LNG Propulsion System as Shipyard's Perspective

DSME DAEWOO SHIPBUILDING & MARINE ENGINEERING CO., LTD.

LNG Fuel Forum
20 Sep. 2011

CONTENTS

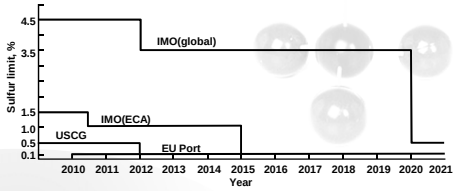
Background

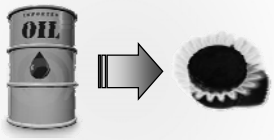
❑ Emission Regulations

• NOx Regulation by IMO
(MARPOL Annex VI, Regulation 13)

Tier	Construction date on or after	g/kWh (RPM<130)
I	1 January 2000	17.0
II	1 January 2011	14.4
III	1 January 2016	3.4

• SOx Regulation by IMO
(MARPOL Annex VI, Regulation 14)



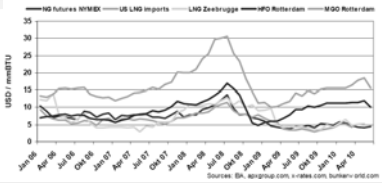


❑ Fuel Price

• Recent Gas & Ship Fuel Price (06 May. 2011)

Fuel	Price	
	($/ton)	($/MMBTU)
HFO (IFO380) @ Singapore	624	16.2
MGO @ Singapore	941	24.5
NG @ Henry Hub	218	4.6

• Gas & Ship Fuel Price (Jan. 2006 ~ Apr. 2010)



Global LNG Fueled Ships (small size)

Vessel	Storage	Year	
A few small ships with CNG	CNG (Compressed Natural Gas)	1982 ~ 1990s	
Glutra (car & passenger ferry)	LNG (2 x 32m^3)	2000	
Viking Energy (platform supply vessel) (+ 1 sister ships)	LNG (1 x 234m^3)	2003	
BergensFjord (car & passenger ferry) (+ 4 sister ships)	LNG (2 x 125m^3)	2007	
Kystvakt (coast guard ship) (+ 2 sister ships)	LNG (1 x 234m^3)	2009	
Moldefjord (car & passenger ferry) (+ 2 sister ships)	LNG (2 x 125m^3)	2009	
Viking Queen (platform supply vessel) (+ 1 sister ships)	LNG (1 x 234m^3)	2009	

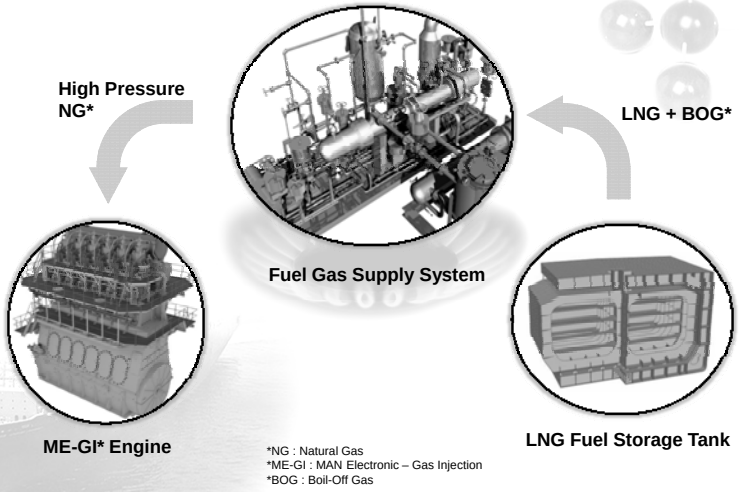
For Large Ships

- Large ship requires totally different technologies to utilize LNG as its fuel.

	Small Ships	Large Ships	Consideration
Propulsion	4 Stoke Gas or D/F Engine & Electric Propulsion	2 Stoke D/F Engine & Mechanical Propulsion	Large Propulsion Power (Bore 90 or 98)
FGS	LNG/NG Supply by Tank Pressure	New Concept FGS	High GI Pressure
Fuel Tank Type	Type C Pressure Vessel	New Concept Fuel Tank	Huge Tank Volume CAPEX, Volume Efficiency
BOG Management	Not Critical	Careful Attention	MARVS
Fuel Tank Arrangement	Complying with B/5 distance from side hull	Difficult to meet B/5	Cargo Loss, Collision
Bunkering	Not Critical	Critical in Method & Time	Tank Volume & Operation Schedule

LNG Fueled Propulsion System

- **LNG Fueled Propulsion System for Large Commercial Ships**



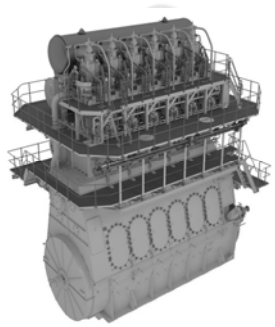
*NG : Natural Gas
*ME-GI : MAN Electronic – Gas Injection
*BOG : Boil-Off Gas

CONTENTS

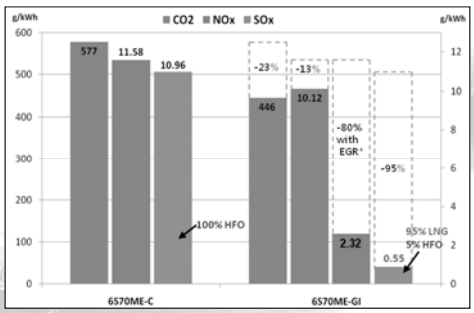
Propulsion Engine: 2-Stroke Dual Fuel Engine

ME-GI Engine (MAN Electronic – Gas Injection)

- 2-stroke dual fuel engine made by MAN Diesel
- Highest efficiency among existing propulsion systems
- Simultaneous Dual Burning (HFO + FG)
- Low CAPEX & OPEX compared to other dual fuel engines
- CO2, NOx, SOx emission reduction

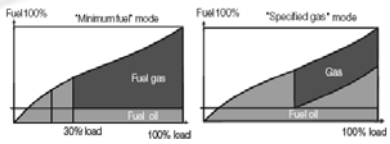


• **ME-GI Engine**



• **Emission Comparison between ME and ME-GI in gas mode**

(Refer to "ME-GI Dual Fuel MAN B&W Engines". Graph by DSME)

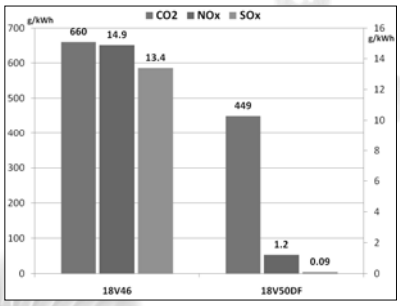


• **Variable Gas Operation Mode of ME-GI**

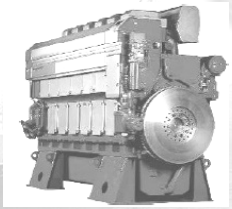
Generator Engine: 4-Stroke Gas / Dual Fuel Engine

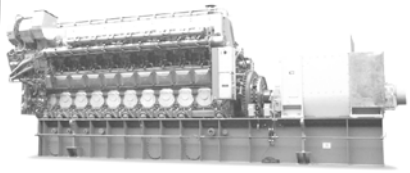
Gas / Dual Fuel Generator Engine

- 4-stroke, medium speed gas or DF engine
- Oil mode (HFO or MDO, DF engine only) or Gas mode (NG + 1% MDO pilot oil)
- SOx, NOx emission is negligible
- Working gas pressure : 5 ~ 8 bar
- Constant speed (RPM) designed



• **DF Engine Emission Comparison.** (Ref. "Wartsila 50DF Project Guide")



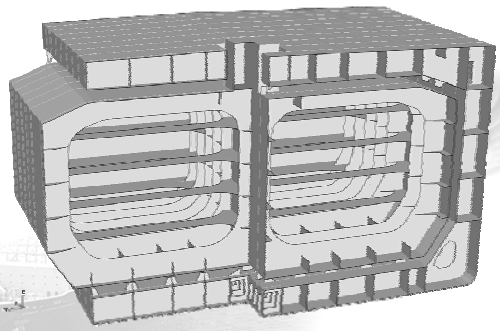


CONTENTS

IMO Independent Type B

IMO Independent type B Tank

- Independent LNG tank – Prismatic type
- PUF(Poly-Urethane Foam) panel type insulation
- Inherent increased pressure design



- **Independent LNG Fuel Tank Example (ACT-IB)**

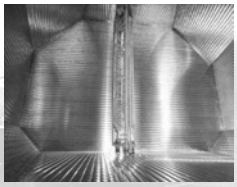
Membrane Tank

❑ IGF interim guideline is expected to amended to allow membrane tank for LNG fueled ships

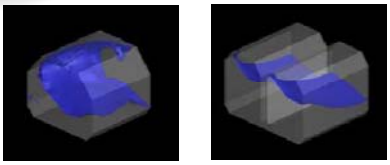
GTT NO 96 system	
Primary membrane	0.7 mm Invar (36% Ni-Fe)
Primary insulation material	Plywood with Perlite
Secondary membrane	0.7 mm Invar (36% Ni-Fe)
Secondary insulation material	Plywood with Perlite
Insulation thickness	530 mm (230 + 300)
Insulation tightening	Securing device set
Note	Anti-sticking treatment between secondary insulation box with hull

✓ DSME LNG FPSO applied 2 row LNG tank (NO 96 CCS)

✓ Internal view of NO96 CCS



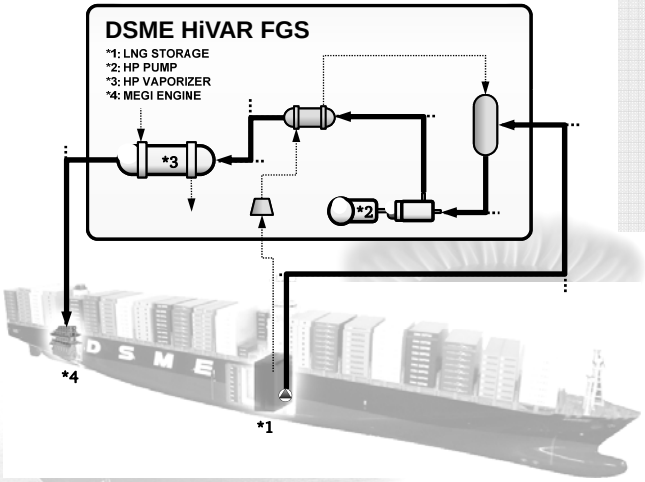
✓ Result of sloshing in 2 row arrangement of NO 96 CCS



CONTENTS

Fuel Gas Supply System – DSME HiVAR

❑ **Conceptual Process Flow Diagram**



❑ **Features**

- HP Pump + HP Vaporizer
- 300 bar Design Pressure
- BOG Recondensing
- Compact Size
- Low Power Consumption
- Low Noise & Vibration
- Easy Maintenance

Power Consumption Comparison (for reference)	
HP Compressor System	HiVAR
1400 kW	70 kW

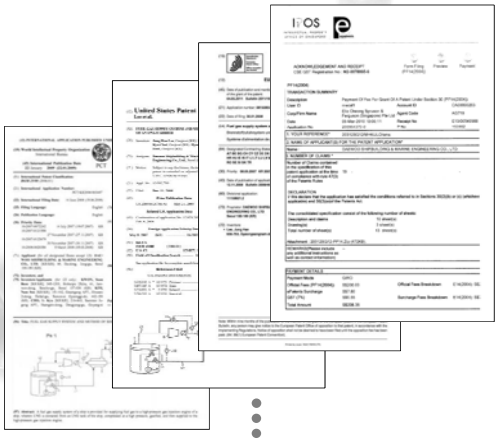
DSME Intellectual Property Rights

DSME Proprietary Technology

Patent List of DSME HiVAR system

- **International Patent Application**
  - ✓ Several patents applied since June 2008
  - ✓ Designated States : EP*(Granted), Singapore(Granted), China, United Arab Emirates
- **United States Patent**
  - ✓ Several patents applied since Dec 2008
- **Patented or Patent Application in Korea**
  - ✓ Several patents applied since May 2007
  - ✓ 20 + granted or pending

※ EP : United Kingdom, Norway, Sweden, Germany, Belgium, France, Denmark, Greece, Switzerland, Finland



- High pressure fuel gas supply using HP pump and HP vaporizer is subject to intellectual and industrial property rights protected by national and international legislation.
- Registered to many countries including US and EU. (Previous arts have been exhaustively checked before registration.)

DSME HiVAR FGS Test Skid (at Copenhagen)

SUCTION DRUM

Design press. : 11.5 barg
Design temp. : -186 ℃
Volume : 0.68 m3

SILENSOR

Ref. noise : 80dB
Performance : > 20dB
Material : Sus 304.

GW SYSTEM

Temp. range : from 50℃ to 60 ℃
Heating power : 330 kw (Max)

HP PUMP

Type : Reciprocating
Discharge press. : 315 barg
Design capa. : 1.6 m3/h

HP VAPORIZER

Type : Shell & Tube
Working press. : 315 barg (Max)
Heating power : 300 kw

PULSATION DAMPER

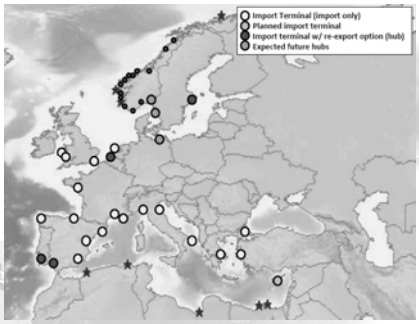
Pipe size : 40A
Length : 24m
Volume : 0.02m3

CONTENTS

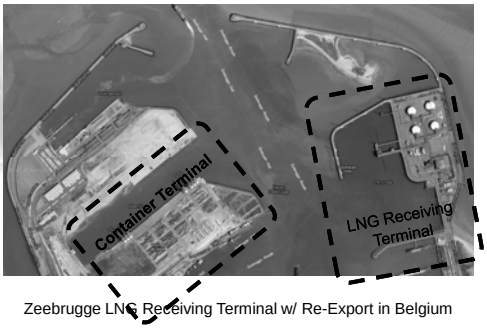
LNG Bunkering

LNG Bunkering Scenarios

- Tank lorry for small ships
- Existing LNG Import or Export Terminals
- Launching local LNG Liquefaction Facilities for bunkering business
- Ship to Ship Transfer utilizing small LNG Bunkering Ships in
  - Container terminals, or
  - Open sea areas



LNG Terminals

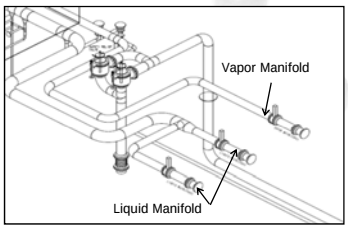


Zeebrugge LNG Receiving Terminal w/ Re-Export in Belgium

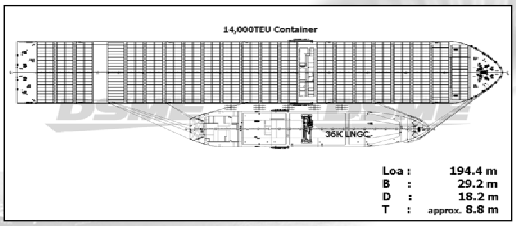
LNG Bunkering Vessel

LNG Bunkering Vessel Concept

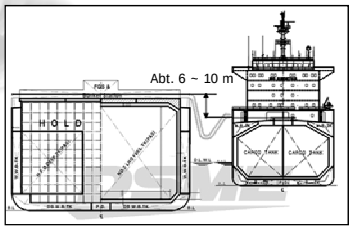
- Pre-requisite for LNG fueled containerships and tankers
- Safe mooring
- Manifold mating
- High speed LNG pumping
- Returned flash gas treatment
- Safety monitoring and interface systems



• **Side by Side Mooring**



• **Side by Side Mooring**



• **Example of Ship to Ship Transfer**

CONTENTS

Overall Safety Design

- IGF* compliant design
- HAZID/HAZOP for LNG fuelled commercial ship
  - Gas existing physical spaces :
    LNG fuel tank space, FGS room, E/R, vent mast, bunkering station, passage way, etc.
  - Gas operations :
    LNG bunkering, FG supply at normal seagoing, drying, inerting, aeration, initial cool down, warming up, etc.

* IGF : the International Code of Safety for Gas-fuelled Ships.
Now it stands as an **interim guideline**.

- HAZID for DSME LNG-Fuelled Container Ship (ABS, BV)

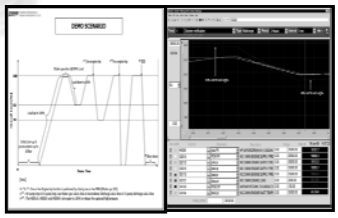
FGS Room

FGS Room Safety

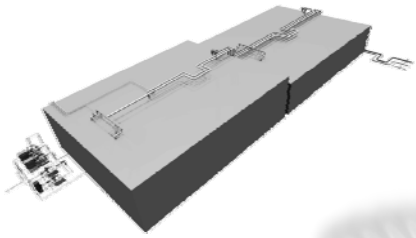
- Explosion proof equipments (motor, etc)
- Ignition source inhibited
- Ventilation systems (30 air change / hour)
- Gas detection & ESD (Emergency Shut Down) system
- Structural integrity against dropping object (container ships)

• HAZID/HAZOP Study and AIP for FGS

• Dynamic Simulations



LNG Fuel Tank Space

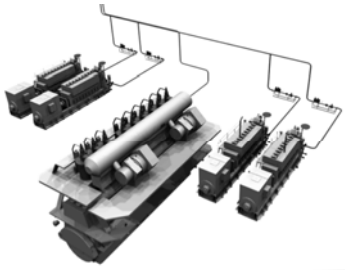


3D Model of VLCC's LNG Fuel Tank Room

LNG Fuel Tank Safety

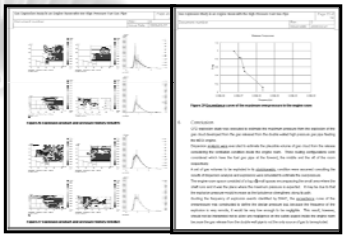
- Tank pressure control by BOG Management
- Emergency venting systems
- Inerting with N2 outside of tank
- Gas detection wystems
- Drip Trays below tank bottom (Secondary Barrier)
- Eductors for drip trays
- Structural integrity against possible collision (container ships)

Engine Room



Engine Room Safety

- Double wall pipe connections
- GVU (Gas Valve Unit) for each gas fueled engine
  - Double block and bleed valves
  - Enclosed GVU room with ventilation
- Ventilation systems
- Gas detection systems
- ESD (Emergency Shut Down) system



• Gas Explosion Study in E/R

CONTENTS

Considerations for LNG Fueled Ship

Ship owner
- Economic Benefit
- Environmental Benefit

LNG Supplier
- Stable & Predictable LNG Price Setup

LNG Fueled Ship

Shipyard
- Reliable, Robust and Safe Design
- Verification during Commissioning and Sea Trial

LNG Bunkering
- Long-term Contract base Stable Supply
- Safe Bunkering Procedure

Summaries and Conclusions

❑ LNG Fueled Large Commercial Ship Design

- Dual fuel engines + Fuel storage tank + FGS system
- LNG bunkering infrastructure
- Safety design & operation procedures
- Development of various LNG fueled ship design

❑ Environment Friendly Operations

- Reduction of exhaust emission (CO_2, SOx, NOx)

❑ Cost-Effectiveness of LNG Fuel

- Environment and operation cost saving

Ship Type	Annual Fuel Cost Saving
Typical Large Container Ship	Approx. 12 ~ 20 mil. USD per year
Typical VLCC	Approx. 6 ~ 12 mil. USD per year

* Based on fuel prices of HFO($630/ton), MGO($930/ton) and LNG($8 ~ $12/MMBTU)