792 27072 27216 4 4208 49680 44208	32754 28325 16789 12000 23381 30488	70416 93456 88920 102168 42048 100656 Urea 91296 94968 44208	103170 121781 105709 114168 65429 131144 Sum 204802 254464 75932	53969 53969 53969 53969 53969 53969 53969 Tran Amm 39233 39233 39233	45527 45577 45577 45577 45577 45577 45577 45577 45577 45577 45577 455777 455777 455777 45577777777	99495 99495 99495 99495 99495 99495 99495 99495 Cost Sum 79996 79996 79996	1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631 148370 82655 3612559 Profit 28496 -21165 157366
22 23 24 25 26 27 28 29 30 Sum XV3 Day 1 2 3 3 4	932 887 864 612 955 913 627 726 690 580 580 N 677 834 878 777	578 633 599 844 509 610 677 772 756 762 1262 38 700	783 904 827 721 908 822 686 871 901 ••••••••••••••••••••••••••••••••••	731 674 605 766 769 830 485 716 N 687 478 575 614	633 357 295 355 431 303 438 904 Urea 5 81 632 366 513	692 799 692 634 627 693 703 701 701 NE 634 558 634 692	3090 11433 12463 8137 10661 5562 7416 13081 N 10352 2266 0 5202	2781 4532 16171 9167 3966 515 8755 7107 5 74572 126072 0 68186	2678 4120 11021 2163 5923 7210 10300 NE 28583 31158 31724 32600	28224 18288 41472 41904 50688 1008 34272 N 16128 6984 0 5616	19800 24264 19944 14472 23688 39168 39168 Penalty cost 5 30960 38304 0 21168	20160 27864 32040 32544 27792 27072 27216 4 4208 49680 44208 40032	32754 28325 16789 12000 23381 30488	70416 93456 88920 102168 42048 100656 Urea 91296 94968 44208 66816	103170 121781 105709 114168 65429 131144	53969 53969 53969 53969 53969 53969 53969 Tran Amm 39233 39233 39233 39233	45527 45577 45577 45577 45577 45577 45577 45577 45577 45577 455777 455777 45577777777	99495 99495 99495 99495 99495 99495 99495 99495 Cost Sum 79996 79996 79996	1108764 1108764 1108764 1108764 1108764 1108764 1108764 Sale 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631 148370 82655 3612559 Profit 28496 -21165 157366 60495
22 23 24 25 26 27 28 29 30 Sum XY3 Day 1 2 2 3 4 4 5	932 887 864 612 913 627 726 690 580 880 880 877 834 878 877 834 8777 828	578 633 599 844 509 610 677 772 756 762 1262 38 762 38 700 758	783 904 827 721 908 822 686 871 901 	731 674 605 766 830 485 716 N 687 478 575 614 621	633 357 295 355 431 303 438 904 Urea 5 581 632 366 513 575	692 799 692 634 627 693 703 701 NE 634 558 634 692 706	3090 11433 12463 8137 10661 5562 7416 13081 N 10352 2266 0 5202 2575	2781 4532 16171 9167 3966 515 8755 7107 \$ 74572 126072 0 68186 74160	2678 4120 11021 2163 5923 7210 10300 NE 28583 31158 31158 31158 311724 32600 33321	28224 18288 41472 41904 50688 1008 34272 N 16128 6984 0 5616 6624	19800 24264 19944 14472 23688 39168 39168 Penalty cos 5 30960 38304 0 21168 30096	20160 27864 32040 32544 27792 27072 27216 4 4208 49680 44208 49680 44208	32754 28325 16789 12000 23381 30488	70416 93456 88920 102168 42048 100656 9 91296 94968 44208 66816 75744	103170 121781 105709 114168 65429 131144 Sum 204802 254464 75932 172803 185800	53969 53969 53969 53969 53969 53969 53969 Tran Amm 39233 39233 39233 39233	45527 45527 45527 45527 45527 45527 45527 45527 45527 45527 45527 40563 40763 40763 40763 40763 40763	99495 99495 99495 99495 99495 99495 99495 99495 Cost Sum 79996 79996 79996 79996	1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631 148370 82655 3612559 Profit 28496 -21165 157366 60495 47499
22 23 24 25 26 27 28 29 30 Sum XV3 Day 1 2 3 3 4	932 887 864 612 955 913 627 726 690 580 580 N 677 834 878 777	578 633 599 844 509 610 677 772 756 762 1262 38 700	783 904 827 721 908 822 686 871 901 	731 674 605 766 769 830 485 716 N 687 478 575 614	633 357 295 355 431 303 438 904 Urea 5 81 632 366 513	692 799 692 634 627 693 703 701 701 NE 634 558 634 692	3090 11433 12463 8137 10661 5562 7416 13081 N 10352 2266 0 5202	2781 4532 16171 9167 3966 515 8755 7107 5 74572 126072 0 68186	2678 4120 11021 2163 5923 7210 10300 NE 28583 31158 31724 32600	28224 18288 41472 41904 50688 1008 34272 N 16128 6984 0 5616	19800 24264 19944 14472 23688 39168 39168 Penalty cost 5 30960 38304 0 21168	20160 27864 32040 32544 27792 27072 27216 4 4208 49680 44208 40032	32754 28325 16789 12000 23381 30488	70416 93456 88920 102168 42048 100656 Urea 91296 94968 44208 66816	103170 121781 105709 114168 65429 131144	53969 53969 53969 53969 53969 53969 53969 Tran Amm 39233 39233 39233 39233	45527 45577 45577 45577 45577 45577 45577 45577 45577 45577 455777 455777 45577777777	99495 99495 99495 99495 99495 99495 99495 99495 Cost Sum 79996 79996 79996	1108764 1108764 1108764 1108764 1108764 1108764 1108764 5ale 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631 148370 82655 3612559 Profit 28496 -21165 157366 60495
22 23 24 25 26 27 28 29 30 Sum Sum Day 1 2 3 4 5 5 6	932 887 864 612 955 913 627 726 690 580 580 N 677 834 878 777 834 878 777 828 987	578 633 599 844 509 610 677 772 756 756 762 1262 38 762 1262 38 700 700 758 637	783 904 827 721 908 822 686 871 901 901 851 801 790 773 759 784	731 674 605 766 830 485 716 N 687 478 575 614 621 712	633 357 295 355 431 303 438 904 Urea 5 581 632 366 513 575 494	692 799 692 634 627 693 703 701 NE 634 558 634 634 692 706 695	3090 11433 12463 8137 10661 5562 7416 13081 N 10352 2266 0 5202 2575 11227	2781 4532 16171 9167 3966 515 8755 7107 5 74572 126072 0 68186 74160 61697	2678 4120 11021 2163 5923 7210 10300 NE 28583 31158 31724 32600 33321 32033	28224 18288 41472 41904 50688 1008 34272 N 16128 6984 0 5616 6624 19728	19800 24264 19944 14472 23688 13968 39168 39168 S 30960 38304 0 0 21168 30096 18432	20160 27864 32040 32544 27792 27072 27216 NE 44208 49680 44208 44208 44032 39024 39816	32754 28325 16789 12000 23381 30488	70416 93456 88920 102168 42048 100656 Urea 91296 94968 44208 66816 75744 77976	103170 121781 105709 114168 65429 131144 Sum 204802 254464 75932 172803 185800 182933	53969 53963 5395 5395	45527 45527 45527 45527 45527 45527 45527 45527 45527 45527 45527 40763 40763 40763 40763 40763 40763 40763	99495 99495 99495 99495 99495 99495 99495 99495 Cost Sum 79996 79996 79996 79996 79996 79996	1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631 148370 82655 3612559 Profit 28496 -21165 157366 60495 47499 50365
22 23 24 25 26 27 28 29 20 5 30 5 sum 29 5 30 5 sum 1 2 2 3 4 4 5 6 6	932 887 864 955 913 627 726 690 580 80 580 80 80 80 80 80 80 80 80 80 80 80 80 8	578 633 599 844 509 610 677 772 756 Ammonia 5 762 1262 38 700 758 637 711	783 904 827 721 908 822 686 871 901 NE 851 801 790 773 759 784 801	731 674 605 766 830 485 716 N 687 478 575 614 621 712 640	633 357 295 355 431 303 438 904 Urea 581 632 366 513 575 575 494 494	692 799 692 634 627 693 703 701 NE 634 558 634 692 706 695 731	3090 11433 12463 8137 10661 5562 7416 13081 N 10352 2266 0 5202 22575 11227 4532	2781 4532 16171 9167 3966 515 8755 7107 5 74572 126072 0 68186 74160 61697 69319	2678 4120 11021 2163 5923 7210 1000 28583 31158 31724 32600 33321 32033 31158	28224 18288 41472 41904 50688 1008 34272	19800 24264 19944 14472 23688 13968 39168 39168 30960 38304 0 21168 30096 18432 48384	20160 27864 32040 32544 27792 27072 27216 NE 44208 49680 44208 49680 44208 39024 39816 37224	32754 28325 16789 12000 23381 30488	70416 93456 88920 102168 42048 100656 9 9196 94968 44208 66816 75744 77976 94968	103170 121781 105709 114168 65429 131144 204802 254464 75932 172803 185800 182933 199977	53969 53963 5395 5395	45527 45527 45527 45527 45527 45527 45527 45527 40763 40763 40763 40763 40763 40763 40763 40763	99495 99495 99495 99495 99495 99495 99495 99495 99495 Cost Cost Cost 79996 79996 79996 79996 79996 79996	1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631 148370 82655 3612559 Profit 28495 -21165 157366 60495 47499 50365 33322
22 23 24 25 26 27 28 30 5 m Day 1 2 3 3 0 ay 1 2 3 4 4 5 6 6 7 7 8 9 9 10	932 887 864 612 955 913 627 726 690 580 880 880 880 880 883 877 777 828 834 878 777 828 8987 790 911 825 888	578 633 599 610 677 772 756 Ammonia 5 762 1262 38 700 758 637 711 675 637 711 675 674 829	783 904 827 721 908 822 686 871 901 NE 851 801 790 773 759 784 801 743 895	731 674 605 766 769 830 485 716 N 687 478 575 614 621 712 640 623 771 712	633 357 295 355 431 303 438 904 Urea 5 581 632 366 513 575 494 702 475 805 737	692 799 634 627 693 703 701 701 8 8 8 4 8 4 558 634 558 634 558 634 992 706 695 731 511 604 628	3090 11433 12463 8137 10661 5562 7416 13081	2781 4532 16171 9167 3966 515 8755 7107 5 74572 126072 0 68186 68186 68186 74160 61697 69319 65611 65508 81473	2678 4120 11021 2163 5923 7210 10300 28583 31158 31158 31158 31158 31724 32600 33321 32033 31158 33887	28224 18288 41472 41904 50688 1008 34272 N 16128 6984 0 5616 6624 19728 9360 6912 28224 28224 21312	19800 24264 19944 14472 23688 39168 Penalty cost S 30960 38304 0 21168 300960 18432 48384 15696	20160 27864 32040 32544 27792 27072 27216 NE 44208 49680 44208 49680 44208 49680 44208 39024 39924 399816 37224 53064 46368 44640	32754 28325 16789 12000 23381 30488	70416 93456 88920 102168 42048 100656 91296 91296 94968 44208 66816 75744 77976 94968 75672	103170 121781 105709 114168 65429 131144 204802 254464 75932 172803 185800 182933 199977 178569 240190 240190 242196	53969 53969 53969 53969 53969 53969 53969 53969 53969 53969 53969 39233 39233 39233 39233 39233 39233 39233 39233 39233	45527 45527 45527 45527 45527 45527 45527 45527 45527 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763	99495 99495 99495 99495 99495 99495 99495 Cost Cost 79996 79996 79996 79996 79996 79996 79996	1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631 148370 82655 36125 36125 361
22 23 24 25 25 26 27 28 29 30 5 wm 1 2 2 3 4 4 5 6 6 7 7 7 8 9 9 10	932 864 612 955 913 627 726 690 580 880 877 834 878 777 828 987 777 828 987 7790 911 825 828 987 782	578 633 599 610 677 772 756 762 1262 38 762 1262 38 700 758 637 711 675 674 829 288	783 904 827 721 908 822 686 871 901 801 790 773 759 773 759 774 801 748 801 748 891	731 674 605 769 830 485 716 N 687 478 575 614 621 712 640 623 771 2723 750	633 357 295 431 303 438 904 Urea 5 581 632 366 513 575 513 575 494 494 702 475 805 737 823	692 799 692 634 627 693 703 701 701 701 701 701 703 703 703 703 703 703 703 703 703 703	3090 11433 12463 8137 10661 5562 7416 13081 N 10352 2266 0 5202 2575 2266 0 5202 2575 11227 4532 3399 2730 1030 4944	2781 4532 16171 9167 3966 515 8755 74572 126072 0 68186 741607 61697 69319 65611 65508 81473 25750	2678 4120 11021 2163 5923 7210 10300	28224 18288 41472 41904 50688 1008 34272 N 16128 6984 0 5616 6624 19728 9360 6912 28224 21312 25200	19800 24264 19944 14472 23688 39168 39168 Penalty cos S 30060 38304 0 21168 30096 18432 48384 15696 63216 53424 65808	20160 27864 32040 32544 27792 27072 27216 NE 44208 44208 44208 44208 44208 44208 39024 39024 39024 39816 37224 53064 46368 44640 54072	32754 28325 16789 12000 23381 30488 13506 159496 31724 105987 110056 104957 105009 102897 105009 102897 105382 108820 57217	70416 93456 88920 102168 42048 100656 91296 94968 44208 66816 75744 44208 66816 75749 94968 75672 137808 119376 145080	103170 121781 105709 114168 65429 131144 204802 254464 75932 172803 185809 182933 199977 178569 240190 228196 228196 228196	53969 53969 53969 53969 53969 53969 53969 53969 53969 53969 53969 53923 39233 39233 39233 39233 39233 39233 39233 39233 39233 39233	45527 45527 45527 45527 45527 45527 45527 45527 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763	99495 99495 99495 99495 99495 99495 Cost Cost 7 9996 79996 79996 79996 79996 79996 79996 79996 79996 79996	1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631 148370 82655 3612559 7612 28496 -21165 157366 60495 157366 60495 50365 33322 54729 -6892 54729
22 23 24 25 25 27 28 30 30 30 30 30 30 30 30 2 3 3 4 5 5 6 6 7 7 8 9 9 10 11 12	932 887 864 612 955 913 627 726 690 580 880 87 834 878 777 834 878 777 828 987 790 911 825 888 782 836	578 633 599 844 509 610 677 772 756 772 1262 38 700 758 637 711 637 711 674 829 828 680	783 904 827 721 908 822 686 871 901 NE 851 801 790 773 784 801 779 784 801 748 801 855 885	731 674 605 766 769 830 485 716 N 687 478 575 614 621 712 640 621 712 640 623 771 723 750 694	633 357 295 431 303 438 904 Urea 5 8 581 632 366 513 575 494 702 475 805 737 805 737 823 8667	692 799 692 634 627 693 703 701 8 634 558 634 558 634 692 706 695 731 511 604 628 497 724	3090 11433 12463 8137 10661 5562 7416 13081 N N 10352 2266 0 5202 2575 11227 4532 3399 2730 1030 4944 2163	2781 4532 16171 9167 3966 515 8755 7107 5 74572 126072 0 68186 74160 61697 69319 65611 65508 81473 25750	2678 4120 11021 2163 5923 7210 10300 NE 28583 31158 311724 32600 33321 32033 31158 33887 34145 26317 26523 28274	28224 18288 41472 41904 50688 1008 34272 N 16128 6984 0 5616 6624 19728 9360 6912 28224 21312 25200 17136	19800 24264 19944 14472 23688 13968 39168 39168 39168 30960 38304 0 21168 300960 38304 0 21168 300960 18432 48384 15696 63216 53424 65808 43344	20160 27864 32040 32544 27792 27072 27216 NE 44208 49680 44208 40032 39024 39024 39816 37224 53064 46368 44640 54072 37728	32754 28325 16789 12000 23381 30488 Amm 113506 159496 31724 105987 110056 104957 100509 102897 102827 102820 57217 96563	70416 93456 88920 102168 42048 100656 91296 94968 44208 66816 75744 75976 75976 75672 137808 119376 145080 98208	103170 121781 105709 114168 65429 131144 204802 254464 75932 172803 185800 182933 199977 178569 240190 228196 202297 194771	53969 53969 53969 53969 53969 53969 53969 53969 53969 53969 53969 53923 39233 39233 39233 39233 39233 39233 39233 39233 39233	45527 45527 45527 45527 45527 45527 45527 45527 45527 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763	99495 99495 99495 99495 99495 99495 99495 Cost Cost 79996 79996 79996 79996 79996 79996 79996 79996 79996 79996	1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631 148370 82655 3612555 707 707 707 707 707 707 707 707 707
22 23 24 25 25 26 29 30 29 30 5 wm 1 2 2 3 4 4 5 6 6 7 8 9 9 11 12 13	932 887 864 612 955 913 627 726 690 580 580 880 834 834 834 834 837 777 828 931 911 828 931 911 828 931 911 828 932 931 931 836 838 770	578 633 599 844 509 610 677 772 756 772 756 8 762 1262 38 762 1262 38 762 1263 38 700 758 637 711 675 674 829 288 630 956	783 904 827 771 908 822 686 871 901 NE 851 801 780 773 759 773 759 784 801 784 801 784 801 784 801 783 895 895	731 674 605 766 769 830 485 716 837 478 575 614 621 712 640 623 771 712 723 750 649 623 771 723	633 357 295 355 431 303 438 904 Urea 5 581 632 366 513 575 366 513 575 494 702 475 823 663	692 799 692 634 627 693 703 701 701 8 634 558 634 695 731 511 604 628 497 724 564	3090 11433 12463 8137 10661 5562 7416 13081 10352 2266 0 5002 2575 11227 4532 3399 3730 1030 4944 2562	2781 4532 16171 9167 3966 515 7107 7107 74572 126072 0 68186 74160 61697 69319 65518 65508 81473 25750 66126 94554	2678 4120 11021 2163 5923 7210 10300 8 8 8 8 31158 31158 31158 31158 31724 32600 33321 32033 31158 33321 32033 31158 33887 34245 26317 26523 28274 30076	28224 18288 41472 41904 50688 1008 34272	19800 24264 19944 14472 23688 13968 39168 5 30960 38304 0 21168 30096 18432 48384 15696 63216 53424 65808 43344 47088	20160 27864 32040 32544 27792 27072 27072 27072 27072 27072 27072 27072 27072 3024 4208 49680 44208 49680 44208 49686 39024 39624 39624 39624 46368 44640 54072 37728	32754 28325 16789 12000 23381 30488 Amm 113506 159496 31724 105987 105987 105099 102897 102822 108820 57217 96563 130192	70416 93456 88920 102168 42048 100656 91296 94968 44208 66816 75744 77976 94968 7572 137808 119376 145080 98208 128448	103170 121781 105709 114168 65429 131144 204802 254464 75932 172803 185803 185903 189977 178569 240190 228196 202297 194771	53969 53969 53969 53969 53969 53969 53969 53969 53969 53969 53969 53923 39233 39233 39233 39233 39233 39233 39233 39233 39233 39233 39233	45527 45527 45527 45527 45527 45527 45527 45527 45527 45527 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763 40763	99495 99495 99495 99495 99495 99495 99495 Cost Sum 79996 79996 79996 79996 79996 79996 79996 79996 79996 79996 79996	1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764 1108764	126972 110629 92018 108090 99631 148370 148370 82655 3612559 707 707 7165 157366 60495 157366 60495 157366 60495 157366 157367 15737 157367 157367 15737 15737 157577 157577 157577 157577 157577 157577 157577 1575777 1575777 1575777 15757777 157577777777
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22 23 24 25 25 26 27 28 30 Sum 29 30 Sum 29 30 Sum 20 3 4 4 5 5 6 6 7 7 8 9 10 10 10 12 13 14 15 15 16 16 11 11 11 12 12 13 24 22 22 23 24 22 22 22 22 22 22 22 22 22 22 22 22	932 887 8864 612 933 627 726 690 880 883 883 883 883 883 883 883 883 88	578 633 599 844 677 772 775 6 772 775 772 775 772 775 772 775 772 775 772 775 8 772 775 8 772 775 8 772 775 8 772 775 979 979 979 979 979 979 979 979 979	783 904 827 721 827 721 822 686 871 901 901 901 901 901 901 871 873 784 801 773 784 801 773 784 801 773 784 801 773 825 831 857 826 831 773 827 721 839 743 839 845 743 851 743 852 743 851 743 852 743 852 743 851 743 851 743 851 743 851 743 851 743 851 743 851 743 754 743 851 743 754 754 754 754 754 754 755 755 755 755	731 674 605 766 830 830 830 830 830 830 830 830 830 830	633 357 295 355 355 355 355 355 303 303 438 904 904 904 5 5 81 5 5 805 737 823 667 702 737 823 805 737 823 805 737 823 805 805 737 823 805 805 805 805 805 805 805 805 805 805	692 799 692 692 693 703 701 701 701 701 701 701 701 701 701 701	3000 11433 12463 8137 13081 5562 7416 5562 13081	2781 4532 16171 19167 39167 39157 37157 107 7107 7107 7107 7107 0 0 6186 74160 6518 6518 6518 6518 6518 6126 6418 65508 81473 25500 64187 77559 8883 34711 80031 77559 264851 35783 83018 831471 83018 84513 85916 65817	2678 4120 11021 2163 7210 10800 8253 7210 10800 7210 7210 7210 7210 7210 7210 7210 72	28224 18288 41472 41904 50688 34272 50688 16128 50688 0 16128 5068 0 5616 6624 9360 5616 6624 9360 5616 6624 9360 5616 6624 9360 9361 2012 21132 21132 21132 21232 21325 21232 21325 21355 21555 213555 2135555 2135555 2135555 2135555 21355555 2135555 213555555 21355555 213555555 2135555555555	19800 24264 19944 19944 14472 33688 39168 39168 5 30660 38304 0 21168 30096 0 21168 300960 21168 300960 21168 300960 38344 47088 48384 15596 43344 47088 1988 1988 19988 1999 1990 1990	20160 27364 2764 27072 27072 27792 27792 27792 27792 27792 44208 44208 44208 44208 44208 44208 44208 44208 44208 44032 439024 39024 39024 39024 38086 48516 45336 4536 45	32754 28255 16789 12000 117504 113506 103987 11056 103987 110056 103987 1100587 1100587 1100587 100597 100587 100597 100587 100597 1000	70416 93456 88920 102168 88920 102656 91296 91296 91296 94568 44208 44208 44208 44208 44208 44208 44580 94568 113706 8208 112376 44580 92664 1127758 1127758 1127758 1121775758 11217758 1121775758 1121775758 1121775758 1121775757	103170 121781 121781 120570 131165 58429 131144 204802 254464 75932 254464 75932 254464 75932 172803 182803 182803 182933 185806 122794 172803 182937 175601 99877 171922 188801 171923 17192 1719 1719	53969 53969 53969 53969 53969 53969 53969 53969 53969 53969 53969 53969 53969 53969 53973 39733	45527 45527 45527 45527 45527 45527 45527 45527 45527 45527 45527 40763 40765	99495 99495 99495 99495 99495 99495 99495 99495 99495 79996 79996 79996 79996 79996 79996 79996 79996 79996 79996 79996 79996 79996 79996 79996 79996	1108764 110876	126972 110629 92018 108090 99631 148370 82655 Profit 28496 60495 47499 50365 50365 50365 54729 -6892 5103 33322 25482 66939 47499 50365 54729 -6892 5103 31002 25482 68393 37422 25182 66393 37422 25182 66374 64747 44458 64374
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Appendix D Aaaaaa Aaaaaaaa Aaaaaaaaa

Excel programing results of ammonia and urea plant with improved stochastic supply chain under varied production rate (XY 1-6 of 30)

XY1		Ammonia			Urea						Penalty cos	+				Trar	sportation	Cost	Urea		
Day	N	S	NE	N	S	NE	N	S	NE	N	S	NE	Amm	Urea	Sum	Amm	Urea	Sum	cost	Sale	Profit
1	677	762	851	687	581	634	0	0	0	0	0	27600	0	27600	27600	52885	48690	101575	167249	1129916	198259
2	834	1262	801	478	632	558	16171	51500	2575	15048	7344	33072	70246	55464	125710	52885	48690	101575	167249	1129916	100149
3	878	38	790	575	366	634	20703	37286	3142	8064	15480	27600	61131	51144	112274	52885	48690	101575	167249	1129916	113584
4	777	700	773	614	513	692	10300	3193	4017	5256	4896	23424	17510	33576	51086	52885	48690	101575	167249	1129916	174773
5	828	758	759	621	575	706	15553	206	4738	4752	432	22416	20497	27600	48097	52885	48690	101575	167249	1129916	177762
6	987	637	784	712	494	695	31930	6438	3451	3600	6264	23208	41818	33072	74890	52885	48690	101575	167249	1129916	150969
7	790	711	801	640	702	731	11639	2627	2575	3384	17424	20616	16841	41424	58264	52885	48690	101575	167249	1129916	167594
8	911	675	748	623	475	511	24102	4481	5305	4608	7632	36456	33887	48696	82583	52885	48690	101575	167249	1129916	143276
9	825	674	743	771	805	604	15244	4532	5562	12096	32256	29760	25338	74112	99450	52885	48690	101575	167249	1129916	126409
10	888	829	895	723	737	628	21733	6901	4532	5184	22464	28032	33166	55680	88846	52885	48690	101575	167249	1129916	137013
11	782	288	891	750	823	497	10815	24411	4120	9072	34848	37464	39346	81384	120730	52885	48690	101575	167249	1129916	105129
12	836	680	857	694	667	724	16377	4223	618	1008	12384	21120	21218	34512	55730	52885	48690	101575	167249	1129916	170129
13	770	956	822 816	798 701	693	564 607	9579 6798	19982 2987	1494 1803	15984 2016	16128 25128	32640 29544	31055 11588	64752 56688	95806 68275	52885 52885	48690 48690	101575 101575	167249	1129916 1129916	130052 157583
14	815	791 667	642	528	232 588	940	14214	4893	10764	11448	1008	5568	29870	18024	47894	52885	48690	101575	167249	1129916	
15	815	722	1040	779	643	777	13905	2060	19467	13248	8928	17304	35432	39480	74912	52885	48690	101575	167249	1129916	177965 150947
17	935	999	771	653	493	678	26574	24411	4120	2448	6336	24432	55105	33216	88321	52885	48690	101575	167249	1129916	137538
18	776	439	766	676	644	719	10197	16635	4378	792	9072	21480	31209	31344	62553	52885	48690	101575	167249	1129916	163306
19	997	375	743	701	648	570	32960	19931	5562	2016	9648	32208	58453	43872	102324	52885	48690	101575	167249	1129916	123534
20	751	815	842	588	876	736	7622	5459	464	7128	42480	20256	13545	69864	83408	52885	48690	101575	167249	1129916	142450
21	932	625	868	679	486	610	26265	7056	1751	576	6840	29328	35072	36744	71815	52885	48690	101575	167249	1129916	154043
22	887	578	783	613	548	578	21630	9476	3502	5328	2376	31632	34608	39336	73944	52885	48690	101575	167249	1129916	151915
23	864	633	904	731	633	692	19261	6644	5459	6336	7488	23424	31364	37248	68611	52885	48690	101575	167249	1129916	157247
24	612	599	827	674	357	799	3348	8395	1236	936	16128	15720	12978	32784	45762	52885	48690	101575	167249	1129916	180097
25	955	844	721	605	295	692	28634	8446	6695	5904	20592	23424	43775	49920	93695	52885	48690	101575	167249	1129916	132164
26	913	509	908	766	355	634	24308	13030	5871	11376	16272	27600	43209	55248	98456	52885	48690	101575	167249	1129916	127402
27	627	610	822	769	431	627	2575	7828	1494	11808	10800	28104	11897	50712	62608	52885	48690	101575	167249	1129916	163250
28	726	677	686	830	303	693	5047	4378	8498	20592	20016	23352	17922	63960	81882	52885	48690	101575	167249	1129916	143977
29	690	772	871	485	438	703	1339	1030	2060	14544	10296	22632	4429	47472	51901 92019	52885	48690	101575	167249	1129916	173958
30 Sum	580	756	901	716	904	701	4996	309	5150	4176	46512	22776	10455	73464	83918	52885	48690	101575	167249	1129916	141940
XY2		Ammonia			Urea						Penalty cos	t					sportation	Cost	Urea		
Day	N	S	NE	N	S	NE	N	S	NE	N	S	NE	Amm	Urea	Sum	Amm	Urea	Sum	cost	Sale	Profit
1	677	762	851	687	581	634	8086	16971	5150	30096	3672	10944	30206	44712	74918	67803	40109	107912	122070	1042048	101916
2	834	1262	801	478	632	558	0	17559	0	0	0	0	17559	0	17559	67803	40109	107912	122070	1042048	159275
3	878	38	790	575	366	634	4532	54257	567	13968	19152	10944	59355	44064	103419	67803	40109	107912	122070	1042048	73415
4	777	700	773	614	513	692	2936	20164	1442	19584	8568	19296	24541	47448	71989	67803	40109	107912	122070	1042048	104845
5	828 987	758 637	759 784	621 712	575 494	706 695	309 15759	17177 23408	2163 876	20592 33696	4104 9936	21312 19728	19649 40043	46008 63360	65657 103403	67803 67803	40109 40109	107912 107912	122070	1042048 1042048	111177 73431
7	987 790	711	784 801	640	702	731	2266	23408	8/6	23328	10080	24912	21863	58320	80183	67803	40109	107912	122070	1042048	96651
8	911	675	748	623	475	511	7931	21451	2730	20880	11304	3384	32112	35568	67680	67803	40109	107912	122070	1042048	109154
9	825	674	748	771	475 805	604	464	21451 21503	2730	42192	24912	3384 6624	24953	73728	98681	67803	40109	107912	122070	1042048	78153
10	888	829	895	723	737	628	5562	13520	9682	35280	15120	10080	28764	60480	89244	67803	40109	107912	122070	1042048	87590
10	782	288	891	750	823	497	2678	41382	9270	39168	27504	4392	53330	71064	124394	67803	40109	107912	122070	1042048	52440
12	836	680	857	694	667	724	20/8	21194	5768	31104	5040	23904	27168	60048	87216	67803	40109	107912	122070	1042048	89618
13	770	956	822	798	693	564	3296	6980	2163	46080	8784	864	12439	55728	68167	67803	40109	107912	122070	1042048	108667
14	743	791	816	701	232	607	4687	15477	1545	32112	28800	7056	21709	67968	89677	67803	40109	107912	122070	1042048	87157
15	815	667	642	528	588	940	979	21863	8189	7200	3168	55008	31030	65376	96406	67803	40109	107912	122070	1042048	80428
16	812	722	1040	779	643	777	1133	19031	24617	43344	1584	31536	44781	76464	121245	67803	40109	107912	122070	1042048	55589
17	935	999	771	653	493	678	10403	4765	1545	25200	10008	17280	16713	52488	69201	67803	40109	107912	122070	1042048	107633
18	776	439	766	676	644	719	2987	33605	1803	28512	1728	23184	38395	53424	91819	67803	40109	107912	122070	1042048	85015
19	997	375	743	701	648	570	16789	36901	2987	32112	2304	1728	56677	36144	92821	67803	40109	107912	122070	1042048	84013
20	751	815	842	588	876	736	4275	14241	4223	15840	35136	25632	22739	76608	99347	67803	40109	107912	122070	1042048	77487
21	932	625	868	679	486	610	10094	24026	6901	28944	10512	7488	41021	46944	87965	67803	40109	107912	122070	1042048	88869
22	887	578	783	613	548	578	5459	26447	927	19440	6048	2880	32833	28368	61201	67803	40109	107912	122070	1042048	115633
23	864	633	904	731	633	692	3090	23614	10609	36432	144	19296	37313	55872	93185	67803	40109	107912	122070	1042048	83649
24	612	599	827	674	357	799	11433	25365	2678	28224	19800	34704	39476	82728	122204	67803	40109	107912	122070	1042048	54630
25	955	844	721	605	295	692	12463	12748	4120	18288	24264	19296	29331	61848	91179	67803	40109	107912	122070	1042048	85655
26	913	509	908	766	355	634	8137	30000	11021	41472	19944	10944	49158	72360	121518	67803	40109	107912	122070	1042048	55316
27	627	610	822	769	431	627	10661	24799 21348	2163	41904	14472	9936	37622	66312	103934	67803	40109	107912 107912	122070	1042048	72900
28	726 690	677 772	686 871	830 485	303 438	693 703	5562 7416	21348	5923 7210	50688 1008	23688 13968	19440 20880	32833 31082	93816 35856	126649 66938	67803 67803	40109 40109	107912	122070 122070	1042048 1042048	50185 109896
30	580	756	901	485	438 904	703	13081	16456	10300	34272	39168	20880	40661	94032	134693	67803	40109	107912	122070	1042048	42141
Sum	500	, 50	551	,10	304	701	10001	1,200	10300	37212	33100	20332	40301	5-4332	10000	0,000	40105	10,312	1110/0	20-2040	2582525
_		_	_									_	_	_		_	_			_	í
XY3 Day	N	Ammonia	NE	N	Urea	NE	N	S	NE	N	Penalty cos	t NE	Amm	Urea	Sum	Tran Amm	urea	Cost Sum	Urea	Sale	Profit
Day 1	677	762	NE 851	687	581	634	10352	5 74572	6283	N 16128	30960	110608	91207	157696	248903	Amm 32827	50354	83180	227691	1247469	52462
2	834	1262	801	478	632	558	2266	126072	1133	6984	38304	116080	129471	161368	290839	32827	50354	83180	227691	1247469	10526
3	878	38	790	575	366	634	0	0	0	0	0	110608	0	110608	110608	32827	50354	83180	227691	1247469	190757
4	777	700	773	614	513	692	5202	68186	876	5616	21168	106432	74263	133216	207479	32827	50354	83180	227691	1247469	93886
5	828	758	759	621	575	706	2575	74160	1597	6624	30096	105424	78332	142144	220476	32827	50354	83180	227691	1247469	80889
6	987	637	784	712	494	695	11227	61697	309	19728	18432	106216	73233	144376	217609	32827	50354	83180	227691	1247469	83756
7	790	711	801	640	702	731	4532	69319	1133	9360	48384	103624	74984	161368	236352	32827	50354	83180	227691	1247469	65013
8	911	675	748	623	475	511	3399	65611	2163	6912	15696	119464	71173	142072	213245	32827	50354	83180		1247469	88120
9	825	674	743	771	805	604	2730	65508	2421	28224	63216	112768	70658	204208	274866	32827	50354	83180		1247469	26499 22271
10	888 782	829 288	895 891	723 750	737 823	628 497	1030 4944	81473 25750	10815 10403	21312 25200	53424 65808	111040 120472	93318 41097	185776 211480	279094 252577	32827 32827	50354 50354	83180 83180	227691 227691		22271 48788
11 12		288	891 857	750 694			4944 2163	25750 66126	10403 6901	17136	43344	120472	41097	211480	252577	32827	50354	83180 83180	227691		48/88 61567
12	836 770	956	857	798	667 693	724 564	5562	94554	3296	32112	43344 47088	104128	103412	194848	239798	32827	50354	83180	227691	1247469	3105
13	743	791	816	798	232	607	6953	77559	2678	18144	9648	112552	87190	194848	298200	32827	50354	83180	227691	1247469	73831
15	815	667	642	528	588	940	3245	64787	7622	3384	31968	88576	75654	123928	199582	32827	50354	83180	227691		101783
16	813	722	1040	779	643	777	3399	70452	25750	29376	39888	100312	99601	169576	269177	32827	50354	83180	227691	1247469	32188
17	935	999	771	653	493	678	5871	98983	979	11232	18288	107440	105833	136960	242793	32827	50354	83180	227691		58572
18	776	439	766	676	644	719	5253	41303	1236	14544	40032	104488	47792	159064	206856	32827	50354	83180	227691	1247469	94509
19	997	375	743	701	648	570	12257	34711	2421	18144	40608	115216	49389	173968	223357	32827	50354	83180	227691	1247469	78008
20	751	815	842	588	876	736	6541	80031	5356	1872	73440	103264	91928	178576	270504	32827	50354	83180	227691	1247469	30861
21	932	625	868	679	486	610	5562	60461	8034	14976	17280	112336	74057	144592	218649	32827	50354	83180	227691	1247469	82716
22	887	578	783	613	548	578	927	55620	361	5472	26208	114640	56908	146320	203228	32827	50354	83180	227691	1247469	98137
23	864	633	904	731	633	692	721	61285	11742	22464	38448	106432	73748	167344	241092	32827	50354	83180	227691		60273
24	612	599	827	674	357	799	13699	57783	3811	14256	648	98728	75293	113632	188925	32827	50354	83180	227691		112440
25	955	844	721	605	295	692	7931	83018	3554	4320	5112	106432	94503	115864	210367	32827	50354	83180	227691		90998
	913	509	908	766	355	634	3605	48513	12154	27504	792	110608	64272	138904	203176	32827	50354	83180	227691		98189
26			822	769	431	627	12927	58916	3296	27936	9360	111112	75139	148408	223547	32827	50354	83180	227691	1247469	77818
27	627	610																	·		
27 28	627 726	677	686	830	303	693	7828	65817	5356	36720	4536	106360	79001	147616	226617	32827	50354	83180	227691	1247469	74748
27 28 29	627 726 690	677 772	686 871	830 485	303 438	703	9682	75602	8343	6480	10368	105640	93627	122488	216115	32827	50354	83180	227691	1247469	85250
27 28	627 726	677	686	830	303														227691		

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