

where the Froude number is defined by

$$Fr = \frac{V_0}{\sqrt{g(\rho_L - \rho_G)D}} \quad (6-138)$$

where g = acceleration due to gravity

- V_0 = liquid velocity in the drain pipe
- ρ_L = liquid density
- ρ_G = gas density
- D = pipe inside diameter
- h = liquid height

For additional information, see Strupp (Chem. Eng., 73:6), 102-214 [1968]. A critical Froude number of 0.31 is usually cited; flow is stable if $Fr > 0.31$. Recent results (Theopas, 3d Int. Conf. Multi-phase Flow, The Hague, Netherlands, 18-20 May 1967, paper K2, and 4th Int. Conf. Multi-phase Flow, Nice, France, 19-21 June 1969, paper K4) show hysteresis, with different critical Froude numbers for flooding and unflooding of drain pipes, and the influence of end effects. Wallin, Crowley, and Haag (Trans. ASME J. Fluids Eng., 405-413 [June 1977]) examine the conditions for horizontal discharge pipes to run full.

Flashing flow and condensing flow are two examples of multi-phase flow with **phase change**. Flashing flow occurs when pressure drops below the bubble point pressure of a flowing liquid. A frequently used one-dimensional model for flashing flow through nozzles and pipes is the **homogeneous equilibrium model** which assumes that both phases move at the same in situ velocity, and maintain vapor-liquid equilibrium. It may be shown that a **critical flow condition**, analogous to sonic or critical flow during compressible gas flow, is given by the following expression for the mass flux G in terms of the derivative of pressure p with respect to mixture density ρ_m at constant entropy:

$$G_{crit} = \rho_m \sqrt{\left(\frac{\partial p}{\partial \rho_m}\right)} \quad (6-139)$$

The corresponding acoustic velocity $\sqrt{\partial p/\partial \rho_m}$, is normally much less than the acoustic velocity for gas flow. The mixture density is given in terms of the individual phase densities and the **quality** (mass flow fraction vapor) x by

$$\frac{1}{\rho_m} = \frac{x}{\rho_G} + \frac{1-x}{\rho_L} \quad (6-140)$$

Choked and unchoked flow situations arise in pipes and nozzles in the same fashion for homogeneous equilibrium flashing flow as for gas flow. For nozzle flow from stagnation pressure p_0 to exit pressure p_e , the mass flux is given by

$$G^2 = -2\rho_0^2 \int_{p_0}^{p_e} \frac{dp}{\rho_m} \quad (6-141)$$

The integration is carried out over an isentropic flash path; flashes at constant entropy must be carried out to evaluate ρ_m as a function of p . Experience shows that isenthalpic flashes provide good approximations unless the liquid mass fraction is very small. Choking occurs when G obtained by Eq. (6-141) goes through a maximum at a value of p_e greater than the external discharge pressure. Equation (6-139) will also be satisfied at that point. In such a case the pressure at the nozzle exit equals the choking pressure and flashing shocks occur outside the nozzle exit.

For homogeneous flow in a pipe of diameter D , the differential form of the Bernoulli equation (6-15) rearranges to

$$\frac{dy}{\rho_m} + z \, dz + \frac{C^2}{\rho_m} \, d\left(\frac{1}{\rho_m}\right) + \frac{dy}{\rho_m} \frac{C^2}{D} \frac{C^2}{\rho_m^2} = 0 \quad (6-142)$$

where y' is distance along the pipe. Integration over a length L of pipe assuming constant friction factor f yields

$$C^2 = \frac{-\int_0^L \rho_m \, dy - z \int_0^L \rho_m^2 \, dz}{\ln(\rho_m) \rho_m + 2fL/D} \quad (6-143)$$

Frictional pipe flow is not isentropic. Strictly speaking, the flashes must be carried out at constant $h + V^2/2 + gz$, where h is the enthalpy

per unit mass of the two-phase flashing mixture. The flash calculations are fully coupled with the integration of the Bernoulli equation; the velocity V must be known at every pressure p to evaluate ρ_m . Computational routines, employing the thermodynamic and material balance features of flow-sheet simulators, are the most practical way to carry out such flashing flow calculations, particularly when multicomponent systems are involved. Significant simplification arises when the mass fraction liquid is large, for then the effect of the $V^2/2$ term on the flash splits may be neglected. If elevation effects are also negligible, the flash computations are decoupled from the Bernoulli equation integration. For many horizontal flashing flow calculations, this is satisfactory and the flash computations may be carried out first, to find ρ_m as a function of p from p_0 to p_e , which may then be substituted into Eq. (6-143).

With flashes carried out along the appropriate thermodynamic paths, the formalism of Eqs. (6-139) through (6-143) applies to all homogeneous equilibrium compressible flows, including, for example, flashing flow, ideal gas flow, and residual gas flow. Equation (6-138), for example, is a special case of Eq. (6-141) where the quality $x = 1$ and the vapor phase is a perfect gas.

Various **nonequilibrium** and **slip flow** models have been proposed as improvements on the homogeneous equilibrium flow model. See, for example, Henry and Fausch (Trans. ASME J. Heat Transfer, 176-187 [May 1974]), Nonequilibrium and slip effects both increase computed mass flux for fixed pressure drop, compared to homogeneous equilibrium flow. For flow paths greater than about 100 mm, homogeneous equilibrium behavior appears to be the best assumption (Fischer, et al., Emergency Relief System Design Using INPRESS Technology, AIChE, New York [1962]). For shorter flow paths, the best estimate may sometimes be given by linearly interpolating (as a function of length) between **frozen flow** (constant quality, no flashing) at 0 length and equilibrium flow at 100 mm.

In a series of papers by Leung and coworkers (AIChE J., 32, 1743-1746 [1986]; 33, 524-527 [1987]; 34, 668-694 [1988]; J. Loss Prevention Proc. Ind., 2(2), 78-86 [April 1990]; 3(1), 27-32 [January 1990]; Trans. ASME J. Heat Transfer, 112, 524-528, 528-530 [1990], 113, 269-272 [1991]) approximate techniques have been developed for homogeneous equilibrium calculations based on pseudo-equation of state methods for flashing mixtures.

Relatively less work has been done on **condensing flows**. Slip effects are more important for condensing than for flashing flows. Siddiqui, Schuster, and Reissner (J. Heat Transfer, 90, 267-276 [1968]) give a model for condensing vapor in **horizontal pipes**. They assume the condensate flows as an annular ring. The Lockhart-Martinelli correlation is used for the frictional pressure drop. To this pressure drop is added an acceleration term based on homogeneous flow, equivalent to the $G^2 d(\rho_m)$ term in Eq. (6-142). Pressure drop is computed by integration of the incremental pressure changes along the length of pipe.

For **condensing vapor in vertical downflow**, in which the liquid flows as a thin annular film, the frictional contribution to the pressure drop may be estimated based on the gas flow alone, using the friction factor plotted in Fig. 6-21, where Re_G is the Reynolds number for the gas flowing alone (Bergholz, et al., Proc. Heat Transfer Fluid Mech. Inst., ASME, June 22-24, 1969, pp. 19-28).

$$-\frac{dp}{dz} = \frac{2C_D \rho_m V^3}{D} \quad (6-144)$$

To this should be added the $G^2 d(\rho_m)/\rho_m$ term to account for velocity change effects.

Gases and Solids The flow of gases and solids in **horizontal pipe** is usually classified as either **dilute phase** or **dense phase** flow. Unfortunately, there is no clear delineation between the two types of flow, and the dense phase description may take on more than one meaning, creating some confusion (Kroenlein, et al., Chem. Eng. Progr., 80(4), 44-54 [April 1980]). For dilute phase flow, achieved at low solids-to-gas weight ratios (loadings), and high gas velocities, the solids may be fully suspended and fairly uniformly dispersed over the pipe cross section (homogeneous flow), particularly for low-density or small particle size solids. At lower gas velocities, the solids may become along the bottom of the pipe. With higher loadings and lower gas velocities, the particles may settle to the bottom of the pipe, form-

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