



**Australian Government**

# **PMAOPS326 Operate gas absorption unit**

**Release: 1**

# PMAOPS326 Operate gas absorption unit

## Modification History

Release 1. Supersedes and is equivalent to PMAOPS326B Produce product using gas absorption

## Application

This unit of competency covers the skills and knowledge required to operate and monitor a gas absorption unit and ancillary equipment to produce product.

Gas absorption units may be glycol dehydration, CO<sub>2</sub> absorption or similar fluid/fluid absorption units.

This unit of competency includes all such items of equipment and unit operations which form part of the gas absorption system. A unit/system comprises two or more components of plant/equipment that are operated together to produce product, including as appropriate to the facility:

- heat exchangers, coolers and cooling systems
- turbines, including low speed operations (LSO), relay oil and governing
- pumps and filters
- valves
- regeneration or top-up systems
- columns, towers
- vessels.

This unit of competency applies to operations technicians who are required to demonstrate a significant understanding of the process and the equipment operation in order to identify and rectify operational problems, perform isolations, start-up and shutdown procedures and operate, monitor and maintain equipment.

This unit of competency applies to an individual operating independently in a plant with local control or in liaison with the control room operator in a plant with a centralised control panel, such as distributed control system (DCS) type controls. In the case of large complex plant, the operations technician would be part of a team during start-up and shutdown procedures.

This unit of competency applies to an individual working alone or as part of a team or group and working in liaison with other shift team members and the control room operator, as appropriate.

This unit of competency does not require the operation of a central control panel.

No licensing, legislative or certification requirements apply to this unit at the time of publication.

## Pre-requisite Unit

Nil

## Competency Field

Operations

## Unit Sector

## Elements and Performance Criteria

Elements describe the essential outcomes.

Performance criteria describe the performance needed to demonstrate achievement of the element.

- |   |                                                           |     |                                                                                                  |
|---|-----------------------------------------------------------|-----|--------------------------------------------------------------------------------------------------|
| 1 | <b>Prepare for work</b>                                   | 1.1 | Receive and give shift handover                                                                  |
|   |                                                           | 1.2 | Identify work requirements                                                                       |
|   |                                                           | 1.3 | Identify and control hazards                                                                     |
|   |                                                           | 1.4 | Coordinate with appropriate personnel                                                            |
|   |                                                           | 1.5 | Check for recent work undertaken on gas absorber                                                 |
|   |                                                           | 1.6 | Note any outstanding/incomplete work                                                             |
|   |                                                           | 1.7 | Check operational status of gas absorber                                                         |
|   |                                                           |     |                                                                                                  |
| 2 | <b>Operate gas absorber in accordance with procedures</b> | 2.1 | Describe the type of gas absorber, the component plant items and their duties                    |
|   |                                                           | 2.2 | Complete routine checks, logs and paperwork taking action on unexpected readings                 |
|   |                                                           | 2.3 | Select the appropriate medium for the stripping and rectification of the product                 |
|   |                                                           | 2.4 | Recover all products from the medium by skimming, as necessary                                   |
|   |                                                           | 2.5 | Top up and drain medium used in the process as required to maintain operating levels             |
|   |                                                           | 2.6 | Adjust gas absorber and its component plant items to their type and duty to maximise performance |

- |     |                                                                                                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |     |                                                                                                                                        |     |                                                                                                         |     |                                                                                                                                  |     |                                                                     |     |                                                 |     |                                                                                                                                          |     |                                                                    |
|-----|------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----|----------------------------------------------------------------------------------------------------------------------------------------|-----|---------------------------------------------------------------------------------------------------------|-----|----------------------------------------------------------------------------------------------------------------------------------|-----|---------------------------------------------------------------------|-----|-------------------------------------------------|-----|------------------------------------------------------------------------------------------------------------------------------------------|-----|--------------------------------------------------------------------|
| 3   | <b>Diagnose and take action on abnormal situations in accordance with procedures</b>                                                     | <table border="0"><tr><td style="vertical-align: top; padding-right: 20px;">3.1</td><td>Monitor gas absorber and its component plant items frequently and critically throughout shift using measured/indicated data and senses</td></tr><tr><td style="vertical-align: top; padding-right: 20px;">3.2</td><td>Monitor vapour pressures to ensure that product remains on specification</td></tr><tr><td style="vertical-align: top; padding-right: 20px;">3.3</td><td>Describe impacts of any changes upstream and downstream</td></tr><tr><td style="vertical-align: top; padding-right: 20px;">3.4</td><td>Recognise actual and developing situations which may require action</td></tr><tr><td style="vertical-align: top; padding-right: 20px;">3.5</td><td>Apply operational knowledge to resolve problems</td></tr><tr><td style="vertical-align: top; padding-right: 20px;">3.6</td><td>Take other actions on abnormal situations which cannot be resolved during the shift to ensure safety and the resolution of the situation</td></tr><tr><td style="vertical-align: top; padding-right: 20px;">3.7</td><td>Follow through items initiated until final resolution has occurred</td></tr></table> | 3.1 | Monitor gas absorber and its component plant items frequently and critically throughout shift using measured/indicated data and senses | 3.2 | Monitor vapour pressures to ensure that product remains on specification                                | 3.3 | Describe impacts of any changes upstream and downstream                                                                          | 3.4 | Recognise actual and developing situations which may require action | 3.5 | Apply operational knowledge to resolve problems | 3.6 | Take other actions on abnormal situations which cannot be resolved during the shift to ensure safety and the resolution of the situation | 3.7 | Follow through items initiated until final resolution has occurred |
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| 3.4 | Recognise actual and developing situations which may require action                                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |     |                                                                                                                                        |     |                                                                                                         |     |                                                                                                                                  |     |                                                                     |     |                                                 |     |                                                                                                                                          |     |                                                                    |
| 3.5 | Apply operational knowledge to resolve problems                                                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |     |                                                                                                                                        |     |                                                                                                         |     |                                                                                                                                  |     |                                                                     |     |                                                 |     |                                                                                                                                          |     |                                                                    |
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| 3.7 | Follow through items initiated until final resolution has occurred                                                                       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |     |                                                                                                                                        |     |                                                                                                         |     |                                                                                                                                  |     |                                                                     |     |                                                 |     |                                                                                                                                          |     |                                                                    |
| 4   | <b>Isolate and de-isolate gas absorber and its component plant items</b>                                                                 | <table border="0"><tr><td style="vertical-align: top; padding-right: 20px;">4.1</td><td>Complete any required pre-start checks</td></tr><tr><td style="vertical-align: top; padding-right: 20px;">4.2</td><td>Start up/shut down gas absorber according to the absorber type and duty in liaison with other personnel</td></tr><tr><td style="vertical-align: top; padding-right: 20px;">4.3</td><td>Start up/shut down/changeover component plant items within unit according to their type and duty in liaison with other personnel</td></tr><tr><td style="vertical-align: top; padding-right: 20px;">4.4</td><td>Isolate entire absorber and/or any component plant item</td></tr><tr><td style="vertical-align: top; padding-right: 20px;">4.5</td><td>Make safe for required work</td></tr><tr><td style="vertical-align: top; padding-right: 20px;">4.6</td><td>Check absorber/plant item is ready to be returned to service</td></tr><tr><td style="vertical-align: top; padding-right: 20px;">4.7</td><td>De-isolate and prepare absorber/plant item for return to service</td></tr></table>                                                                                                       | 4.1 | Complete any required pre-start checks                                                                                                 | 4.2 | Start up/shut down gas absorber according to the absorber type and duty in liaison with other personnel | 4.3 | Start up/shut down/changeover component plant items within unit according to their type and duty in liaison with other personnel | 4.4 | Isolate entire absorber and/or any component plant item             | 4.5 | Make safe for required work                     | 4.6 | Check absorber/plant item is ready to be returned to service                                                                             | 4.7 | De-isolate and prepare absorber/plant item for return to service   |
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| 4.5 | Make safe for required work                                                                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |     |                                                                                                                                        |     |                                                                                                         |     |                                                                                                                                  |     |                                                                     |     |                                                 |     |                                                                                                                                          |     |                                                                    |
| 4.6 | Check absorber/plant item is ready to be returned to service                                                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |     |                                                                                                                                        |     |                                                                                                         |     |                                                                                                                                  |     |                                                                     |     |                                                 |     |                                                                                                                                          |     |                                                                    |
| 4.7 | De-isolate and prepare absorber/plant item for return to service                                                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |     |                                                                                                                                        |     |                                                                                                         |     |                                                                                                                                  |     |                                                                     |     |                                                 |     |                                                                                                                                          |     |                                                                    |

## **Foundation Skills**

This section describes those language, literacy, numeracy and employment skills that are essential to performance.

Foundation skills essential to performance are explicit in the performance criteria of this unit of competency.

## Range of Conditions

This field allows for different work environments and conditions that may affect performance. Essential operating conditions that may be present (depending on the work situation, needs of the candidate, accessibility of the item, and local industry and regional contexts) are included.

### **Regulatory framework**

The latest version of all legislation, regulations, industry codes of practice and Australian/international standards, or the version specified by the local regulatory authority, must be used, and include one or more of the following:

- legislative requirements, including work health and safety (WHS)
- industry codes of practice and guidelines
- environmental regulations and guidelines
- Australian and other standards
- licence and certification requirements

All operations to which this unit applies are subject to stringent health, safety and environment (HSE) requirements, which may be imposed through state/territory or federal legislation, and these must not be compromised at any time. Where there is an apparent conflict between performance criteria and HSE requirements, the HSE requirements take precedence.

### **Hazards**

Hazards include one or more of the following:

- electricity
- gas
- gases and liquids under pressure
- structural hazards
- structural collapse
- equipment failures
- industrial (machinery, equipment and product)
- equipment or product mass
- noise, rotational equipment or vibration
- plant services (steam, condensate and cooling water)
- working at heights, in restricted or confined spaces, or in environments subjected to heat, noise, dusts or vapours
- flammability and explosivity
- hazardous products and materials
- unauthorised personnel
- sharp edges, protrusions or obstructions
- slippery surfaces, spills or leaks
- extreme weather
- other hazards that might arise

**Routine problems**

Routine problems include one or more of the following:

- variation/loss of feed
- unstable control of pressure, temperature level and flows
- control equipment failure
- process plant trips
- change in atmospheric conditions (rain, temperature, wind and lightning)
- medium contamination (acidic - pH, solids, water content and hydrocarbon content)
- poor regeneration (flow/heat/cooling)
- analyser inaccuracy/malfunction

**Non-routine problems**

Non-routine problems are unexpected problems, or variations of previous problems and must be resolved by applying operational knowledge to develop new solutions, either individually or in collaboration with relevant experts, to:

- determine problems needing action
- determine possible fault causes
- develop solutions to problems which do not have a known solution
- follow through items initiated until final resolution has occurred
- report problems outside area of responsibility to designated person

Operational knowledge includes one or more of the following:

- procedures
- training
- technical information such as journals, engineering specifications
- remembered experience
- relevant knowledge obtained from appropriate people
- 

**Start up/shut down**

Start up/shut down includes the following:

- start up and shut down to/from normal operating conditions
- start up and shut down to/from isolated, cold or empty
- start up and shut down to/from other conditions/situations experienced on the plant

**Procedures**

All operations must be performed in accordance with relevant procedures.

Procedures are written, verbal, visual, computer-based or in some other form,

include one or more of the following:

- emergency procedures
- work instructions
- standard operating procedures (SOPs)
- safe work method statements (SWMS)
- formulas/recipes
- batch sheets
- temporary instructions
- any similar instructions provided for the smooth running of the plant

**Operate** Operate is to monitor, adjust/make change to the production unit and/or its component items to meet specifications, by one or both of the following:

- manually in the plant
- using local controller in the plant

**Product** Product includes anything produced by a process step and so includes:

- intermediate products, such as the product from one process step, which then becomes the feed for another

## Unit Mapping Information

Release 1. Supersedes and is equivalent to PMAOPS326B Produce product using gas absorption

## Links

MSA Training Package Implementation Guides - <http://mskills.org.au/training-packages/info/>