

Emerson's Instrument & Valve Services saves Martin Resources thousands of dollars during new plant start-up

RESULTS

- Saved \$25,000 per day by getting the plant into production
- Completed instrument validation in less than two weeks
- No instrument-related downtime since startup



APPLICATION

Instrumentation and control valves in a new sulfuric acid production unit in Plainview, Texas.

CUSTOMER

Martin Resources is a wholly owned subsidiary of Martin Midstream Partners LP, which processes, markets, and distributes sulfur and sulfur-based products.

CHALLENGE

An independent contractor was hired as the low bidder to configure and calibrate more than 200 HART® field devices and control valves in a new sulfuric acid production facility. Most of the instruments were Rosemount™ pressure and temperature transmitters, along with Fisher® control valves with FIELDVUE® digital valve controllers. The original schedule called for starting the plant after a six-week commissioning period. However, the control system kept shutting down because the field instruments were not communicating properly. The original commissioning crew had neither the tools nor the knowledge to do this job, and since they were not certified by Emerson, they could not call for factory support.

According to the Martin Resources Acid Plant Manager Dan Hinsley, "It was several months before we could get into production – at a cost of as much as \$25,000 per day in lost production. We could have been up and running much sooner if the work had been done correctly the first time."

"Having Emerson Instrument & Valve Services in here was the best thing we've ever done. They were thorough and perfect on everything, because they knew what they were doing. Best money we ever spent."

**Dan Hinsley,
Acid Plant Manager,
Martin Resources, Plainview, TX**

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www.assetweb.com

SOLUTION

After several attempts by the original instrumentation contractor to start and run the plant, Hinsley called his Rosemount representative and asked for help. Within a few days, a crew of trained Emerson instrument and control technicians arrived onsite and began going through every instrument and control valve in the new plant to ensure they were properly installed and configured according to the design specifications. This meant validating every instrument to be sure the measurements were accurate and that the 4-20 ma signals were reaching the distributed control system. It also meant checking all control loops to be certain every valve was responding correctly to the inputs.

The well-trained and equipped Emerson team worked efficiently and effectively to finish the assignment in less time than initially estimated. They were on site when the plant was started up and didn't leave until it was running smoothly. Although Emerson stands behind their work, there has been no need to call them back as no instrument problems have developed since startup.

According to Hinsley, who is in charge of instrument maintenance, he has had very little reason to use the AMS™ Suite: Intelligent Device Manager predictive maintenance software because “the plant has been running like a charm!”

“The Emerson technicians had everything completely done in less than two weeks – after the instrument contractor tried for months to get the plant started. “

**Dan Hinsley,
Acid Plant Manager,
Martin Resources, Plainview, TX**

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