Subsea Engineering

Yutaek Seo
Subsea pipelines

• Normally, the term “subsea flowlines” is used to describe the subsea pipelines carrying oil and gas products from the wellhead to the riser foot.
Pipeline Route Selection

- When layout the field architecture, several considerations should be accounted for:
  - Compliance with regulation authorities and design codes
  - Future field development plan
  - Environment, marine activities, and installation method (vessel availability)
  - Overall project cost
  - Seafloor topography
  - Interface with existing subsea structures
Pipeline Route Curve Radius

- The required minimum pipeline route curve radius ($R_s$) should be determined to prevent slippage of the curved pipeline on the sea floor while making a curve in accordance with the formula.

$$R_s = L_s = \frac{F T_H}{W_s \mu}$$

- If the pipeline-soil friction resistance is too small, the pipeline will spring-back to straight line.
• The formula also can be used to estimate the required minimum straight pipeline length ($L_s$), before making a curve, to prevent slippage at initiation.

• If $L_s$ is too short, the pipeline will slip while the curve is being made.
Pipeline Route Survey

• Once the field layout and pipeline route is determined by desktop study using an existing field map, the pipeline route needs to be surveyed.

• The survey company is contracted to obtain site-specific information including bathymetry, seabed characteristics, soil properties, stratigraphy, geohazards, and environmental data.

• Bathymetry (hydrographic) survey using echo sounders provides water depths (sea bottom profile) over the pipeline route.

• The new technology of 3-D bathymetry map shows the sea bottom configuration more clearly than the 2-D bathymetry map.
Subsea pipelines burst

Figure A.1—Ductile Burst Sample
Figure A.2—Brittle Burst Sample
Pipeline on-bottom stability design

- Waves and steady currents subject the pipeline on the seabed to drag, lift, and inertia forces.
- To keep the pipeline stable, the soil resistance should be greater than the hydrodynamic force induced on the pipeline.

Figure 13.1 Forces acting on the pipeline resting on the seabed.
• The traditional method of pipeline stability is given by the following:

\[\mu(W_s - F_L) \geq (F_D + F_l)\]

\[\frac{\mu(W_S - F_l)}{F_T} > 1\]

where

\(\mu\) = soil-pipe friction
\(W_S\) = submerged weight
\(F_l\) = lift force
\(F_T\) = total horizontal force from waves and currents

• In general, the larger the submerged weight, the higher the frictional resistance.

• However, later methods for determining the stability include the depth of embedment of the pipeline. Additional resistance is provided by the soil and reduces the required submerged weight of the pipeline.
Drag force

- Drag and Inertia forces act together laterally on the pipeline.
- The drag force due to water particle velocities is given by

\[ F_d = \frac{1}{2} \rho C_D D (U + V)^2 \]

where

- \( F_d \) = drag force/unit length
- \( \rho \) = mass density of seawater
- \( C_D \) = drag coefficient
- \( D \) = outside diameter of pipeline (including the coatings)
- \( U \) = water particle velocity due to waves
- \( V \) = steady current

\( C_D \) is 0.7 from DNV 1981 Pipeline Design Guidelines
Lift force

• Lift force, $F_L$, acting vertically tends to reduce the submerged weight of the pipeline.

$$F_L = \frac{1}{2} \rho_w D C_L V^2$$  \hspace{1cm} \text{Lift Force}

Where, $\rho_w$ is the water mass density (64 lb/ft$^3$)

$V$ is the near-bottom wave & current velocity ($=U+V$)

$D$ is the outside diameter of pipeline (including coating)

$C_L$ is the lift coefficient

($= 0.9$ from DNV 1981 Pipeline Design Guidelines)
Inertia force

- The inertia force due to water particle acceleration is given by

\[ F_i = \rho C_M \frac{\pi D^2}{4} \left( \frac{du}{dt} \right) \]

where

- \( F_i \) = inertia force/unit length
- \( \rho \) = mass density of seawater
- \( C_M \) = drag coefficient
- \( D \) = outside diameter of pipeline (including the coatings)
- \( \frac{du}{dt} \) = water particle acceleration due to waves

\( C_M \) is 3.29 from DNV 1981 Pipeline Design Guidelines)
Determining hydrodynamic coefficients

- The hydrodynamic coefficients $C_D$, $C_L$, and $C_M$ given in DNV 1981 Pipeline Design Guidelines are 0.7, 0.9, and 3.29, respectively.
- However, it is possible to use to determine the values of these coefficients with respect to $Re$ for steady current and Keulegan-Carpenter number for steady currents combined with wave-induced currents.
Pipeline coating

Corrosion coating
• Inner surface of the pipe is not typically coated but if erosion or corrosion protection is required, fusion bonded epoxy (FBE) coating or plastic liner is applied.
• Outer surface of the carbon steel line pipes are typically coated with corrosion resistant FBE or neoprene coating.
• The three layer polypropylene (3LPP), three layer polyethylene (3LPE), or multi-layer PP or PE is used for reeled pipes to provide abrasion resistance during reeling and unreeling process.
Insulation coating

• To keep the conveyed fluid warm, the pipeline should be heated by active or passive methods.
• The active heating methods include, electric heat tracing wires wrapped around the pipeline, circulating hot water through the annulus of pipe-in-pipe, etc.
• The passive heating method is insulation coating, burial, covering, etc. Glass syntactic polyurethane (GSPU), PU foam, and syntactic foam commonly are the commonly used subsea insulation materials.
• Although these insulation materials are covered (jacketed) with HDPE, they are compressed due to hydrostatic head and migrated by water as time passes, so it is called a “wet” insulation
U-value

- Figure 14-4 shows the temperature distribution of a cross section for a composite subsea pipeline with two insulation layers.
The OHTC or U value can be obtained using the formula below:

\[
U = \frac{1}{\frac{1}{h_1} + \frac{r_1}{K_1} \ln \left( \frac{r_2}{r_1} \right) + \frac{r_1}{K_2} \ln \left( \frac{r_3}{r_2} \right) + \cdots + \frac{r_1}{K_{m-1}} \ln \left( \frac{r_m}{r_{m-1}} \right) + \frac{r_1}{r_m h_m}}
\]

Where,
- \( h_1 \) = internal surface convective heat transfer coefficient,
- \( h_m \) = external surface convective heat transfer coefficient,
- \( r \) = radius to each component surface,
- \( K \) = thermal conductivity of each component
• The terms on the right hand side of the above equation represent the heat transfer resistance due to internal convection, conduction through steel well of pipe, conduction through insulation layers and convection at the external surface.

• They can be expressed as follows.

\[ R_{\text{film,in}} = \frac{1}{h_i A_i} \]  
\[ (14-29) \]

\[ R_{\text{pipe}} = \frac{\ln(r_i/r_i)}{2\pi L k_{\text{pipe}}} \]  
\[ (14-30) \]

\[ \sum R_{\text{coating}} = \frac{\ln(r_{no}/r_{ni})}{2\pi L k_n} \]  
\[ (14-31) \]

\[ R_{\text{film,ext}} = \frac{1}{h_o A_o} \]  
\[ (14-32) \]
Heating

- Direct electrical heating
  - Allow production of fields that earlier is considered as not feasible
  - Effective solution with high heat input
  - Easy to install and operate
  - Reliable components
  - Can be retrofitted on pipelines in operation
  - Implementation require minor modification
  - The running costs are considerably reduced compared to traditional methods utilizing chemicals
Pipeline installation

- The four pipeline installation methods

- Trailing Tow Boat
- Tow Line
- Lead Tow Boat
- Tow Line
- TOWING (near-bottom tow) (bottom tow, mid-depth tow, and surface tow) Buoys and Drag Chains

- S-LAY

- J-LAY

- REEL-LAY
(1) Towing

- Made up of a carrier pipe (up to 60” to date) with several components (bundle) inside near beach
- Limitations on length that can be fabricated (beach size limit) and installed (towing limit)
- Carrier pipe provides a corrosion free environment internally
- Requires several support vessels (cheaper ones than S/J/Reel-lays)
(2) S-Lay

• Pipeline is fabricated on the vessel using single, double, or triple joints.
• Requires a “stinger” up to 100m long, either single section or two/three articulated sections.
• Deeper water requires longer stinger and higher tension resulting in more risk.
• Typical lay rate is approximately 3.5km per day.
• Maximum installable pipe size is 60”OD by AllSeas Solitaire.
• S-Lay configuration
• S-Lay tensioner and stinger
(3) J-Lay

• Welding is done on vessel, but at one station, so is slower
• Pipe has a departure angle very close to vertical, so less tension is required
• Principal application is for deep water
• Stinger is not required
• Typical lay rate is approximately 1 - 1.5 km per day
• Maximum installable pipe size is 32”OD by Saipem S-7000
• J-Lay configuration

- Traveling tensioner
- J-lay tower
- Fixed tensioner
- Welding/inspection station
- Triple or quadruple joints (120-ft or 160-ft) with a collar installed in the middle of the last joint
- Installation Vessel
- Rollers
• Welding station and tensioner
• There are multiple welding stations in S-lay, depending on pipe size and pipe WT. Therefore, it is important to control the time spending at each station.

• If one station spends 10 minutes while the others spend 5 minutes, the pipe lay rate is reduced by 50%.

• For example, if each station takes 7 minutes to connect one pipe joint (40 ft), the lay rate would be 1.6 miles per day as below:

\[
\frac{(24 \times 60 \text{ min/day})}{(7 \text{ min/40 ft})} = 8,230 \text{ ft/day} = 1.6 \text{ miles/day}
\]

• The J-lay has only one welding station but can weld multiple pipe joints such as triple to hex joints (120 ft to 240 ft).
(4) Reel-Lay

- Pipe welded onshore in a controlled environment and spooled onto vessel in continuous length until complete or maximum capacity is reached.
- Much lower tension and therefore more control than S lay.
- Limited on coating types – no concrete coating or stiff insulation coating.
- Limitations on reeling capacity by volume or weight.
- Typical lay rate is 14 km per day.
• Pipeline Installation Vessel (S-Lay)
• Pipeline Installation Vessel (J-Lay)
• Pipeline Installation Vessel (Reel-Lay)

Subsea 7, Skandi Navica (Reel-lay)
<table>
<thead>
<tr>
<th>Contractor</th>
<th>Vessel</th>
<th>Tension capacity</th>
<th>Max. pipe OD</th>
<th>Max. water depth (ft)</th>
<th>Lay method</th>
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<tr>
<td>Allseas</td>
<td>Lorelay</td>
<td>360</td>
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<td>J / Reel</td>
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<td></td>
<td>Seven Oceans</td>
<td>880</td>
<td>16</td>
<td>?</td>
<td>Reel</td>
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# Subsea Systems Cost Estimation

- **URF**

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<thead>
<tr>
<th>Description</th>
<th>Cost (US$)</th>
<th>Basis</th>
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<tbody>
<tr>
<td>CRA Material Cost – 316L</td>
<td>5,100-6,300</td>
<td>Per tonne, 4” to 26”</td>
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<tr>
<td>CRA Material Cost – 825</td>
<td>7,600-10,080</td>
<td>Per tonne, 4” to 32”</td>
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<tr>
<td>Carbon Steel Material Cost</td>
<td>1,300</td>
<td>Per tonne, all sizes</td>
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<td>Insulation Coating</td>
<td>333,000-794,000</td>
<td>Per km, for 12” to 32”</td>
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<td>Manifolds</td>
<td>2.8-5.2 Million</td>
<td>4 slot to 10 slot</td>
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<td>Infield Gathering Manifold (18”)</td>
<td>8.8 Million</td>
<td>6 x 18” tie-ins.</td>
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<td>Umbilical</td>
<td>$170-$310 per m</td>
<td>2-10 well cluster sizes</td>
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<td>12” Flexible Riser</td>
<td>2.4 Million</td>
<td>Complete with ancillaries</td>
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<td>Riser Bases</td>
<td>1.0-3.2 Million</td>
<td>4” to 26”</td>
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<td>PLETs</td>
<td>0.2-4.7 Million</td>
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<td>Main Jumpers</td>
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<td>Well Jumpers – Solid Duplex</td>
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<td>6”-8”, included Multiphase Meter</td>
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• Subsea tree CAPEX

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<td>Tubing Hanger System</td>
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<td>Choke Module</td>
<td>3,332,604</td>
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<td>Flowline Support Base</td>
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<td>Wellhead System</td>
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<td><strong>Total</strong></td>
<td><strong>8,700,000</strong></td>
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• Subsea tree Intervention

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<tr>
<th>Type of Intervention</th>
<th>Intervention Costs (AU$M) Based on Rig Spread of AU$890k/day</th>
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<td>Vertical System</td>
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<tr>
<td>Through Tubing Intervention</td>
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<td>Tree Replacement</td>
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<td>Tubing Replacement</td>
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<td>Sidetrack</td>
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## Subsea Installation Cost Estimation

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<th>Description</th>
<th>Cost (US$)</th>
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<tr>
<td>Lay Barge</td>
<td>450,000</td>
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<td>Lay Barge Mob/demob</td>
<td>15 million</td>
<td>Per Campaign</td>
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<tr>
<td>MSV</td>
<td>200,000</td>
<td>Per Day</td>
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<tr>
<td>MSV Mob/demob</td>
<td>4 Million</td>
<td>Per Campaign</td>
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<td>Survey</td>
<td>1,000,000</td>
<td>Per Campaign</td>
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<td>CRA Pipelay rates</td>
<td>0.8-1.8</td>
<td>km/day, 36” – 4”</td>
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<tr>
<td>Carbon Steel Pipelay Rates</td>
<td>2.3-4.5</td>
<td>km/day, 36” – 4”</td>
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Pipeline Protection

Trenching and Burial

• The offshore pipelines are trenched for such conditions and requirements as:
  - Physical protection from anchor dropping or trawl dragging
  - On-bottom stability
  - Approval authorities

• The open trench could be covered by natural sedimentation depending on soil conditions and currents near sea bottom.

• However, backfilling after the trenching or burial is required for additional protection and thermal insulation purposes.
• Trenching equipment should be selected based on sea floor soil conditions. Followings are available trenching equipment in the industry:
  - Ploughing – all types of soil
  - Jetting – sand and soft clay
  - Mechanical digging & cutting – stiff clay and rock
  - Dredging – all types of soil
• Trenching Equipment

(a) Plough

(b) Water Jet Trencher

(c) Mechanical Trencher

(d) Dredger
• Burial could be done by backfilling the soil by cutting each top side of the open trench using the same jet trencher used for trenching.

• Without burial, pipelines can be covered with rocks or concrete mattress. This method is good for a pipeline laid on a hard rock sea bottom which is difficult to be buried.
Flexible Riser: Rough-bore Pipe with Carcass

- Carcass (Stainless Steel)
  - External Pressure Resistance

- Internal Sheath (Polymer)
  - Internal Fluid Containment Barrier

- Pressure Armor (Carbon Steel)
  - Hoop Load Resistance

- Tensile Armor (Carbon Steel)
  - Tensile Load Resistance

- External Sheath (Polymer)
  - External Fluid Barrier
Flexible Riser configurations

- Free-Hanging Configuration
- S Configuration
- Wave Configuration
- Free Hanging Catenary
- Lazy-S
- Lazy Wave
- Pliant Wave® (Tethered)
- Steep-S
- Steep Wave
- Steep
Buoyancy devices

• Distributed – lazy wave and steep wave configurations
  - Configuration achieved by buoyancy modules
  - Manufacturers include
    : Trelleborg CRP Ltd
    : Flotech
    : Emerson Cuming

• Concentrated – lazy S and steep S configurations
  - Configuration achieved by tether buoy
  - Manufacturers include
    : Trelleborg CRP Ltd
Distributed buoyancy

- Steep-wave
- Lazy-wave
- Pliant wave
- Floatation attached to riser resulting desired riser configuration
- Buoyancy Supplied by discrete modules
- Clamps required for buoyancy module to make connection to pipe
• Buoyancy Module
  - 2 half shells
  - Held in place by clamp
  - Half shells strapped together over clamp
  - Profiled to avoid overbending of riser
• Design consideration
  - Usually syntactic foam
  - Net buoyancy requirement
    : output from configuration design
  - Clamping
    : Module slippage can alter configuration
  - Gradual loss of buoyancy over time
  - Clashing
Concentrated buoyancy

- Concentrated buoyancy
  - Steep-S
  - Lazy-S
- Design considerations
  - Usually pressurized steel tanks
  - Buoyancy requirement: ensure taut in all internal fluid conditions
  - Compartmentalized buoyancy tanks: Redundancy
- Tether hold-down arrangement
- Gutter to prevent interference
• Subsea Arch
Pressure vs. ID
Thank you!