METHOD FOR TRANSPORTING IMPELLENT GASES
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ABSTRACT: The described system DAL comprises a method and a device for transportation of buoyant impellent gases, without the need for expensive pipes and liquid tankers. The gas is self air-lifted from its source to a consignment point by means of voluminous, light, hollow bodies. Upon release of the gas at the consignment point, the bodies are filled with another cheap buoyant gas (steam or heated air) for the return trip to the source. In both directions substantial quantities of supplementary freight goods can be transported. Requirements and advantages are presented.

THE PROBLEM AND ITS SOLUTION CONCEPT

The Situation

More than 90% of the presently known finds of natural gas can not yet be used economically as supplies of energy. Annually, billions of cubic meters of natural gas are being burned off at the heads of oil wells. Systematic exploitation and utilization of natural gas fields is by no means fully developed.

Conventional Transport Systems

Contrary to the situation that prevails in the case of transporting oil, pipelines and tankers are not economical for transporting natural gas and must therefore be seen as intermediate solutions. Investments

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for both these modes are extraordinarily high. Even an interconnected system of tankers and pipelines is not flexible enough. Moreover the tanker mode requires refrigeration (-258°F) and loading and unloading while the gas is liquid. Liquefaction cost approximately $8 per 1000 norm cubic meters (Nm³). Thus pipeline and tanker are not economically optimal solutions for the transportation of natural gas.

**The Solution Principle**

Reflections on a better solution of this problem center on a specific property of natural gas: it is lighter than air. Compared to the earth atmosphere, natural gas has a much lower specific weight which thus makes it possible to transport it through the air in large containers which are able to fly. At the place of delivery of the natural gas, these containers can be filled with another light gas that is cheaply and abundantly available there, in order to make the flight return to the natural gas source. Both steam and hot air are possibilities here.

**Special Requirements and Possibilities for Realization**

The weight of the containers plus power plant and thrusters, with the necessary accessories, must be less than the lift that is generated by a load of steam or hot air. A lightweight and heat insulated sandwich skin for the containers will be required to guarantee the necessary temperature stability for the steam or other gases. To supply the necessary heat to keep the temperature at prescribed levels, the heat of the engine exhausts is used. The steam or hot air is forced out by natural gas in the loading process. Mixing of the gases is prevented by moveable separating walls in the individual cells.

**Comments**

The most significant advantages of gas transport by "lighter than air ships" compared to pipelines have been indicated in an expert opinion from Professor Alfred Walz (Technical University of Berlin, Institute for Supersonic Flow). Also Mr. Miles Sonstegard of the University of Arkansas has determined, for his system, that the transportation of liquid natural gas (LNG) in "lighter than air ships" is decisively more advantageous than fixed pipeline systems.

**Patents and Acronym**

Detailed construction considerations and calculations form the basis for patent applications in over 40 countries, some of which have already been granted. These patent applications cover construction and mode of operation of the DAL transport system, which requires no hangar or special landing facility. The acronym DAL represents the German conceptual description

"Dampf/Erdgas Austausch Lufttransporter"
(Steam/Natural Gas Exchange Cargo Airship)

In the following section, the concept described above is explained in greater detail via an example of typical airship of the kind mentioned before. The explanation indicates further advantageous construction features.
DESCRIPTION OF THE SYSTEM

Structure Characteristics

The natural gas air transport system DAL is designed around large, dynamically stable self-propelled flying bodies. It is technically feasible, for example, to consider a ship of 364 m (1100 ft) length and 104 m (317 ft) diameter with a volume of 2,300,000 cubic meters (63,000,000 cubic feet) and which consists of a pressurized skin made of fiber-reinforced plastics. A rigid integrated cabin structure and keel, 130 meters long, 26 meters wide, and 18 meters high, is attached to the pressurized balloon via circumferential bands. The cabin houses the crew, passengers, freight containers, all equipment necessary for driving the vessel, and approximately 150 flexible tanks for ballast water or liquid freight (e.g., oil). In the interior of the airship, flexible bulkheads (dividing walls) are installed to allow separation of the total space into gas compartments of variable size. Figure 10/74 shows the distribution of different gases within the interior of the ship during a single transport journey.

REPRODUCIBILITY OF THE ORIGINAL PAGE IS POOR
Technical Data

The average speed is planned to be 150 km/hour at 1000 m (3000 ft) altitude. The required power of the engine is assumed to be 8000 hp. The volume of natural gas that can be transported over the distance North-Slope New York (that is 5250 kilometers) for instance is about 2,1 million cubic meters of methane, assuming 90% of full load and 4% fuel consumption. The extra available cargo space when heating the methane to 100°C is about 1200 tons. The action radius with full load is only limited by economics. This means that circumnavigation of the earth without intermediate stops is feasible (possible). On the flight back to the source of the natural gas the payload with steam as buoyant gas is about 800 tons, with hot air of 100°C, 200 tons, and with preponderantly hydrogen buoyant gas at 100°C, 2000 tons.

Propulsion and Steering Mechanism

Motive power is produced by a thruster with a ring slot at the stern of the airship. Steering of the jet stream is performed by eccentrical regulation of the inner cone of the thruster. Thus an effective maneuvering capability at low air speeds and low noise levels is provided.

Double-Walled Skin

For this concept, the skin of the airship body is the decisive component. It must be light and strong, gas tight and heat insulating, aging resistant and weather resistant.

Weight and Strength - The skin must carry the aerodynamic loads during flight. The external pressure distribution on the flying body (fig.1/?) shows, that significantly less strength is sufficient over the large surface area of the middle part.

The gas pressure P can be reduced to a quarter of the stream pressure Q.

Use of small spherical cells of higher strength in the bow and stern, f.i. realized by means of the highly pressurized tube ring element
shown on the left in Fig. U, drastically reduces the skin weight via such divisions of the total skin surface. Fig. L indicates alternative solution. Foil and polyester fabric are intended as skin materials for a maximum strength to weight ratio.

Temperature Insulation - This tensile fiber polyester fabric hull consists of two separate walls with a heat insulating protective gas maintained under pressure in between, thus making it temperature resistant to 100 °C.

The double-walled skin is pumped full with nitrogen or argon and is maintained under a permanent pressure of approximately 20 Torr. For the wall, about 16 centimeters (6 inches) thick, there exists a heat-loss value of approximately 20 Kcal/m²h, i.e., approximately 240 Norm-m³/h of natural gas is required to cover the heat loss for the above-mentioned large flying body with 96,000 m² surface area. This is about 8,000 m³ or 4% of the natural gas volume for a flight distance of 5,000 km and a cruising speed of 150 km/h. The heat of the exhaust gases of the motors can cover this heat loss with considerable reserve. The structure of the double-walled skin is characterized by the arrangement of tensile loaded bands between the high strength exterior wall and the interior wall of the skin. Between these tensile bands, folded zig zag form aluminum vapor plated foil serves to substantially prevent heat radiation. The skin walls are completely covered inside as well as outside with aluminum foil, so that diffusion is prevented. The aluminum is, in turn, covered with a fluoride resin or similar water repellent material. The protective gas is completely dry. Also light has no effect on the skin material. Thus the greatest possible resistance to aging is provided. The skin covering is also immune to radiation, lightning, rain, and ice formation.

NATURAL GAS SHIPMENT

The medium that provides the lift for the vessel on the way to the natural gas source is either hot air or steam. Figure 12 shows the DAL filled with steam shortly before departure to the natural gas source.
The problem of heat loss is solved technically via regulated additions of heat from the exhaust heat of the motors. The exhaust heat from the axial piston, natural-gas-driven motors keeps the lifting gas at 100°C via a closed steam circulation. Axial piston motors with novel swash-plate power plant are being developed by Papst-Motoren KG.

Because 400 tons of payload are attainable with warm air filling, it is possible to carry even the heaviest drilling rigs, together with the necessary equipment and personnel, directly into regions where oil and natural gas are found, even if they are difficult to reach by way of surface transportation (arctic lands, deserts, continental shelves, tundra, dunes).

Figure 13/74 indicates how steam or warm air is forced out by pumped-in natural gas at the gas source.
At this point nearly the entire body has been filled with natural gas. Only small leftover spaces are available for vapor and warm air to balance lift. This is the departure condition at the gas source. The total lift is 1683 tons, if a buoyant volume of 2.3 million cubic meters is assumed, divided as follows:

\[
\begin{align*}
2 & 100\ 000\ \text{m}^3\ \text{natural gas} \\
200\ 000\ \text{m}^3\ \text{balancing air}
\end{align*}
\]

All gases are heated to 100°C. For an assumed unloaded weight of the airship of 570 tons including keel frame, skin, crew, passengers, supplies, and auxiliary ballast water, a lift of 1,100 tons is available for payload, e.g., LNG or oil. At departure from the natural gas source, the total lift is comprised of:

1 613 tons natural gas
70 tons warm balancing air

After traveling the example distance of 5 250 km the natural gas component is reduced to 1565 tons. This equalized by a steam lifting component of 53 tons and a reduction of the air lifting component to 65 tons. The total departure lift of 1,683 tons is thus maintained.
After arrival at the delivery destination, steam is pumped into the cells intended for it and the natural gas is thereby forced out. Steam is abundantly available as a byproduct at electric power plants. Thus the cycle is completed! Landing is achieved by setting the wind, driving to maintain position, and descending. After landing, the ship is held on the ground via suction. The keel frame is kept airtight against the ground by an inflated tube skirt which encircles the bottom perimeter. Unevenness up to one meter can be equalized by this means. The landing surface can thus lie near the gas source. Small auxiliary suction pumps reduce the pressure under the tube-skirt structure to approximately 300 mm water-column, so that the DAL can also be held fixed in storms with winds up to 150 km/h.

SAFETY CONSIDERATIONS

The life expectancies of the double sheath covering made of highly impact-resistant fiber-reinforced polyester and other plastics as well as the foil gaskets and the aluminium-foil protective covering are very large indeed. The protective gas between the double sheath in the absence of oxygen, moisture or light guarantees maximum lifetime. The danger of ignition of the natural gas is largely controlled by the pressurization of the heat insulated double sheath with a non flammable gas (e.g. nitrogen). After a puncturing of the exterior wall the protective gas escapes and the neighboring bands and the inner wall attach themselves automatically to the outer wall, thereby sealing the leak. The strength of the outer skin (about 40 000 kP/m) and the seams is eight times the normal load during flight at full speed. The entire double sheath covering remains filled with gas during operation.

Arrangement, control and checking of the power plant are based on the fail-safe principle. Even loss of 50% of the power allows full maneuverability of the ship. The DAL may remain afloat for months without the engines running. Liquid fuel is not needed/used, i.e. higher safety.

COST AND ECONOMIC FEASIBILITY

One natural gas transport vessel with a capacity of 2.3 million cubic meters (63 million cubic feet) of natural gas and 1,200 tons of oil can be built today for about $20,000,000 if 50 units are to be manufactured. Cost of operation per year is estimated at $1,300,000. On 100 round trips, covering a distance of 250 km (3,260 miles) each, a heat equivalent of about 280,000 tons of oil can be transported.

Comparing the cost of transportation by air shipment and by pipeline, you find as presumed 68 billion of cubic meter per year and a distance of 2,520 km a demand of 237 DALs. An investment of $20,000,000 per DAL means 7 cent per cubic meter transport capacity; out of which result about 0.7 cent per cubic meter gas as transport costs. These conditions will of far not be reached with the pipeline mode. The costs of transporting for one barrel of gasoline would amount to $1.6 These cost figures could be reduced by hauling additional freight or passengers. About 1% of the transported volume are used up for propulsion and buoyancy per 1000 kms.

For loading and unloading freight, the bottom of the cabin of the DAL contains special containers for water, capable of holding up to 2,420 tons. Water is pumped out while freight is taken on and the reverse takes place when freight is unloaded. For an exchange of 110 tons of
load the pumping costs amount to approximately 50 cents. Loading and unloading would usually be done by this gradual process.

The annual revenue from goods transported by one OAL of 364 m length and 104 m diameter, assuming a 70% utilization of freight capacity and 70% utilization in time, is illustrated in the following table:

<table>
<thead>
<tr>
<th>Lift generated by</th>
<th>Net cargo capacity</th>
<th>$ Million</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steam</td>
<td>880 t</td>
<td>9.6</td>
</tr>
<tr>
<td>Natural Gas</td>
<td>1100 t</td>
<td>11.55</td>
</tr>
<tr>
<td>Hydrogen</td>
<td>2200 t</td>
<td>23.10</td>
</tr>
</tbody>
</table>

For 50 round trips over a Distance of 6,215 miles each, this corresponds to an annual mileage of 621,500 miles. (Base 3 cts/ton.mile)

**SUMMARY**

Compared to pipeline or pipeline shp - pipeline systems of transporting natural gas, the proposed natural gas air transport system DAL shows the following advantages:

- Independence from geographic and climatic hazards. One means of transportation only for both land and sea routes, door-to-door transportation even over great distances.
- Independence from locally changing political situations. Quick shifting to alternative sources maximum of flexibility.
- Lower investments of reduced risk.
- The possibility of large-scale coordination of supplying even remote natural gas sources. Thus additional optimization and rationalization is feasible.
- Lower cost for transporting natural gas via freight and passenger revenue.
- Even small finds will be economically attractive.

**CONCLUSION**

The DAL-Airship-System in principle can be used:

- for transportation of high volume and heavy goods
- in aero-crane applications
- for passenger transportation purposes with maximum comfort.
- for transporting impellent gases and thus puts a big question mark over natural-gas-pipeline systems.