

# COAL POWER & COMBUSTION

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## QUARTERLY REPORT OCTOBER - DECEMBER 1976

*MASTER*

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# CONTENTS

<b>EXECUTIVE SUMMARY</b>	<b>1</b>
<b>I. MULTICELL ATMOSPHERIC PRESSURE FLUIDIZED-BED BOILER</b> Pope, Evans, and Robbins, Inc. E(49-18)-1237	<b>7</b>
<b>II. ENERGY CONVERSION ALTERNATIVES STUDY (ECAS)</b> Lewis Research Center—National Aeronautics and Space Administration E(49-18)-1751	<b>11</b>
<b>III. PRESSURIZED FLUIDIZED-BED COMBUSTOR AND TURBINE POWER GENERATION</b> Combustion Power Company, Inc. E(49-18)-1536	<b>13</b>
<b>IV. SUPPORTIVE STUDIES OF PRESSURIZED FLUIDIZED-BED COMBUSTION</b> Argonne National Laboratory	<b>17</b>
<b>V. EXTERNALLY FIRED GAS TURBINE FOR MODULAR INTEGRATED UTILITY SYSTEMS</b> Oak Ridge National Laboratory	<b>21</b>
<b>VI. PRESSURIZED FLUIDIZED-BED COMBUSTION RESEARCH</b> National Research Development Corporation (England) E(49-18)-1511	<b>25</b>
<b>VII. COAL-OIL SLURRY COMBUSTION PROGRAM</b> ERDA/FE with in-house technical support at: Pittsburgh Energy Research Center	<b>29</b>
<b>VIII. SOLVENT-REFINED COAL (SRC) COMBUSTION TEST PROGRAM</b> Pittsburgh Energy Research Center	<b>31</b>
<b>IX. ANTHRACITE REFUSE UTILIZATION</b> Morgantown Energy Research Center	<b>33</b>
<b>X. HIGH TEMPERATURE DUST CONTROL</b> Construction Engineering Research Laboratory— U.S. Department of the Army E(49-18)-1782	<b>35</b>

<b>XI. APPLICATIONS OF FLUIDIZED-BED COMBUSTION TECHNOLOGY TO INDUSTRIAL BOILERS</b>	<b>37</b>
Exxon Research and Engineering Company	
E(49-18)-1798	
<b>XII. ON-LINE PARTICULATE ANALYSIS INSTRUMENTATION</b>	<b>39</b>
Leeds & Northrup Co.	
E(49-18)-2412	
<b>XIII. PARTICLE MEASURMENT IN FLUIDIZED-BED COMBUSTION SYSTEMS</b>	<b>41</b>
Spectron Development Laboratories, Inc.	
E(49-18)-2413	
<b>XIV. BOILER TUBE BUNDLE AND BURNER MODULE TEST WITH POTASSIUM</b>	<b>43</b>
Oak Ridge National Laboratory	
<b>XV. INDUSTRIAL APPLICATION OF FLUIDIZED-BED COMBUSTION PROCESSES</b>	<b>49</b>
Combustion Engineering Company	
E(49-18)-2473	
Georgetown University	
E(49-18)-2461	
Battelle Memorial Institute, Columbus Laboratories	
E(49-18)-2472	
Exxon Research and Engineering Company	
E(49-18)-2471	
FluiDyne Engineering Corporation	
E(49-18)-2463	
Arthur G. McKee and Company	
EX-76-C-01-2418	
<b>XVI. MODELING OF FLUIDIZED-BED COMBUSTION PROCESSES</b>	<b>53</b>
Massachusetts Institute of Technology	
E(49-18)-2295	
<b>XVII. FLUIDIZED-BED WASTE MATERIAL UTILIZATION: SOIL MODIFICATION</b>	<b>55</b>
Virginia Polytechnic Institute and State University	
Tennessee Valley Authority	
E(49-18)-2411	
United States Department of Agriculture	
E(49-18)-2488	
United States Department of Transportation	
E(49-18)-2491	
<b>XVIII. COMBINED-CYCLE ELECTRIC POWER GENERATION USING PRESSURIZED FLUIDIZED-BED COMBUSTION</b>	<b>57</b>
Curtiss-Wright Corporation	
E(49-18)-1726	
<b>XIX. EVALUATION OF A PRESSURIZED FLUIDIZED-BED COMBUSTION (PFBC) COMBINED CYCLE POWER PLANT CONCEPTION DESIGN</b>	<b>61</b>
Burns and Roe Industrial Service	
E(29-18)-2371	

**XX. COAL-FIRED COMBINED-CYCLE DEVELOPMENT PROGRAM**  
General Electric Energy Systems—Technology Division  
E(49-18)-2357

**63**

**GLOSSARY**

**65**

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## EXECUTIVE SUMMARY

The United States has more energy available in coal than in petroleum, natural gas, oil shale, and tar sands combined. Nationwide energy shortages, together with the availability of abundant coal reserves, make the use of coal vital to the Nation's total supply of clean energy. In response to this need, the Office of Fossil Energy of the Energy Research and Development Administration (ERDA) is conducting a research and development program to provide technology that will permit rapid commercialization of processes for improved direct combustion of coal, for advanced coal-burning power equipment, and for converting coal to synthetic fuels. These fuels must be suitable for power generation, transportation, storage, and residential and industrial uses.

The technologies selected for development—gasification, liquefaction, combustion, and advanced power systems—satisfy an urgent need for a particular type of fuel, are potentially feasible both technically and economically (in terms of the costs of research and development and the final product), and will not exceed the air, water, and solid pollution standards established by the Environmental Protection Agency (EPA). The emphasis given each technology varies, depending on such things as technical complexity, development stage (laboratory research, including bench-scale tests and experiments with process development units, and pilot plant design, construction, and operation), variety of uses for the fuel produced, and urgency of the need that the technology is designed to satisfy.

ERDA's coal combustion and power program, started by the Office of Coal Research (OCR) of the U.S. Department of the Interior (merged into ERDA in January 1975), has focused on two major areas: direct combustion of coal and advanced power systems. Efforts in the area of direct combustion are concentrated on:

- Development of atmospheric and pressurized systems capable of burning high-sulfur coal of all rank and quality in fluidized-bed combustors.
- Development of advanced technology power systems to generate power more economically than present technology permits while using medium- and high-sulfur coal in an environmentally-acceptable manner.

- Development of the technology enabling coal-oil slurries to be substituted as feedstock for gas or oil-fired combustors
- Improvement of the efficiency of present boilers

Compared with conventional coal-fired systems, fluidized-bed combustion systems, when generating steam for conventional turbine systems, give higher power generation efficiencies and cleaner exhaust gases, even when burning high-sulfur coals. If the fluidized-bed system is pressurized, additional economies in capital and operating costs may be realized. The benefits from high-pressure combustion are a reduction of furnace size due to decreased gas volume and better sulfur removal. High-pressure combustion, however, requires the development of equipment to clean the hot combustion products to make them suitable for use in power generation turbines.

The advanced power systems program is directed toward developing electric power systems capable of operating on coal or coal-derived fuels. These systems involve the use of high temperature gas turbines burning low-Btu gas and turbine systems using inert gases and alkali metal vapors. It is anticipated that these systems will have lower electricity costs than new steam power plants constructed using today's technology and burning medium and high-sulfur coals.

To develop direct combustion and advanced power systems as rapidly as possible, ERDA is sponsoring a variety of research and development projects. Responsibility for designing, constructing, and operating a *Multicell Atmospheric Pressure Fluidized-Bed Boiler* at the Monongahela Power Plant in Rivesville, West Virginia, was contracted to Pope, Evans, and Robbins, Inc. This improved combustion design is to be used to produce steam for conventional power generation. The system features sulfur removal during combustion and the use of modular "cells" to facilitate construction and improve plant operability and reliability. Activities at the Rivesville Plant during the quarter concentrated on the testing of equipment for acceptance, continuance of cold mode operation, initial steps for continuous oil fire of the MFB unit, and subsequent cold firing of the carbon burnup cell.

The Lewis Research Center, National Aeronautics and Space Administration, through contracts with several corporations, is conducting an *Energy Conversion Alternatives Study (ECAS)* wherein performance and economic comparison are made of advanced power generation technologies. The parametric and conceptual design phases of the study were completed during this quarter.

Combustion Power Company, Inc. has completed all of the experimental work for developing a *Pressurized Fluidized-Bed Combustor and Turbine Power Generation* system using high-sulfur coals, and

combining desulfurization with combustion. Drafting of the final report was initiated during the quarter.

The cyclic properties of Greer limestone were evaluated as part of the *Supportive Studies of Pressurized Fluidized-Bed Combustion* at Argonne National Laboratory. The research and development program to evaluate the feasibility and potential of fluidized-bed combustion and sulfur dioxide absorption at elevated pressures continued with three combustion/regeneration cycles completed during the quarter.

Design work on the *Externally-Fired Gas Turbine for Modular Integrated Utility Systems (MIUS)* by Oak Ridge National Laboratory remained halted during the quarter pending a decision on program definitions and additional funding. A preliminary plan outlining a proposed test program was prepared and sent to ERDA for review.

The combustor to be used in the *Pressurized Fluidized-Bed Combustion Research* being conducted by National Research Development Corporation was pressure tested and commissioned during the quarter and testing began in mid-November. Coal burning continued for 70 hours when shutdown was enforced by a complete hold-up in the coal feed hopper. Adequate data were obtained, however, to achieve the objectives of Part I of the test so that Test 6, Part II, will be run in January.

Major modifications of the 100 HP boiler used in the *Coal-Oil Slurry Combustion Program* being conducted by the Pittsburg Energy Research Center were completed during the quarter. Test equipment was also installed to begin a test program on the rheology of coal-oil slurries. Results of tests performed in the *Solvent-Refined Coal (SRC) Combustion Test Program*, also being conducted by the Pittsburg Energy Research Center were completed during the quarter. Test equipment reduction in nitrogen oxide emissions was achieved by reducing the amount of excess air. The original burners of the furnace were refurbished during the quarter to permit testing of char from an agricultural waste pyrolysis process.

The last of the series of test runs on Kamenski No. 14 bank refuse were completed during the quarter by the Morgantown Energy Research Center in its *Anthracite Refuse Utilization Program*. The second 18-inch fluidized-bed combustor was delivered and erection of the unit began.

The Construction Engineering Research Laboratory of the U.S. Army Corps of Engineers completed a *High Temperature Dust Control* study. The final report is currently being prepared.

The final report of Exxon Research and Engineering Company's analysis of *Applications of Fluidized-Bed Combustion Technology to Industrial Boilers* was approved and printed during the quarter. The document is available through the National Technical Information Service, Springfield, Virginia 22161.

The instrument assembly was completed and checked out during the quarter for the *On-Line Particulate Analysis Instrumentation* experiments being conducted by Leeds and Northrup Company.

During October, Spectron Development Laboratories installed the Particle Morphokinometer System for the *Particle Measurement in Fluidized-Bed Combustion Systems* studies at Argonne National Laboratory.

*Boiler Tube Bundle and Burner Module Tests with Potassium* being conducted by Oak Ridge National Laboratory included the near completion of water testing of the gas-fired potassium boiler module. Nearly all the mechanical design work for the potassium system was completed this quarter.

Work continued on the *Industrial Application of Fluidized-Bed Combustor* processes. In the development of industrial superheated steam boilers, Combustion Engineering Company concentrated activity during the quarter in three major areas; cold flow test program, sub-scale unit design, and demonstration plant design. Georgetown University and Battelle Memorial Institute continued their work on industrial boilers. The development of an industrial boiler with all natural circulation boiler circuitry was the result of evaluations intended to optimize the steam generator design at Georgetown University. The thirty percent design of the sub-scale unit and related facilities was completed by Battelle. The detailed design of the combustor/boiler was also completed. Exxon Research and Engineering Company and FluiDyne Engineering Corporation continued their work on indirect-fired heaters. Exxon's efforts were directed toward the planning and design of two laboratory units which are to be a part of the Phase I program. The unit design for the two-dimensional flow visualization unit was completed and combustion initiated. The process design for the process steam coking unit was also complete. Primary effort at FluiDyne Engineering Corporation during the quarter concentrated on the technology support and preliminary design of the demonstration unit. Fluidized-bed combustion performance and equipment operations tests with Iowa coal, designated as the primary fuel, were completed.

During the quarter, the *Modeling of Fluidized-Bed Combustion Processes* had progressed to the final testing of the system model using fast bubble mechanics coupled to single-sized coal particle feed. The

final testing of the same model coupled to the multi-size coal particle feed was also near completion.

Four separate contractors are investigating the potential use of ***Fluidized-Bed Waste Material Utilization for Soil Modification***. Studies at the Virginia Polytechnic Institute and State University involved the use of the material as a nutrient source of calcium for crops and efforts by the Tennessee Valley Authority demonstrated the use of the material as a liming agent. Additional agriculture-related studies were conducted by the Agriculture Research Service. The Federal Highway Administration assessed the value of the material for use in soil stabilization applications.

***Combined-Cycle Electric Power Generation Using Pressurized Fluidized-Bed Combustion*** is the objective of a study conducted by the Curtiss-Wright Corporation. Major component and equipment design neared completion during the quarter.

Work continued on the ***Evaluation of a Pressurized Fluidized-Bed Combustion (PFBC) Combined-Cycle Power Plant Conceptual Design*** by Burns and Roe Industrial Service. Performance data on the four basic configurations of PFB arrangements, and preliminary cost data of major equipment for the four schemes were completed.

The ***Coal-Fired Combined-Cycle Development Program*** was developed under the leadership of General Electric Energy Systems who submitted the Commercial Plant Design Requirements Report to ERDA during the quarter.



# I. MULTICELL ATMOSPHERIC PRESSURE FLUIDIZED-BED BOILER

POPE, EVANS, AND ROBBINS, INC.

NEW YORK, NEW YORK

Plant Site: Rivesville, West Virginia

Contract No.: E(49-18)-1237

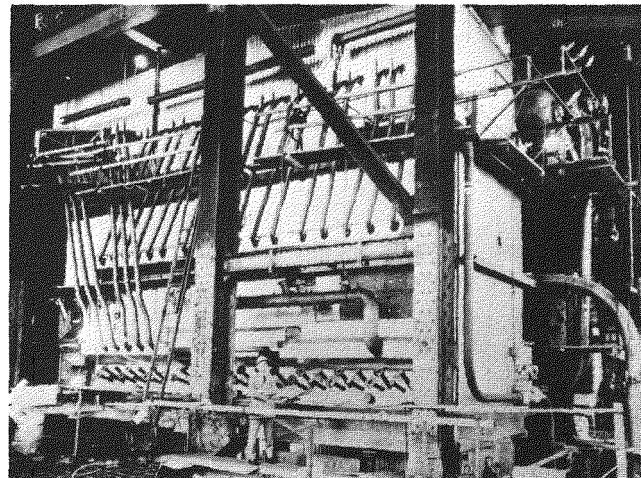
Total Funding: \$19,244,313  
(100% ERDA)

## INTRODUCTION

A multicell atmospheric pressure fluidized-bed boiler is being developed by Pope, Evans and Robbins, Inc. (PER), under the sponsorship of ERDA. The objective of this program is to design, construct, and operate a prototype multicell fluidized-bed boiler at an electric utility power station as an environmentally acceptable method of burning high-sulfur or corrosive coals without excessive maintenance problems. The system is to have a capacity of 30 megawatts (Mw) and is to be operated under practical electric utility conditions. PER is also conducting a laboratory research program to optimize boiler hardware and operational parameters. Experience gained from designing and operating the boiler and from laboratory research will be used as the basis for scaling up to a utility-sized system. The schedule for development of the fluidized-bed boiler is shown in Figure I-1.

## PROCESS DESCRIPTION

The fluidized-bed boiler is 12 feet wide, 25 feet high, and 38 feet long. It has conventional water tube walls, a convection economizer, and a capacity of 300,000 pounds of steam per hour. The boiler is unique in that it has horizontal superheater tube bundles submerged



in the combustor bed of fluidized coal, ash, and limestone. The unit is divided into four separate cells, three of which are about equal in size. The fourth cell, the carbon burnup cell, is smaller in width due to its own design parameters. The dimensions of the cells were influenced by shipping limitations, duty requirements, and the anticipated function of each cell. The design of the cells was based on the intended heating functions as follows:

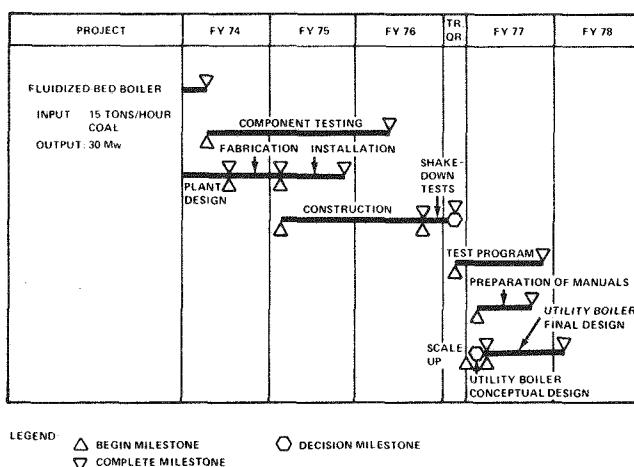


Figure I-1. MULTICELL FLUIDIZED-BED BOILER PROGRAM SCHEDULE

Cell A, the primary superheater, has a horizontal superheater tube bundle submerged in the fluidized-bed, with two additional horizontal bundles, the evaporator and the economizer, located in the convection zone (free board).

Cell B, the finishing superheater, has a horizontal bank of superheater tube bundles in the fluidized-bed zones with horizontal boiler and economizer bundles in the convection zone.

Cell C has a horizontal boiler tube bundle in the fluidized-bed zone with horizontal boiler and economizer bundles in the convection zone.

Cell D, the carbon burnup cell, contains only horizontal economizer tubes in the convection zone.

The bottom of the fluidized-bed is located approximately where the grate would be in a conventional coal-fired boiler. The expanded bed is four feet thick, has a six-foot free zone above it, and there is an additional six-foot convection heat transfer volume above the free zone. The partition walls between the cells are of the membrane type, i.e., a waterwall of finned tubes without refractory protection.

Coal and limestone are fed to cells A, B, and C, which are then fired with 18% excess air. Elutriate from these cells contains approximately 0.1 pound of carbon per pound of coal feed and is collected in a mechanical dust collector. This material is then sent to Cell D and burned with 25 percent excess air. The carbon is burned in an inert ash and sulfur-absorbing fluidized-bed of limestone at nominal bed temperatures of 2000° F in the carbon burnup cell whereas coal is burned at 1550° F in cells A, B, and C. The mixing tendencies of the fluidized-bed are controlled by using boiler tubes as baffles and walls. The particles are moved from one portion of a cell to another by the inherent fluid-like behavior of the bed.

One of the advantages of the multicell fluidized-bed boiler is that sulfur dioxide and nitrogen oxide emissions are controlled and well within current EPA standards. Other than electrostatic precipitators, expensive cleanup and energy-consuming flue gas equipment is not required. The sulfur dioxide emissions are captured by limestone in the fluidized-bed combustor which operates at a controlled temperature low enough to avoid objectionable NO<sub>x</sub> emissions. The limestone may be kept reactive by regeneration to recover concentrated sulfur dioxide or by the addition of fresh limestone. Emission of ash particles is low because

the coal is not pulverized, resulting in a mean dust-particle size of 100 microns, compared to 20 microns for similar processes.

Other advantages of the fluidized-bed boiler include:

- Low-quality, high-sulfur coal can be burned without danger of slagging due to low combustion temperatures.
- The heat release and heat transfer coefficients are high, thus reducing boiler size, weight, and cost.
- The multicell design lends itself to mass production assembly of the major components, thus facilitating shipping and saving plant construction time.
- It is anticipated that use of the fluidized-bed boiler, rather than a conventional coal-fired unit requiring a flue gas scrubber system, can result in an overall cost savings for the boiler of up to 25 percent.
- The overall operating efficiency of the multicell fluidized-bed boiler power plant is projected to be 39 percent, compared to approximately 32 percent for a conventional coal fired plant using a stack-gas cleanup unit when operating with the same coal and at the same steam pressure and temperature.

## HISTORY OF THE PROJECT

In February 1965, the Office of Coal Research (OCR, now part of ERDA) awarded Pope, Evans and Robbins, Inc., (PER) a contract to build and operate a small atmospheric fluidized-bed boiler. The ability to meet the most rigorous air pollution standards while burning high-sulfur coals was demonstrated, and ash fouling and slagging problems common to other types of boilers were eliminated. Furthermore, the boiler promised improved power plant efficiency and cleanliness when burning chars, anthracite, or conventional coal and eliminated the need for pulverizing the coal feed.

Under another OCR contract, initiated in May 1972, PER (in its Alexandria, Virginia, laboratory) performed additional experimental work using a 0.5 Mw unit. Four types of fuels (two high-sulfur bituminous coals, North Dakota lignite, and a petroleum coke) were burned to demonstrate the feasibility of fluidized-bed combustion and to examine the effect of lignite's high sodium content. The results of this work indicate that the addition of small quantities of common salt to

the fluidized-bed was a useful method of increasing limestone utilization, that chloride emissions were low, and that corrosion due to the addition of salt did not occur. Sulfur oxide emissions were reduced to levels well below the emission standards of existing and proposed federal and local regulations.

Because previous work indicated a high probability of success, work under the current contract was initiated in October 1972 to design, construct, and operate a 30-Mw-size multicell fluidized-bed boiler under practical utility conditions. Boiler steam pressure and temperature conditions were designed to meet the requirements of the Monongahela Power Company plant at Rivesville. Foster Wheeler Energy Corporation, as sub-contractor to PER, is responsible for the fabrication and installation of the 30 Mw boiler. Foster Wheeler is also responsible for:

- Preparation of the designs, technical specifications, arrangement drawings, bills of materials, etc., for the boiler and the pumps, valves, and burners directly attached to the boilers
- Preparation of an auxiliary system test program.
- Design, construction, and testing of a cold model.

Champion Construction and Engineering Company, Inc., was awarded the contract for general construction work at the plant site and for scheduling shipments of structural steel, motors, pumps, etc. Champion and PER jointly review and approve structural drawings prior to fabrication.

Field erection work in the Monongahela Power Company power plant is nearing completion, as are auxiliary systems, plant general construction, and laboratory construction work. Boiler installation is complete and cold test operations of individual systems and equipment have begun.

Concurrent with work on the 30 Mw boiler, PER has continued its laboratory research program, including cold-model and fluidized-bed module tests.

## PROGRESS DURING OCTOBER-DECEMBER 1976

### Summary

Operation of new equipment and systems in the Alexandria, Virginia laboratory continued and problem areas requiring corrective action were identified. Hot mode operation of the fluidized-bed module

(FBM) unit with flyash continued as did the adjustment of the pneumatic control system for operation in the automatic control mode. Internals in the Petrocarb flyash distribution system were modified and installed to eliminate flow stoppage problems experienced in initial testing.

At the Rivesville facility, activities concentrated on the testing of equipment for acceptance, continuance of cold mode test operations, initial steps for oil firing of the carbon burnup cell preparatory to lighting off and combusting the coal.

### Laboratory Research

As conversion of the fluidized-bed unit to accommodate the carbon burnup cell (CBC) mode of operation was completed, a total of ten tests were conducted in the CBC during the quarter. The first test (Test No. 644-1) used coal in order to determine combustion efficiencies with which to compare the results obtained while firing the flyash used in subsequent testing. The CBC was equipped with three feed points and Test No. 644-2 was the first test to use that configuration. Plugging of the feeder and feed rate control were problems in this and Test No. 644-3.

Test No. 644-4, conducted in November, was the first CBC test in which a long steady-state operation period was achieved while firing flyash only. The Petrocarb flyash feeder was operated nearly empty. The feeder was operated in a partially filled mode for Test No. 644-5 to prevent the feeding problems previously experienced.

Parameters studied during Test No. 644-6 included bed particle size distributions, effect of temperature and excess oxygen upon flyash combustion, and temperature distribution within the bed. The effects of CBC operation on the bed material size distribution was also studied. Bed samples were withdrawn periodically throughout the test and screened. Four CBC hot tests performed in December were conducted to determine combustion efficiency, bed temperature distribution and CBC operating characteristics when using fewer than the three flyash feed points used in previous tests.

During the tests in the cold mode of the Petrocarb flyash injection system, it was found that at solid feed rates greater than 600 pounds per hour, the flyash would not feed down from the top half of the unit. All attempts to operate the system full, at feed flyash

rates greater than 600 pounds per hour, proved unsuccessful. Consequently, replacement internals were designed by Petrocarb Inc. to eliminate this problem. Initial tests of the modified system were performed in a closed-loop test circuit. Preliminary testing indicated that a flyash throughput of over 1,000 pounds per hour, sufficient capacity to feed the FBM during hot CBC testing, appeared to be feasible.

As part of the current CBC tests, a theoretical modeling effort of the operation was also initiated in October.

#### **Plant Activities**

Acceptance and commissioning of auxiliary equipment and electrical systems to permit initial light-off of the CBC with oil was accomplished. Initial light-off and continuous oil firing of the CBC was achieved November 29. During December, an effective method of coal light-off for Cell D was developed and initiated. Coal was first combusted successfully on December 7, 1976.

## II. ENERGY CONVERSION ALTERNATIVES STUDY (ECAS)

LEWIS RESEARCH CENTER,  
NATIONAL AERONAUTICS AND SPACE  
ADMINISTRATION  
CLEVELAND, OHIO

Contract No.: E(49-18)-1751

Total Funding: \$2,600,000

ERDA: \$1,600,000

National Science Foundation:  
\$1,000,000

### INTRODUCTION

The Energy Conversion Alternatives Study (ECAS) is being managed by the National Aeronautics and Space Administration's Lewis Research Center under the sponsorship of ERDA and the National Science Foundation. Each sponsor contributed 50 percent of the total funding for the first task with ERDA providing additional funds for the later tasks. The studies are being conducted by General Electric Company, Westinghouse Electric Corporation, and a team of Burns & Roe and United Technologies, Inc., supplemented by Lewis Research Center personnel.

The overall objective of this project, started in August 1974, is to study advanced power generation techniques which can use coal or coal-derived fuels and to evaluate their relative merits and potential benefits. ECAS is to be conducted using a common basis of technology and materials performance in the light of new national goals and current conditions. In addition, ECAS is to define development plans for the various advanced systems, providing estimates of both cost and risk, and is to provide a basis for establishing needed technology or development programs. The evaluation of alternative systems on a comparable basis is needed so that cost-benefit analyses may be performed and the preferred systems selected for further development.

### PROGRAM DESCRIPTION

The objectives of the ECAS program involve a review of the technical claims, designs, performance, materials selection, development needs, costs, etc. of each power generating system currently being studied. To determine the relative performance, economics, natural resources requirements, environmental impacts, development requirements, and risks of the various advanced energy conversion systems, a Conversion Systems Evaluation is being used. This will be coupled with an Energy Systems Evaluation to assess the benefits and impacts of widespread implementation of these advanced energy conversion systems in electric utility applications. The project is divided into four tasks:

#### Task I—Parametric Analyses

25 to 300 Mw of generating capacity  
Variety of coal or coal-derived fuels  
Variety of heat rejection methods  
Variety of combustors/furnaces  
Variation of major power generation parameters  
Materials and performance related to technology status

#### Task II—Conceptual Designs

Component conceptual designs  
Plant layouts  
Detailed estimates (performance, economics, environmental impact, natural resources for selected cases)  
Construction requirements  
Operating characteristics  
Technology advancements required

**Task III—Implementation Assessment**

Preliminary research and development plans

Time and resources required to bring system to commercial service

Commercial acceptability

Special problems and limiting factors

**Task IV—Reports**

A preliminary outline for reporting on the output of Tasks I, II, and III is shown below.

**Output of Parametric Analyses**

Efficiency

Economics

Capital cost

Cost of electricity

**Natural resource requirements**

Coal

Water

Land

**Environmental impact**

Emissions (sulfur dioxide, nitrogen oxides, carbon monoxide, hydrocarbons, particulates)

Thermal pollution

Wastes

**Output of Conceptual Designs**

Plant layouts

Improved evaluation of plant characteristics

Efficiency

Economics (capital cost, cost of electricity)

**Natural resource requirements**

Coal

Water

Land

Critical materials

**Environmental impact**

Emissions (sulfur dioxide, nitrogen oxides, carbon monoxide, hydrocarbons, particulates)

Trace elements

Thermal pollution

Wastes

**Output of Implementation Assessment**

Development time and funding requirements

Preliminary research and development plans

Assess uncertainties and risks

Identify key experiments and common technology

**Factors affecting implementation**

Economic viability

Environmental impact

Natural resource conservation

Reliability potential

Safety

Ease of operation, control, and maintenance

Limiting factors

Task I, Parametric Analyses, was completed during the second quarter of 1975. A variety of overall systems were studied, based on combinations of the following types of units:

Combustors: fluidized-bed, pulverized coal with

scrubbers, and coal-derived liquid fuel; both atmospheric and pressurized.

Power cycles: coal-fired steam cycles, coal-derived liquid-fueled simple and recuperative cycle gas turbine, combined gas turbine-steam turbine cycles, with air-cooled, water-cooled, and ceramic turbines using coal-derived low-Btu gas as fuel; supercritical carbon dioxide (Fehr) cycle; alkali metal vapor Rankine topping cycle; closed cycle gas turbines with organic liquid Rankine bottoming cycle; open and closed cycle, including liquid-metal magnetohydrodynamics.

Fuel cells: low-temperature phosphoric acid; low-temperature alkaline; high-temperature molten carbonate; high-temperature solid electrolyte. For these, clean liquid and gaseous fuels from coal together with integrated gasifiers were used.

Preliminary results of the parametric analyses, including a benefit and break-even cost analysis, indicated that potentially large dollar benefits may be possible for some of these advanced systems.

## PROGRESS DURING OCTOBER-SEPTEMBER 1976

The parametric design and conceptual design phases of the Energy Conversion Alternatives Study (ECAS) have been completed.

The most promising baseload coal-fueled power generation technologies were studied to determine their relative potential. The competing technologies were evaluated for their projected cost of electricity, overall efficiency, emissions, and required resources. Results showed that, relative to the base case of conventional fossil fuel steam plants, a significantly lower cost of electricity and overall efficiency can result in the near term from the use of two technologies; fluidized-bed combustion for power plants using conventional steam conditions, and combined-cycle plants in which an advanced open cycle gas turbine discharging into a steam bottoming plant is fueled by an integrated low-Btu gasifier.

### III. PRESSURIZED FLUIDIZED-BED COMBUSTOR AND TURBINE POWER GENERATION

COMBUSTION POWER COMPANY, INC.  
MENLO PARK, CALIFORNIA

Plant Site: Menlo Park, California  
Contract No.: E(49-18)-1536  
Total Funding: \$3,818,115  
(100% ERDA)

#### INTRODUCTION

A combustor-gas turbine system is being developed by Combustion Power Company, Inc. (CPC), under the auspices of ERDA. This contract is an extension of an earlier research and development contract between CPC and the Environmental Protection Agency (EPA) in which municipal solid waste was burned with minimal pollution in CPC's CPU-400 pressurized fluidized-bed combustion and gas turbine system. The program objective is to develop a process to generate electrical energy through the combustion of high-sulfur coals mixed with dolomite, using an on-line gas turbine for direct generation. The program schedule is shown in Figure III-1.

#### PROCESS DESCRIPTION

A schematic of the CPC combustor-gas turbine system is shown in Figure III-2. In this process, the coal is crushed to a size smaller than  $\frac{1}{4}$ -inch, mixed with dolomite, and fed into the fluidized-bed combustor in a stream of compressed air. Fluidization is maintained by injecting air from the turbine compressor.

In the fluidized-bed combustor, the coal is burned

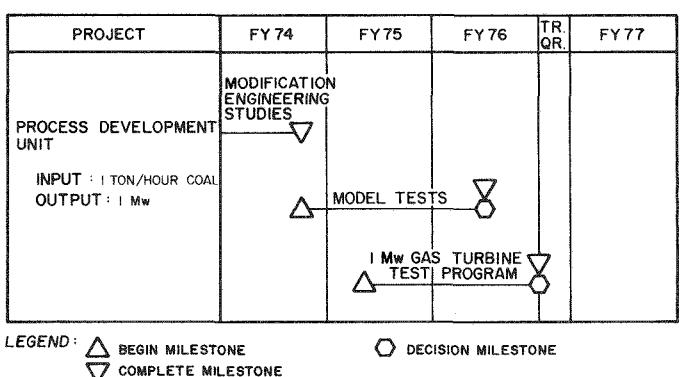
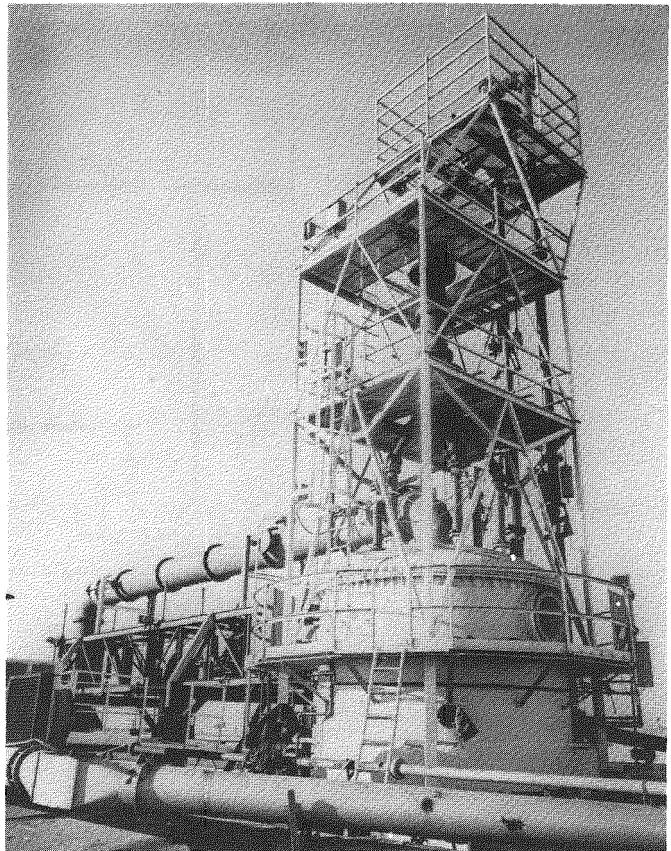
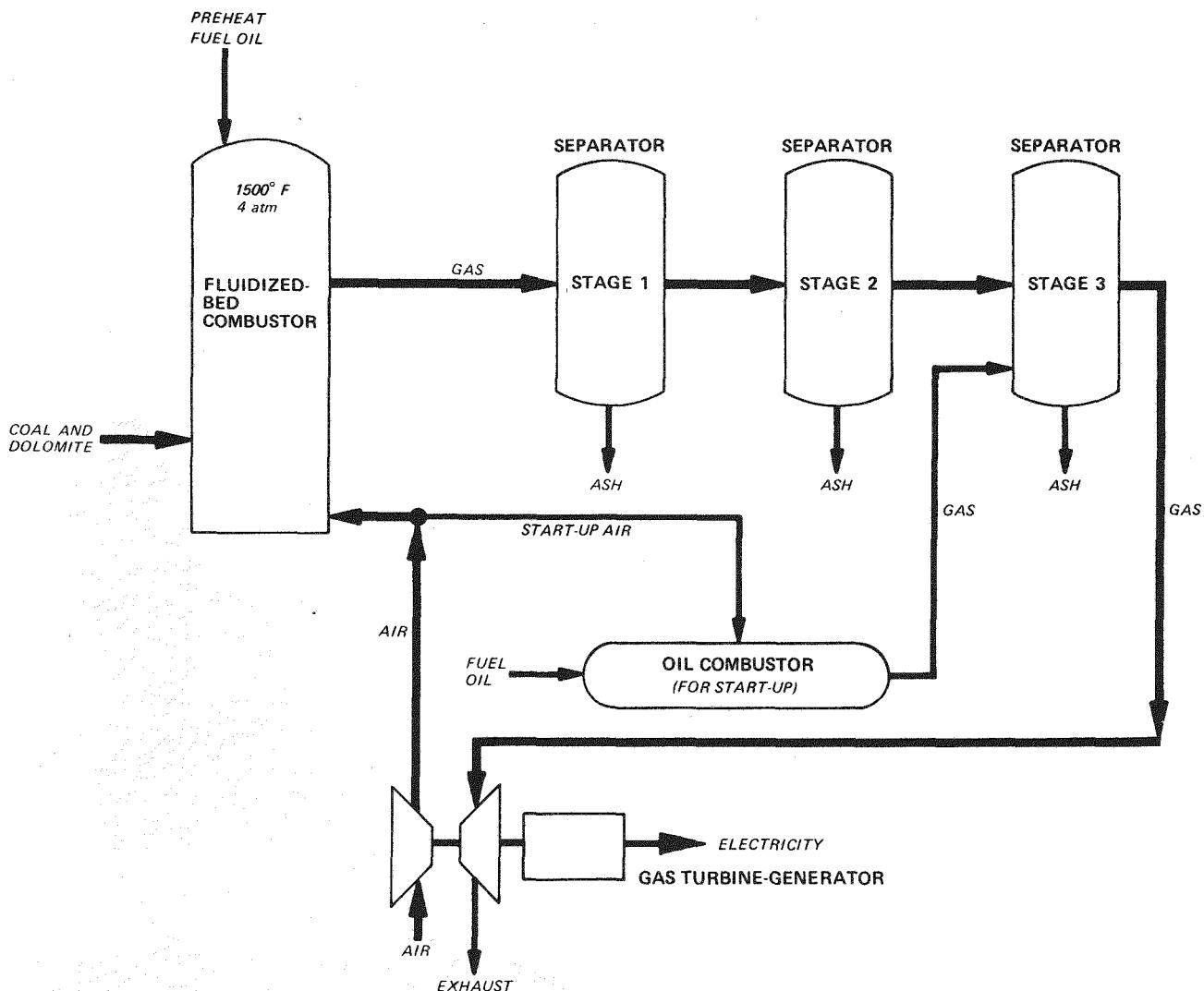


Figure III-1. COMBUSTOR-GAS TURBINE DEVELOPMENT SCHEDULE



**Figure III-2. COMBUSTOR-GAS TURBINE SCHEMATIC**

to produce gas and the sulfur compounds in the gas are absorbed by the dolomite. The gaseous products are passed through a three-stage system of separators to remove the solid particles. Stages 1 and 2 each consist of a pair of cyclone separators which remove particles greater than five microns in size. The third stage uses inertial separators to remove particles as small as two microns. A moving-bed granular filter is being installed to replace this third stage separator to improve the hot gas cleanup process. The cleaned gas is then expanded in a gas turbine driving a one Mw generator.

To facilitate start-up, fuel oil is used to preheat the fluidized-bed combustor to reaction temperature and is also used in an oil combustor during turbine start-up. The various transient modes of operation during start-

up are controlled by a process control computer, which also records all process operating conditions.

Some of the advantages of the CPU-400 system are:

- Sizing is the only pretreatment of coal needed
- High-sulfur caking coal can be burned without exceeding current EPA standards for sulfur dioxide and nitrogen oxide emissions
- The only stack gas treatment necessary is removal of particulates

## HISTORY OF THE PROJECT

For the past seven years, Combustion Power Company, Inc. has been conducting a development pro-

gram, under the sponsorship of EPA, to convert the heat energy of solid waste to electrical energy through the use of the CPU-400 system. With the cooperation of EPA, the Office of Coal Research (OCR, now a part of ERDA) contracted with CPC in June 1973 to conduct a research and development program designed to demonstrate the combustion of high-sulfur coal using CPU-400 technology.

Under the current contract, CPC conducted parametric evaluations of coal combustion in a model of the CPU-400 combustor, using caking and noncaking high-sulfur coals. The caking coal used was Lower Kittanning seam and the noncaking coal used was Illinois No. 6. The coals were burned using superficial velocities of four, seven, and ten feet per second, bed temperatures of 1400° F, 1600° F, and 1800° F, calcium-sulfur ratios of 1.5, three, and five, and three additives for absorbing sulfur compounds (two types of dolomite and one type of limestone). Each coal type was tested for 120 hours at nominal operating conditions of seven feet per second, 1600° F, and a calcium-sulfur ratio of 1.5.

The CPU-400 system was modified to provide the capability for coal and dolomite storage and feeding. This modified CPU-400 is known as the process development unit. Long-duration tests using the data from the model experiments were designed to determine and

minimize exhaust emission levels of noxious gases and particulates. In addition, candidate turbine blade materials and coatings were installed in the turbine rotors and stators to evaluate erosion and corrosion effects.

The results of the test program indicate that both dolomites used were equally effective in suppressing sulfur dioxide, the relative effects of superficial velocities and bed temperatures were slight, and the optimum calcium-sulfur ratio was 1.5. Limestone was consistently 10 to 15 percent less effective than dolomite under all test conditions. The most serious problem encountered during the tests was that the separators installed in the process development unit were found to be inadequate in controlling particulates to a degree which would ensure acceptable turbine blade life or to meet current EPA particulate exhaust emission standards.

## **PROGRESS DURING OCTOBER-DECEMBER 1976**

All of the experimental work under this contract was completed during the quarter. Drafting of the final report was initiated. The subcontract work by Solar and Westinghouse was also completed and their final reports were in preparation at the end of the quarter.



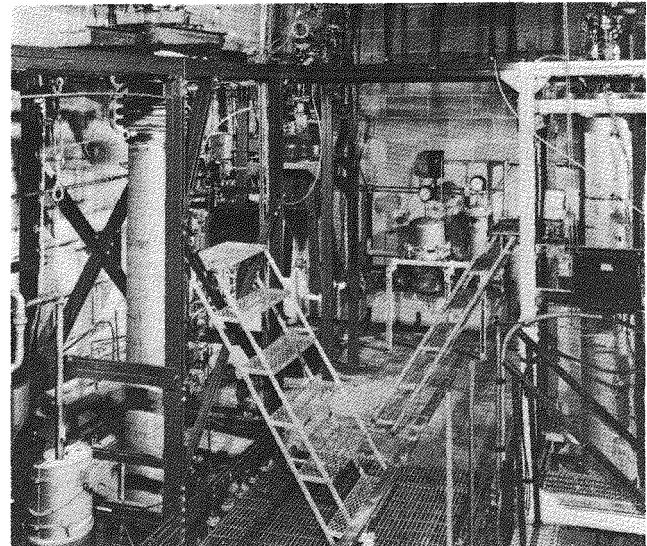
## IV. SUPPORTIVE STUDIES OF PRESSURIZED FLUIDIZED-BED COMBUSTION

ARGONNE NATIONAL LABORATORY  
ARGONNE, ILLINOIS

### INTRODUCTION

Argonne National Laboratory (ANL), under ERDA sponsorship since November 1974, is conducting a research and development program to evaluate the feasibility and potential of fluidized-bed combustion at pressures up to ten atmospheres. The objectives are:

- Optimize combustion procedures while maximizing retention of sulfur dioxide in the fluidized bed, minimizing the amount of nitrogen oxides in effluent gas, and increasing combustion efficiency.
- Evaluate the behavior and efficiency of the system for different types of coal such as lignite and subbituminous.
- Study the levels of trace-element pollutants in the flue gas and the effects of process operating conditions on these levels.
- Determine the mechanisms of the various reactions in the process and how their thermodynamics and kinetics are affected when parameters are varied.



level. The system is thoroughly instrumented and equipped with an automatic data-logging system.

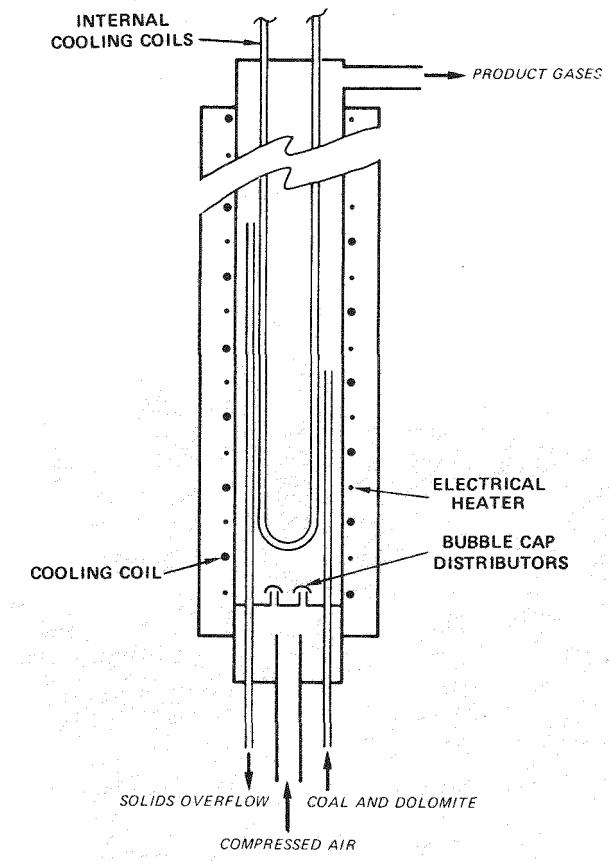
Coal and dolomite are transported by an air stream into the base of the combustor. Compressed air for fluidizing the mixture is also injected. The coal is entirely burned in a fluidized bed of dolomite. During combustion, the sulfur contained in the coal is released as sulfur dioxide, which is then absorbed by the dolomite. The sulfated dolomite is subsequently regenerated and reused in the combustor.

### FACILITY DESCRIPTION

A schematic of the pressurized fluidized-bed combustor is provided in Figure IV-1. The combustion unit is six inches in diameter and 11 feet long. The exterior is wrapped with electrical heaters to raise the bed temperature to the coal ignition temperature and with cooling coils to regulate the bed temperature during coal combustion. Four additional hairpin coils for cooling are immersed in the fluidized bed. An internal overflow pipe is used for maintaining a constant bed

### HISTORY OF THE PROJECT

Initial research and development efforts on pressurized fluidized-bed combustion included experiments to measure the effects of temperature, fluidizing gas velocity, and the ratio of the calcium content of the dolomite to the sulfur content of the coal. In these experiments, Pittsburgh seam coal was burned at eight atmospheres in a three-foot-high fluidized bed with three percent oxygen in the flue gas. The results indicated that:



**Figure IV-1. ANL PRESSURIZED FLUIDIZED-BED COMBUSTOR**

- For calcium-sulfur ratios above 2.0, more than 90 percent of the sulfur dioxide was retained in the dolomite bed and the amount retained decreased as the calcium-sulfur ratio decreased.
- Nitrogen oxide levels were extremely low, ranging between 0.40 and 0.15 pounds of nitrogen dioxide per million BTU, as compared to the EPA emissions standards of 0.70.
- Combustion efficiency varied directly with combustion temperature, ranging from about 89 percent at 1450° F to about 97 percent at 1650° F. Unburned carbon elutriated from the bed was the major source of inefficiency.
- Additive entrainment varied directly with the superficial gas velocity, varying from about five percent at two feet per second to as high as 80 percent at five feet per second. The use of larger dolomite particles would have reduced entrainment considerably at the higher gas velocity.
- Values of heat transfer coefficients varied directly with gas velocity, ranging from about 40 Btu per square foot per degree Fahrenheit at a gas velocity

of about two feet per second, to about 115 at five feet per second.

Experiments were also conducted using a subbituminous coal with a high ash content and a lignite. The operating performance of the fluidized-bed combustor in processing these western coals was excellent, thus demonstrating the versatility of the fluidized-bed concept for processing coals of widely varying rank and quality.

Another series of experiments was conducted to study the effect of combustor operating pressure on concentrations of nitrogen oxides and other noxious gases in the flue gas. In the absence of dolomite, the concentration of nitrogen oxide increased rapidly as the combustor pressure was reduced, going from less than 200 parts per million at eight atmospheres to approximately 1,600 parts per million at one atmosphere. In the presence of dolomite, the concentration of nitrogen oxide also increased as the pressure decreased, but only to about 400 parts per million at 1 atm. In both cases, the sulfur dioxide concentration was relatively unaffected. Temperature in the range of 1450° F to 1650° F had little or no effect on gas impurity concentration.

The distribution and potential emission of trace elements from fluidized-bed combustors were studied for comparison with available data from conventional coal-fired combustors. The elements of primary interest were lead, beryllium, mercury, and fluorine. Generally, the results indicate that the concentration of trace elements emitted from the fluidized-bed combustor may be significantly lower than that emitted from conventional coal-fired combustors.

Current support studies include regeneration process studies, synthetic sorbent development, limestone characterization, and trace element and combustion emission studies.

## PROGRESS DURING OCTOBER-DECEMBER 1976

### Summary

A cyclic sorbent utilization experiment was performed with Greer limestone and Sewickley coal during the quarter. The cyclic properties of the stone that will be used by Pope, Evans, and Robbins (PER) in the Rivesville plant were evaluated.

Three combustion/regeneration cycles were completed during the quarter at a pressure of approximately three atmospheres and 1570° F. At these conditions, the reactivity of the stone with sulfur in the first cycle was equivalent to that experienced in PER's atmospheric combustor. The reactivity did not change noticeably in the second cycle, but decreased in the third.

### Discussion of Activities

A cyclic utilization experiment was performed with Greer limestone and Sewickley coal that is being used by Pope, Evans and Robbins (PER) in the atmospheric plant at Rivesville, West Virginia. The intent of the investigation was to evaluate the technical feasibility of limestone regeneration in the pilot plant. Three combustion/regeneration cycles were completed during the quarter.

The combustion experiments were performed at a pressure of approximately three atmospheres and 1570° F, the temperature and pressure at which limestone calcines. At these conditions, the reactivity of the stone with sulfur in the first cycle was equivalent to that experienced in PER's atmospheric combustor. The reactivity did not change noticeably in the second cycle. In the third cycle, however, the reactivity did decrease.

In the first combustion cycle a calcium oxide to sulfur mode ratio of 3.26 was required to obtain a sulfur retention of 84 percent with a nominal bed height of 0.9 meter.

The operating conditions during the regeneration steps of each cycle were a nominal system pressure of about four psig, a bed temperature of 1100° C, a fluidizing gas velocity of about 1.2 meters per second, a total reducing gas concentration of approximately 3.0 percent in the dry offgas, and a fluidized-bed height of about 46 centimeters. The required heat and reductants for regeneration were provided by incomplete

combustion of Sewickley coal in the fluidized-bed. The same coal is being used for the combustion and regeneration steps of this experiment.

In the first cycle, an extent of regeneration (the conversion of calcium sulfate to calcium oxide) of 68 percent was calculated, based on a sulfur dioxide concentration of 8.4 percent in the dry offgas. In the second and third cycles, the sulfur dioxide concentrations in the offgas were 8.6 and 8.0 percent, respectively.

The use of an ordinary coal (one that does not have a high ash fusion temperature) during regeneration appears to have no effect on the regeneration process. On the basis of the results to date, the regenerability of the Greer limestone appeared to be acceptable.

The effect of experimental variables or the defluidization characteristics (agglomeration) of the regenerator bed were also investigated in the PDU regenerator during the quarter. Sulfated Greer limestone obtained from PER and Sewickley coal are being used. A statistical experiment was completed to determine the effects of bed temperature, total reducing gas concentration, and feed sorbent particle size on the defluidization velocity, the minimum velocity required to prevent agglomeration. At the higher temperature, a greater reducing gas concentration in the offgas and, with larger feed particles, a greater gas velocity is required to prevent defluidization and agglomeration of the bed during regeneration.

Precalcination followed by heat treatment of the Greer limestone almost doubled its ability to absorb sulfur dioxide in the combustor. It was estimated that the environmental impact, as measured by the bulk of the waste stream, could be reduced by 30 to 50 percent, at an additional cost of about 0.5 mill per kilowatt. Using the same method of reactivity enhancement for Tymochtee dolomite only slightly increased its reactivity, while failing to increase the sorption capacity of Dolowhite dolomite.



## V. EXTERNALLY FIRED GAS TURBINE FOR MODULAR INTEGRATED UTILITY SYSTEMS (MIUS)

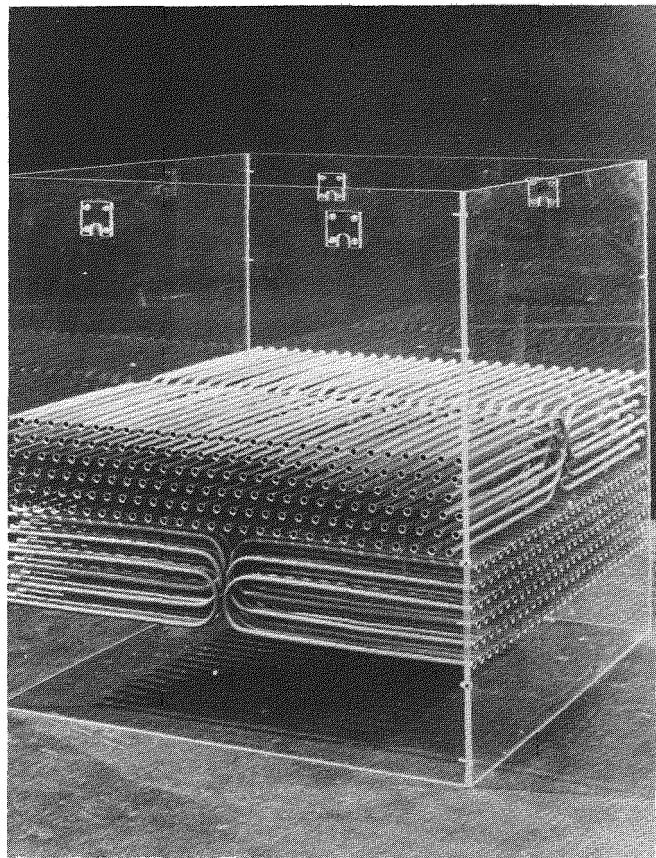
OAK RIDGE NATIONAL LABORATORY  
OAK RIDGE, TENNESSEE

### INTRODUCTION

A fluidized-bed coal combustor for an externally fired closed-cycle gas turbine is being designed by Oak Ridge National Laboratory (ORNL) as part of the Modular Integrated Utility System (MIUS). ERDA and the Department of Housing and Urban Development (HUD) (under HUD contract 1AA-H-40-72) are the joint sponsors of this project.

The objective of MIUS is to provide electricity and other utility services consistent with reduced use of scarce national resources, protection of the environment, and minimized cost. MIUS is modular, in that it can be located near appropriate users based on the actual demands of community development, rather than a forecast of requirements. MIUS might be sized to accommodate from several hundred to several thousand multi-family dwelling units, single-family units, and associated commercial facilities. It employs an integrated systems approach in a total energy concept whereby some resource requirements of one service are met by utilizing the effluent of another. For example, waste heat from a prime mover may be used for heating buildings, processing potable water, operating absorption-type refrigeration units, etc., as can heat from solid waste incineration. In addition to conserving energy, MIUS should realize a savings in capital costs because long transmission lines and municipal sewers would not be required.

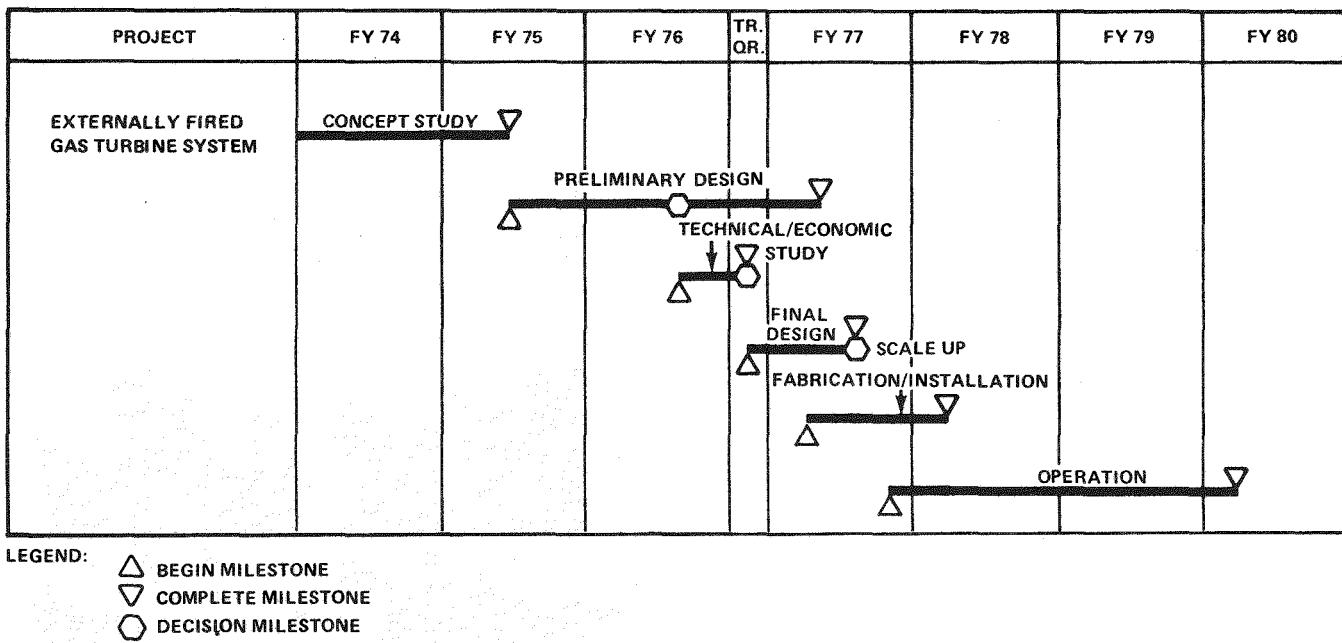
ORNL's contribution to this project is to conduct a multiphase research program to develop one or more coal-fired power plants for use in a MIUS demonstration project. These phases include preliminary evalua-



tion of the concept, design of a 0.5 Mw coal-fired power plant that can be used in the small total energy system envisioned, and construction, operation, and evaluation of the plant. In conjunction with this project, ORNL is conducting a continuing research program. The development schedule for this program is shown in Figure V-1.

### PROCESS DESCRIPTION

For MIUS operation with coal, ORNL is designing a fluidized-bed combustion system to be coupled with a closed-cycle gas turbine. A vertical sectional drawing

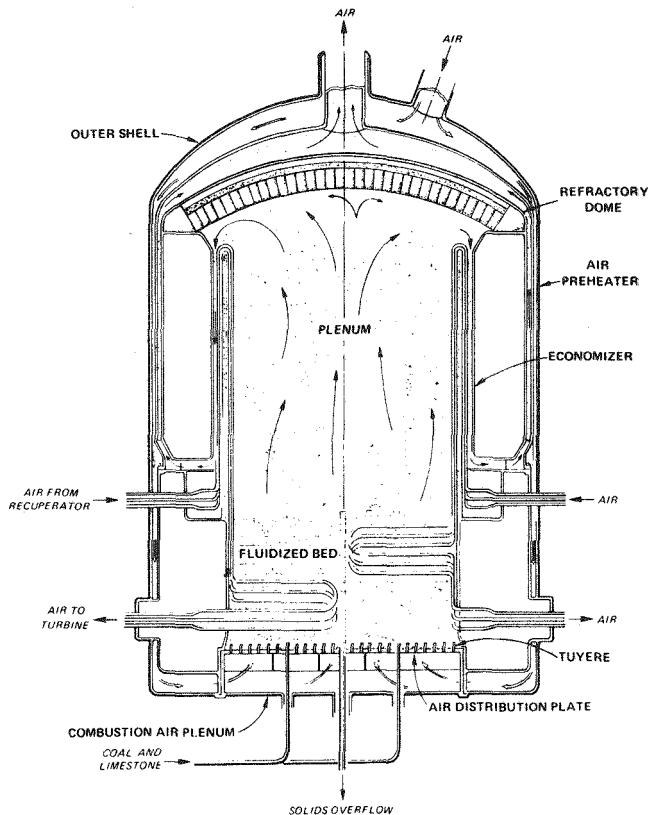


**Figure V-1. COAL-FIRED TURBINE FOR MIUS PROGRAM SCHEDULE**

of the proposed combustor is shown in Figure V-2. The design provides for efficient operation at less than peak load since this will be the normal operating condition. As currently designed, the fluidized beds in the combustion system are composed of coal and limestone, the function of the lime being to capture sulfur dioxide from the burning coal. This reaction produces calcium sulfate, thus making it unnecessary to remove sulfur dioxides from the stack gases.

Preheated air enters a plenum chamber under the bed, flows up through air-distribution tuyeres in the bed plate, through the 20-inch deep bed, through a plenum chamber over the bed, and then through the economizer region. The plenum chamber over the bed allows particles thrown up from the bed to decelerate and fall back into the bed. The superficial velocity of combustion gases can be varied from two to four feet per second. The air for the bed furnace is preheated by a heat regenerator consisting of a stationary heat transfer matrix. Hot stack gases flowing through one portion of the solid matrix transfer heat through the matrix to the air flowing through the other portion.

The particle movement in the fluidized bed promotes good combustion of the coal particles and provides excellent heat transfer coefficients with exposed heat transfer tube surfaces. The bed temperature is maintained at about 1600° F by air tubes about one-half inch in diameter welded into manifolds at the top



**Figure V-2. FLUIDIZED-BED COMBUSTION SYSTEM FOR MIUS**

and bottom. This configuration provides sufficient heat transfer surface area to remove the appropriate fraction of the heat of combustion.

The temperature gradient through the entire closed-cycle system is kept relatively constant, the power output being changed by varying the pressure in the system. Current parametric studies agree with previous analyses which indicate that the optimum pressure ratio for such a closed cycle with recuperation is between three and four to one. A conventional plate fin heat transfer matrix is used for the recuperator. A larger fraction of the heat of combustion goes into the air heated by the fluidized-bed and a smaller fraction goes into the waste heat boiler which produces 250° F water/steam. This waste heat boiler simplifies both fabrication and control. For good cycle efficiency, the compressor inlet temperature should be 80° F if outside air or cooling water temperature is maintained at 60° F. A fan is currently included to reduce back pressure on the turbine and thereby increase the thermal efficiency.

Particulates larger than ten microns in the stack gases are removed by two stages of cyclone separators, and regenerative cooling of the gases to below 600° F allows the bulk of the remaining fines to be removed with porous bags made of glass cloth. The MIUS coal fired gas turbine process has the advantage that it provides the required overall thermal efficiency at full load, with little loss of thermal efficiency for part-load operation, the more common operating condition. In addition, the fluidized-bed combustion system operates well with liquid or gaseous fuel, as well as char, low-sulfur coal, or solid organic waste. Therefore, it may also be used as an incinerator. Another advantage is that by keeping combustion temperature at approximately 1600° F, the formation of appreciable amounts of nitrogen oxide is prevented, and agglomerate clinkers are not formed because the ash temperature is below its fusion point.

ORNL has given much attention to basic problems such as:

- Ensuring even distribution of coal and limestone across the fluidized bed
- Minimizing bed pulsations and tube vibrations
- Decrepitation rates and reactivities of various limestones and dolomites after recycling
- Upper limits of gas velocity and bed depth
- Possibility of excessive corrosion on the combustion side of the tubes
- Effectiveness of fly ash removal equipment

## HISTORY OF THE PROJECT

Anticipating the impending energy shortage, HUD, with the assistance of ORNL, is investigating total energy systems for use with new building complexes as a part of the MIUS program. ORNL examined the problems of supplying heat to housing complexes from district heating systems tied to central stations and subsequently by examining various aspects of small total energy systems. Hundreds of these systems, employing diesel engines, gas engines, or gas turbines, are currently in use in the United States and have proved to be economically attractive. When shortages of gas and fuel oil began to develop in 1972, HUD asked ORNL to investigate the possibility of developing a small total energy system that would operate with coal as the fuel, particularly with high-sulfur coal. This led to the formulation of a program in May 1974, funded and technically directed by the Office of Coal Research (OCR, now part of ERDA), to be carried out at ORNL through HUD.

Phase I of this program, concept and preliminary evaluation, involved the comprehensive review of a wide variety of methods for employing coal in small total energy systems for HUD applications. Completed in July 1974, Phase I demonstrated that one promising way to use coal as the energy source for MIUS application is to burn it in a fluidized bed of limestone to produce hot air for expansion in a closed-cycle gas turbine. The thermal efficiency of the closed-cycle turbine is sufficiently high under partial loading, at which MIUS normally operates, to produce power that is economically competitive with power generated by utility companies. The closed-cycle system can convert about 30 percent of the energy in the fuel to electricity and about 50 percent to heat for gas turbine working fluid recuperation and to steam at 250° F or hot water at 150° F.

Critical evaluations of the results of Phase I work were generally favorable. To supplement that work, an additional study of gas turbine bucket erosion, deposits, and corrosion was conducted, with particular emphasis placed on experience with coal-fired gas turbines. In January 1975, ORNL was authorized to proceed with Phase II, the development of a firm conceptual design and cost estimate for the construction of a system for testing and evaluation. ORNL also has a continuing research and development program in support of this contract.

## PROGRESS DURING OCTOBER-DECEMBER 1976

Project review by ERDA representatives continued with respect to future funding and possible redirection of the program. The detailed design work was temporarily halted due to uncertainties related to furnace design and use of gas turbine. The coal and limestone feed systems and cold flow model tests continued since they are applicable to any furnace design.

Installation of the coal feed system in the endurance

test facility was completed during the quarter and a total of 100 hours of operating time were completed. Problems were encountered preventing complete automatic operation. A slight imbalance in the flow rate of coal, causing accumulation at one point in the closed system, necessitated a manual change in operating speed.

FluiDyne completed the 500-hour corrosion test in November and preparation of the report was begun. The report on heat transfer tests was completed and submitted for review.

## VI. PRESSURIZED FLUIDIZED-BED COMBUSTION RESEARCH

NATIONAL RESEARCH DEVELOPMENT  
CORPORATION

LONDON, ENGLAND

Plant Site: London, England

Contract No.: E(49-18)-1511

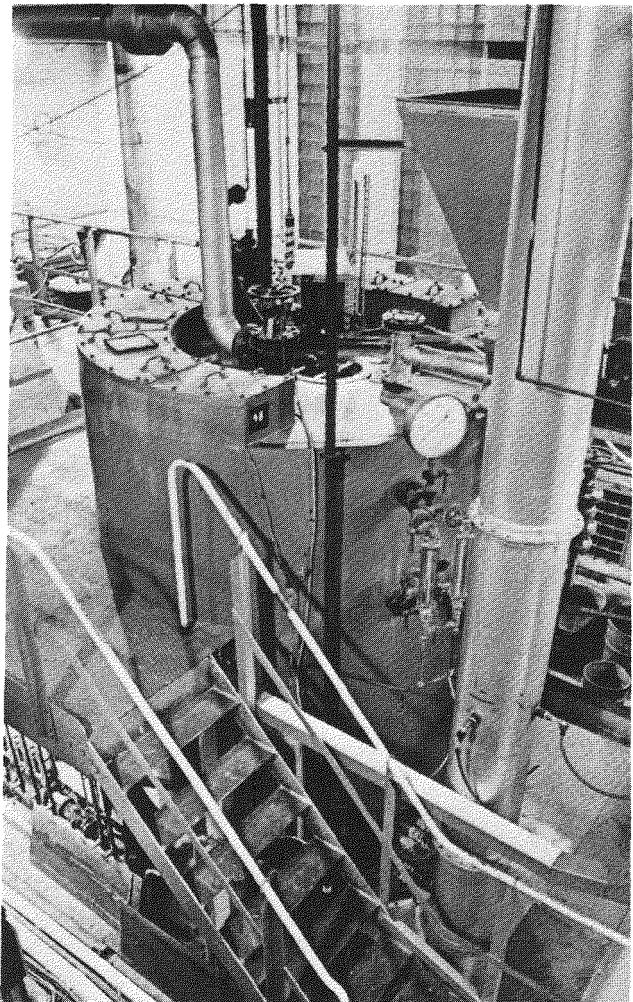
Total Funding: \$907,331  
(100% ERDA)

### INTRODUCTION

The National Research Development Corporation (NRDC), in conjunction with the British Coal Utilization Research Association, Ltd. (BCURA), is studying pressurized fluidized-bed combustion under the sponsorship of ERDA. This research and development program is being conducted to assess the capabilities of pressurized fluidized-bed combustion from the point of view of minimizing pollution, especially from high-sulfur coals; avoiding excessive maintenance because of corrosion in conventional plants; and reducing capital and operating costs of electric power generating systems. The program enables ERDA to obtain combustor performance data on systems of substantial size, while obtaining additional research information. The specific purpose of this contract is to establish the effect on performance of:

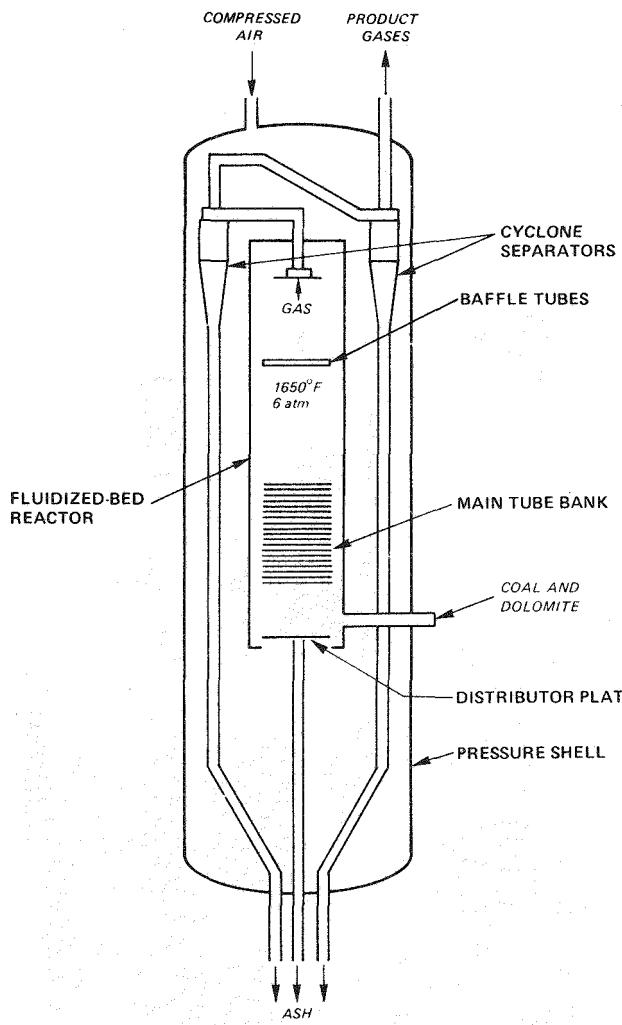
- Fouling of turbine blades
- Emission of alkalis and sulfur and nitrogen oxides
- Bed behavior (clinker formation) at higher temperatures ( $1650^{\circ}\text{ F}$  to  $1750^{\circ}\text{ F}$ ) than previously used for this type of combustor ( $1470^{\circ}\text{ F}$ ).

The data acquired will be combined with other data on fluidized-bed combustors and will be used as the design basis for a pressurized fluidized-bed combined-cycle plant.



### PROCESS DESCRIPTION

Figure VI-1 is a schematic of the pressurized fluidized-bed combustor being used in the NRDC test program. The reactor, the principal component of the unit, has a distributor plate in addition to an immersed bank of water-cooled tubes for regulating the bed temperature. Baffle tubes (without cooling) are located above the bed surface for fluid dynamic stability. Another important component of the combustor is a two-stage system of cyclone separators. The reactor and separators are enclosed in a pressurized shell (with an



**Figure VI-1. NRDC PRESSURIZED FLUIDIZED-BED COMBUSTOR**

internal diameter of six feet) to eliminate stresses that large pressure differentials would generate on the reactor refractory. Pulverized coal, with dolomite added for removal of sulfur compounds, is carried to the base of the fluidized-bed reactor by an air stream. Pressurized air enters the top of the shell, flows around the internal components, and enters the base of the reactor through the distributor plate, where it is used as the fluidizing medium. The product gases are passed through the cyclone separators to remove entrained fines. The gas can be used in a combined-cycle process.

## HISTORY OF THE PROJECT

Early work by NRDC/BCURA on pressurized fluidized-bed combustion involved 1,000 hours of test runs

(1968 to 1971) at a bed temperature of 1470° F, using Pittsburgh seam and some United Kingdom coals. The results of these tests indicated that turbine erosion and deposition were negligible and that sulfur emissions could be controlled by adding dolomite.

Under the current contract, which began in August 1972, the combustor was modified to permit it to operate at higher temperatures. Four tests were conducted, with changes in combustor pressure, coal origin, bed temperature and sulfur dioxide acceptor. In these experiments, NRDC/BCURA found that:

- Combustion efficiencies exceeded 99 percent at 1750° F and were only slightly lower at 1650° F.
- Sulfur emissions for 3 percent sulfur coal could be limited to 0.1 pound per million Btu by adding dolomite at a calcium-sulfur ratio of slightly greater than two.
- Nitrogen oxide emissions averaged about 0.2 pound per million Btu.
- Deposits on the cascade blades did not occur to a significant extent at bed temperatures of 1650° F, but were sufficiently extensive at bed temperatures of 1750° F to be a potential source of operating problems.
- The ash in the bed did not sinter or adhere to the walls under any of the operating conditions investigated.

The main conclusion from these results is that performance when burning Illinois and Pittsburgh seam coals at bed temperatures of around 1650° F should be as good as the performance achieved in previous tests. The ability to operate at higher temperatures in a combined-cycle plant will result in a further saving in fuel (about 2 percent) and an extension in operating load range that can be achieved by varying bed temperature.

This test program (Tests 1-4) was completed in September 1973, and NRDC prepared a final report. In late 1974, the program was extended to include a fifth test to investigate fluidized-bed combustion at a bed temperature of 1650° F and an excess air rate of 100 percent, with attention also directed to any primary or secondary cyclone depositions and to cascade erosion, corrosion, and deposition. Currently, contract negotiations are in progress to expand the number of fluidized-bed tests at 1650° F to investigate the effect of various excess air rates, bed depths, and bed velocities on combustion efficiency, sulfur and nitrogen oxides emissions, and circulation. Additional construction materials will be tested for corrosion resistance.

## PROGRESS DURING OCTOBER-DECEMBER 1976

### Summary

The combustor was pressure tested and commissioned during the quarter and Test 6 began in mid-November. Coal-burning continued for 70 hours before the unit was shut down due to a complete hold up in the coal feed hopper. Adequate data were obtained, however, to achieve the objectives of Part I of the test. Part II of the test will be conducted in January. Repairs on the secondary cyclone which interrupted the test were completed and preparation for Part II began.

### Discussion of Activities

After the combustor was pressure tested and commissioned, Test 6 began in November. The test was scheduled to be conducted in two parts and to be run without a break, if feasible. After 70 hours of operation, the test was curtailed to investigate a high pressure drop in the secondary cyclone. This occurrence resulted from a hold up in the coal feed hopper and the unit had to be shut down.

Most of the objectives of Part I were achieved during the test with adequate data obtained to analyze temperature distributions, heat transfer rates, combustion

efficiency, heat and mass balances, and nitrogen oxide and sulfur dioxide emissions.

Operating conditions of the test were:

Fluidizing velocity	2.5 feet per second
Bed temperature	1605° F
Pressure	70 psig
Excess air	25 percent
Dolomite feed rate	103 pounds per hour
SO <sub>2</sub> in exhaust	680 ppm

Samples of coal, dolomite, bed overflow, and dust collected by the primary and secondary cyclones were analyzed to calculate heat and mass balances.

Preliminary analysis indicated a high combustion efficiency with no detectable carbon monoxide in the offgas, and no evidence of sintering in the bed.

Problems were experienced with coal feeding. The three to five percent surface moisture content of the coal was higher than specification, leading to difficulties in feeding coal from the pressurized feed hopper into the conveying lines.

The high pressure drop that developed across the inlet to the secondary cyclone was found to be due to a distortion of the inlet passageway, presumably caused by a temperature/pressure wave. Repairs to the cyclone were completed and the coal was prepared for Test 6, Part II.



## VII. COAL-OIL SLURRY COMBUSTION PROGRAM

ERDA/FE with in-house technical support of:  
**PITTSBURGH ENERGY RESEARCH CENTER**  
**PITTSBURGH, PENNSYLVANIA**

### INTRODUCTION

A coal-oil slurry combustion project is being conducted by the Pittsburgh Energy Research Center (PERC) to provide ERDA with an in-house technical capability in support of its coal-oil slurry combustion program. The purpose is to investigate and validate the potential of this near-term retrofit technology for oil conservation and increased coal utilization. PERC is presently operating a 100 Hp firetube oil-fired boiler on coal-oil slurry and is designing and constructing a liquid-fuel-fired Combustion Test Facility (CTF) analogous to the one currently operated by the Energy Conversion Group for solid fuel research. The CTF should provide the data required to design combustion systems using various slurries under process development for both industrial and utility boilers.

The objective of the CTF program is to demonstrate the value of using coal-oil slurries in commercial oil-fired boilers without the need for extensive retrofitting modifications. Because coal-oil slurries often demonstrate physical properties and combustion characteristics different from conventional petroleum-based fuels, new burner designs and system requirements will have to be developed. Fuel characteristics affecting the design of feed systems include atomization and mixing of fuel with combustion air, air preheat requirements, flame characteristics and stability, and heat-transfer properties.

The CTF program will include the following tests:

- Shakedown
- Slurry erosion
- Slurry suspension stability

- Slurry combustion
- Slurry handling
- Slurry characterization
- Flue gas emission control
- Economic analyses of various slurries in retrofitted steam generating plants.

Data collected from the above tests will be used to design combustion systems using various slurries for both industrial and utility boilers.

### PROCESS DESCRIPTION

The main components of the CTF include:

- An air cooled steam condenser and condensate unit
- Coal-oil slurry mixing and feed equipment
- Flue gas cleaning equipment
- Fuel storage facilities
- Coal preparation equipment

Raw coal feed is first crushed to —200-mesh and then fed to a slurry mixing tank. Dust is controlled in the crushing area through the use of a pulverizer blower and a cyclone blower and baghouse system. No. 6 fuel oil, heated to 1000° F by a suction heater, is mixed with the pulverized coal in the slurry mixing tank. The slurry is then conveyed to a slurry holding tank mounted on a weigh scale. As required, the feed slurry is pumped to a preheater, heated to 300° F, and injected into the air-blown combustor.

Hot flue gas from the combustor is cooled and mixed with pulverized sodium bicarbonate, which absorbs significant quantities of sulfur dioxide present in the flue gas. After the particulates are removed in a baghouse, the clean gas is discharged to a 60-foot stack.

The steam produced by the test boiler is condensed in an air-cooled heat exchanger. The condensate is then deaerated, conditioned with chemicals, and recycled to the boiler.

## HISTORY OF THE PROJECT

The difficulties of converting oil-fired facilities to coal-firing are well documented. One alternative which has been studied to some extent is the supplementing of fuel oil with pulverized coal-oil slurries. Preliminary studies have shown that this approach would cost less than firing oil exclusively and would require only minimum changes to existing boilerhouse facilities. The development of viable slurry-firing processes poses a short-term solution to restriction on fuel supplies by reducing oil consumption by up to 40 percent in application units now firing with oil. The markets which could make use of this plan include both large and small industrial units and utility companies.

The CTF was designed under the constraints and conditions of a commercial packaged boiler and auxiliaries so as to permit the test results to be applied directly to industrial situations. The CTF will, however, be extensively instrumented and contain a computer-controlled data acquisition system to allow for on-line, real-time analyses and computations. With this equipment, the operating characteristics will be defined with a minimum of experimental tests.

## PROGRESS DURING OCTOBER-DECEMBER 1976

A number of modifications were made to the 100 HP boiler during the quarter. The most significant change was made in the control of the fuel feed line. A back pressure control system maintains a constant pressure in the line to the burner nozzle using a recirculating flow. Alternatively, the variable speed drive on the pump can be regulated, without recirculation, to maintain the appropriate pressure at the nozzle. A high-pressure alarm and shutoff were included in the variable speed pump for safety.

Modifications were also completed to allow automatic control of the fuel and combustion air flows from the instrument room. Normal operation and complete efficiency tests can now be conducted from the instrument room.

Equipment was set up to run specific gravity, viscosity, and ash content determinations on the fuel used in the combustion tests. The behavior of the slurry during operation and the progress of the mixing operation can be monitored.

Also during December, a test using material supplied by Georgia Tech was run. The material was a low-volatile solid and a pyrolysis oil, derived from wood. A deposit which developed in the nozzle required the unit to be shut down. A 100-mesh screen was installed between the heater and nozzle to remove the fine particles believed to have caused the deposit.

Available equipment was set up to begin a test program on the rheology of coal-oil slurries. During the next quarter, the major effort will be directed toward answering questions on aging, the change in viscosity as the slurry sits unstressed, and the recovery time.

Work began on the Combustion Test Facility and was 29 percent complete at the end of the quarter.

## VIII. SOVENT-REFINED COAL (SRC) COMBUSTION TEST PROGRAM

PITTSBURGH ENERGY RESEARCH CENTER  
PITTSBURGH, PENNSYLVANIA

### INTRODUCTION

As part of the overall ERDA program to increase coal utilization, combustion tests on Solvent-Refined Coal (ERC) are being conducted by the Pittsburgh Energy Research Center (PERC). SRC is a low-ash, low-sulfur, coal-derived fuel having a melting point of less than 300° F and a heating value of approximately 16,000 BTU per pound. Although the process of solvent refining is fairly well defined, there has as yet been no effective evaluation of SRC as a utility boiler fuel. The specific purpose of this project, therefore, is to study the handling, pulverizing, combustion, and fouling characteristics of SRC.

race type mills, but heat generated by the processes caused the SRC to soften and agglomerate. The possibility still exists, however, that these difficulties could be overcome by strict temperature control of the material in the mill.

After being pulverized, the SRC is pneumatically transported to a recycle loop in the primary air-fuel transport line. This recycle loop minimizes fluctuations in the primary air-fuel ratio. The fuel is then injected through four burners into the furnace, which is seven feet wide, twelve feet high, and five feet deep. In the combustion chamber, the burners impart a swirl to both the primary and secondary air streams.

### PROCESS DESCRIPTION

The SRC combustion test program uses a multi-burner, water-wall furnace designed to burn pulverized coal at a nominal rate of 500 pounds per hour. The SRC being used in the project was obtained from the six-ton-per-day pilot plant in Wilsonville, Alabama. The material was produced from a high-sulfur Illinois coal. The SRC contains 0.8 percent sulfur, 0.3 percent ash, has a heating value of 15,400 BTU per pound, and has a fluid temperature of less than 300° F.

In the test program, the SRC is air dried, transported to a feed hopper, and then conveyed to a pulverizer by a screw feeder. It is then pulverized in an impact mill with integral classification. Previous studies were conducted on hammer mills and ball-and-

### PROGRESS DURING OCTOBER-DECEMBER 1976

Results of combustion tests conducted with solvent refined coal (SRC) in the 500-pound-per-hour furnace were reported. It was found that significant reductions in nitrogen oxide emissions were achieved by reducing the amount of excess air. The nitrogen oxide emissions at or below 20 percent excess air were less than the federal standard of 0.7 pounds NO<sub>2</sub> per million BTU. The flames were stable at all excess air levels. Deposit formation was evident on the burners when combustion air was reduced to five percent excess. Extended operation was not possible under these conditions. The carbon combustion efficiency was 99 percent or greater at all excess air levels except five percent, at which the combustion efficiency dropped to 98.4 percent.

The original burners were refurbished and installed in the 500-pound-per-hour furnace during the quarter,

in order to test fire char from an agricultural waste pyrolysis process developed at Georgia Tech. The material was prepared from sawmill waste consisting of pine bark and sawdust. Char samples with 5.0 and 35.9 percent volatile levels were supplied. Initial combustion tests were conducted firing the chars blended with an equal weight of Pittsburgh seam coal. Blending was accomplished in a "V" type blender. Sufficient materials were prepared to complete combustion tests. An additional test was conducted firing the high volatile char alone.

In all tests, stable flames could be maintained with 600°-650° F secondary air preheat. Nitrogen oxide emissions were significantly lower than emissions obtained from combustion of pulverized coal under the same firing conditions. Combustion efficiency appeared to be rather low for the low-volatile blend test. The fuel particle size was considerably larger than desired and a large amount of ash was formed. Consequently, the test will be repeated with particular attention given to the particle size of the fuel and more precise burner adjustments.

## IX. ANTHRACITE REFUSE UTILIZATION

MORGANTOWN ENERGY RESEARCH CENTER  
MORGANTOWN, WEST VIRGINIA

### INTRODUCTION

Anthracite refuse and silt bank materials which have resulted from the mining and cleaning of anthracite coal in the northeastern section of Pennsylvania are potential sources of low-carbon, high-ash fuel. The mining region in which the material is located covers only about 480 square miles and is fairly densely populated. The U.S. Bureau of Mines has estimated that within the area there are 800 banks containing a total of 910 million cubic yards of refuse. This material has been deposited by mining operations and reject streams from preparation and cleaning plants over the entire history of the region. The deepest layers of material were deposited over 100 years ago when preparation methods were crude, whereas the surface layers have resulted from much better washing procedures and are therefore essentially depleted of coal. Some of the older banks have been reworked in recent years using better cleaning methods to recover the coal and consequently the characteristics of the refuse varies widely from bank to bank and even within a single bank.

The Morgantown Energy Research Center (MERC) is investigating the combustion characteristics of the refuse materials in a fluidized-bed combustor. Due to the declining mining activity in the area and the subsequent growing dependence on oil, the value of the refuse as a fuel is becoming increasingly important. In addition, the refuse banks are aesthetic eyesores in the community, are occupying valuable land which could be used for other purposes, and constitute a potential health and safety hazard due to the likelihood of spontaneous combustion. The use of the material as a fuel in fluidized-bed combustors would not only provide a needed energy source in the area, but

would also reduce some of the problems currently associated with the banks.

### PROCESS DESCRIPTION

The MERC atmospheric pressure fluidized-bed combustor is a refractory-lined cylindrical combustor with an 18-inch internal diameter in the bed region and an expanded freeboard cross section of 24-inch diameter. The combustor is equipped with a horizontal, water-cooled heat exchanger submerged in the bed and a separate water-cooled tube bundle in the freeboard to reduce exit gas temperatures. To control temperatures with the low-heating-value refuse fuels, six hairpin loops of  $\frac{1}{4}$ -inch 310 stainless steel pipe with individual water flow controls were installed.

Fuel is pneumatically injected into the base of the combustor with ambient-temperature air. Fluidizing air is supplied through a plenum which feeds several orifices in the conical distributor. Solids which are removed from the exiting flue gas in the primary cyclone are reinjected into the bed by an air injector for carbon burnup. Flue gases leaving the cyclone are further cleaned by a secondary cyclone and parallel bag filters prior to discharge through the stack. Gases are sampled at the combustor outlet for on-line analysis purposes. Excess spent bed material is withdrawn through the apex of the inverted conical air distributor by a screw feeder.

A five-day operating period is typical for the combustor. Startup begins by preheating the empty combustor vessel with a premixed natural gas-air flame

through the air distributor. Upon reaching operating temperature, the fluidized bed is built by feeding either a 50-50 mixture (by weight) of anthracite coal and inert material (such as limestone) or with refuse directly. When the planned depth has been achieved, the natural gas flow is curtailed and the temperature of the bed is stabilized by adjusting water flow in the submerged heat exchanger followed by reinjection of the primary cyclone ash. The complete startup procedure requires two to four hours from cold lightoff to stabilization of temperatures with normal feeding of refuse and reinjected ash.

## PROGRESS DURING OCTOBER-DECEMBER 1976

The No. 2 18-inch fluidized-bed combustor was delivered and erection of the unit was initiated during the quarter. The refractory was repaired and the combustor set in place. Structural steel and piping modifi-

cations were underway. Total reconstruction of the unit was 40 percent complete by the end of the quarter.

The last two runs on Kamenski No. 14 bank refuse were completed in November, finishing that series of runs. The refuse had a heating value of 4,505 Btu per pound and contained 58 percent ash.

A one week run was completed under the EPA contract with Battelle as subcontractor. Data from this run will be used to analyze for emissions from a commercial-sized fluidized-bed combustor.

The valve test program required a continuous source of 1600° F particulates for cycling through valves undergoing destructive testing. A series of runs were made using the fluidized-bed combustor as a solids heating mechanism. A series of tests were run in the FBC to determine how much spent bed material could be recycled and heated to 1,600° F without upsetting the operation. Results showed that 2.0 to 2.5 times the weight of bed material can be heated to bed temperature per hour without losing control of the operation.

## X. HIGH TEMPERATURE DUST CONTROL

CONSTRUCTION ENGINEERING RESEARCH  
LABORATORY

U.S. DEPARTMENT OF THE ARMY

CHAMPAIGN, ILLINOIS

Contract No.: E(49-18)-1782

Total Funding: \$67,302  
(100% ERDA)

### INTRODUCTION

Under the sponsorship of ERDA, the Construction Engineering Research Laboratory (CERL), U.S. Department of the Army, is evaluating the efficiency of a patented (U.S. Patent No. 3,815,336) Particle Precipitating Heat-Transfer Surface (PPHTS) device in removing dust particles from the high-temperature exhaust gas streams of fluidized-bed combustors. The fluidized-bed combustor used in the project is operated for ERDA by Pope, Evans, and Robbins, Inc. (PER) at a government-owned test facility in Alexandria, Virginia.

- Procurement of the necessary components and fabrication and installation of the apparatus
- Calibration of the automatic particulate analyzer, flow monitoring apparatus, and pressure and temperature transducers
- Development of procedures for data acquisition and reduction
- Provision of assistance to PER during operation of the combustor in acquisition of the necessary data and performance of subsequent data analyses and summaries

### PROGRESS DURING OCTOBER-DECEMBER 1976

#### PROGRAM DESCRIPTION

The PPHTS evaluation project, which began in July 1975, is scheduled for completion by mid-1976. The tasks included in the project are:

- Design of the test apparatus and PPHTS test sections

The principal program effort during the quarter was directed toward compiling, preparing, and drafting the component sections of the final report. Previous problems which resulted in delays in producing the report have been resolved and the report will be available for summary in the near future.



## XI. APPLICATIONS OF FLUIDIZED-BED COMBUSTION TECHNOLOGY TO INDUSTRIAL BOILERS

EXXON RESEARCH AND ENGINEERING COMPANY

LINDEN, NEW JERSEY

Contract No.: E(49-18)-1798

Total Funding: \$112,000

ERDA: \$100,000

FEA/EPA: \$12,000

### INTRODUCTION

Several coal conversion technologies, including direct combustion of coal in a fluidized-bed boiler, coal liquefaction, and coal gasification, are currently being developed. When implemented on a commercial scale, these technologies will greatly increase the utility of coal as a highly acceptable source of industrial energy. Of these technologies, fluidized-bed combustion offers the greatest possibility of near-term implementation. Therefore, Exxon Research and Engineering Company is conducting a research program to study the diverse industrial applications of fluidized-bed combustion technology. The project is being sponsored jointly by ERDA, the Environmental Protection Agency (EPA), and the Federal Energy Administration (FEA).

The objective of this study is to conduct economic, energy, and environmental analyses of the industrial applications of atmospheric and pressurized fluidized-bed technologies as methods of using coal to generate electrical power and process steam for in-plant use. Some advantages anticipated with fluidized-bed combustion technology are improved pollution control, high thermal efficiencies, reduced capital and operating costs, and the ability to use a wide variety of coal types. In addition, fluidized-bed combustion systems are expected to surpass air quality standards for stationary source emissions.

### PROGRAM DESCRIPTION

The program was initiated in January 1975 and is scheduled for completion in late 1976. The study will consider both new and retrofitted atmospheric fluidized-bed boilers with steam output capacities ranging from 10,000 to 400,000 pounds per hour. The effects of fluidized-bed combustion technology will be evaluated for each industrial sector, a composite of all industries, localized geographic regions, and the entire nation. The key dates for which these effects will be predicted are 1980, 1985, 1990, 1995, and 2000. The tasks involved in the project are:

- Determination of the applicability of fluidized-bed combustion technology for meeting industrial boiler requirements based on:
  - life-cycle cost
  - energy conversion efficiency
  - reliability
  - maintenance requirements
  - stack gas emissions
  - waste disposal and utilization
  - required plant characteristics
  - fuel flexibility
  - ease of installation and operation
- Development of estimates and confidence limits for the maximum degree of industrial application based, as a minimum, on fluidized-bed combustion technology characteristics, industrial sector

specifications for boilers, boiler age distribution, and boiler replacement data.

- Assessment of the demand for fluidized-bed combustion technology, including consideration of the cost of fluidized-bed combustion systems, capital availability, equipment production capabilities, environmental acceptability, industrial propensity to switch to new boiler design, competing technologies, and solid waste characteristics with respect to disposal and utilization. The assessment is to provide the numbers of fluidized-bed boilers that will be required by industry to satisfy the maximum, minimum, and most realistic projected demand.
- Determination of the impact that demand for and application of industrial fluidized-bed combustion technology will have on total national energy consumption and on reduction of fuel oil and natural gas consumption.
- Analysis of economic data, capital requirements, and operating costs of the fluidized-bed combustion systems; calculation of the economic implications of fluidized-bed combustion applications; and comparison with the costs of other alterna-

tives, such as the use of clean fuels in a conventional boiler.

- Determination of the effect of industrial fluidized-bed technology applications on air emissions, solid waste production, and effluents to water, and comparison with the environmental effects of other technologies and other fuels and industrial power and steam sources.
- Determination of specific technical requirements for representative industrial fluidized-bed boilers, based on the demand, economic, environmental, and technical analyses.

## PROGRESS DURING OCTOBER-DECEMBER 1976

The final project report, "Application of Fluidized-Bed Technology to Industrial Boilers," was approved and printed during the quarter. The document is available through the National Technical Information Service, Springfield, Virginia 22161.

## XII. ON-LINE PARTICULATE ANALYSIS INSTRUMENTATION

LEEDS & NORTHRUP COMPANY  
NORTH WALES, PENNSYLVANIA

Contract No.: E(49-18)-2412

Total Funding: \$75,816  
(100% ERDA)

### INTRODUCTION

An on-line particulate analysis instrument is being developed by Leeds & Northrup Company, under ERDA sponsorship, for pressurized fluidized-bed combustion systems. The objective of this project is to design and construct a prototype instrument to measure particulate loadings and particle size distributions in high temperature gas streams and to evaluate this instrument on pressurized fluidized-bed combustion systems. This type of instrumentation will enable near real-time monitoring and analysis of gas entrained particles to evaluate performance of particle separators and to record the size and concentration of particles at the inlet to gas turbines in direct combustion systems. This capability will provide critically needed information relative to analysis of turbine blade erosion problems.

The instrument development work is based on Leeds & Northrup's prior work in low-angle forward scattering of light by suspended particles. The development phase of this project involves extending the method to instrumentation compatible with large gas ducts and applicable to high temperature (1500°-2000° F) and high pressure (up to 10 atm.) gas streams. Following the development phase, a prototype instrument will be delivered to Argonne National Laboratory for initial evaluation on its six-inch fluidized-bed combustor.

### MEASUREMENT METHOD

When small particles are illuminated by a laser light source, a diffraction pattern is produced in the Fraunhofer plane of a collection lens. The intensity and angular distribution of the diffracted flux is related to the size of the particle in the illuminating beam. Large particles produce a narrowly defined flux pattern, while smaller particles diffract flux over wider angles and with lower flux intensity. The angular extent of the diffraction pattern is given by the equation:

$$\sin \theta = (1.22/d)\lambda$$

where:  $\theta$  = half angle to the first minimum of the pattern

$\lambda$  = wavelength of light source

$d$  = particle diameter

The total intensity of the scattered flux is given by:

$$I = Knd^2,$$

where:  $I$  = total diffracted light

$K$  = instrument calibration constant

$n$  = number of particles

$d$  = particle diameter

If a specially shaped spatial filter is placed in the Fraunhofer plane of the collection lens, the intensity of the transmitted scattered light can be made proportional to any power of the particle diameter. In particular, a disk-shaped spatial filter has been designed and constructed to produce signals proportional to the fourth, third, and second power of the particle diam-

eters in the illuminating beam. The three functions are separated in angular extent and rotated to allow serial extraction of information.

The transmission characteristics are optimized through a special computer program based on the mathematical expression (Bessel function) for the intensity distribution of the diffracted flux. The exact spatial filter characteristic design or shape is adjusted so that the response per unit function ( $d^4$ ,  $d^3$ ,  $d^2$ ) is constant for all particle sizes within the range of the measurement. The three signals generated by a rotating disk are collected and averaged over many rotations of the spatial filter. Ratios are computed to find the mean diameter of the particle distributions as well as the variance of the distribution. The  $d^3$  signal is proportional to the volume of particles illuminated and thus can be calibrated for concentration of particles in the fluid stream.

To apply such measurement to hot gas streams requires optical filtering to eliminate infrared radiation emitted by the particles and from the walls of the duct, scaling the size of the optical components for across-the-duct sampling, and working out means for air purge to keep the quartz windows on the duct clear of any deposits. Since it is believed that any particles larger than four microns in diameter are detrimental to turbine blade life, the size range of interest for this instrumentation is 1-50 microns. This range of particle

size can be measured using a helium-cadmium laser having a wavelength of .325 micron.

## PROGRESS DURING OCTOBER-DECEMBER 1976

A meeting held at Curtiss-Wright in December resolved the installation plans for the particulate instrumentation. Upon completion of tests at Argonne National Laboratory (ANL), the instrument will be returned to Leeds and Northrup Company (L&N) for modification to enable the instrument to be installed for subsequent testing on Curtiss-Wright Corporation's small gas turbine unit. Tests will be performed initially on the four-inch diameter inlet in the turbine, followed by testing on the ten-inch duct of the final filter.

The instrument assembly was completed and checked out during the quarter. Functional tests on background noise, particle size calibration, and sensitivity were performed. Problems with the laser performance, optical prism, and background noise were identified and solutions initiated. After these problems are resolved, the instrument will be shipped to ANL.

The instruction manual draft was also prepared during the quarter.

### XIII. PARTICLE MEASUREMENT IN FLUIDIZED-BED COMBUSTION SYSTEMS

SPECTRON DEVELOPMENT LABORATORIES, INC.

COSTA MESA, CALIFORNIA

Contract No.: E(49-18)-2413

Total Funding: \$17, 219  
(100% ERDA)

#### INTRODUCTION

The primary objective of this program is to assess the capability of an advanced diagnostic technique to make required particle field measurements in fluidized-bed combustion (FBC) systems. These measurements are needed, for example, to determine efficiencies of particle separators and filters, and to monitor particle environments at gas turbine inlets of combined cycle systems. Measurements will be made at the Argonne National Laboratory (ANL) FBC facility, and will provide data on particle size and velocity distributions in the combustion gas flows. Currently available SDL laser instrumentation will be used for data acquisition.

#### PROGRAM DESCRIPTION

##### Instrument Description

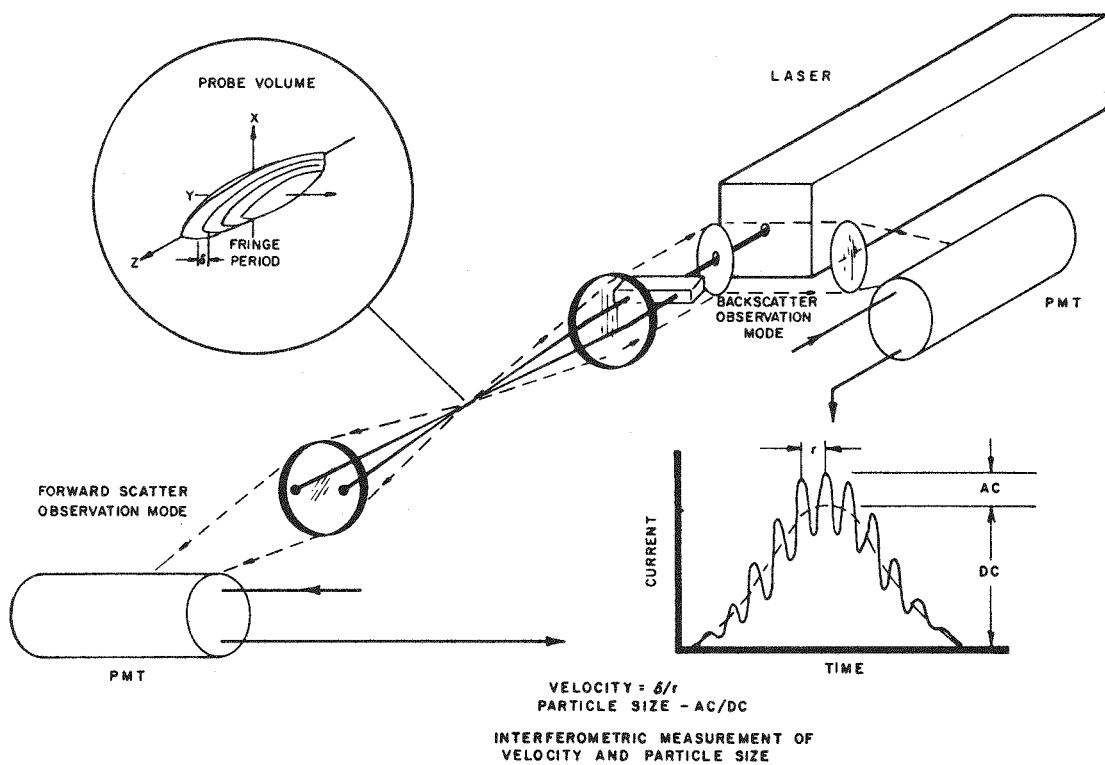
The SDL equipment to be used in this program is a laser light scattering instrument called a Particle Morphokinometer (PM) system. Key features of the instrument for the FBC application include:

- In-situ measurement
- Simultaneous size and velocity measurement
- Electronic data processing and management

- Continuous and real time data output
- Easy interface with user computer and control systems

The system is shown schematically in Figure XIII-1. The light beam emitted from a continuous wave (CW) laser is divided in two and subsequently re-mixed by optical components. The region where the two beams cross contains the measuring probe volume, remote from instrument hardware. In the probe volume, light from the two beams interfere, resulting in a set of interference fringes as illustrated in the sketch. As particles pass through the probe volume, the interfered light is scattered and collected into a photomultiplier tube (PMT), either in the forward or backscatter mode. The PMT output, shown in the sketch (lower right), is then processed electronically to determine individual particle size and velocity. Velocity is measured by ratioing the fringe period,  $\delta$ , to the signal time period,  $\tau$ . Size is determined by a function of the signal AC to DC ratio. Individual measurements can then be displayed one at a time, stored in a histogram generator, or input to user computer or control systems.

PM systems similar to the one to be used at ANL have been employed successfully to measure particle size and velocity distributions in various other applications. These include air pollution particles from airborne platforms, cloud chambers, furnaces, and erosion test facilities.



### Figure XIII-1. PARTICLE MORPHOKINETOMETER SYSTEM

## ANL Application

An SDL PM system will be installed at the ANL FBC facility to measure particle size and velocity in the combustion gas at several different stations. The system will be used in the backscatter mode at ANL. Optical access to the flow will be made through optical windows designed by SDL and installed by ANL.

## **PROGRESS DURING OCTOBER-DECEMBER 1976**

The Particle Morphokinetometer System was installed at the Argonne National Laboratory's fluidized-bed combustion facilities in October. The system was checked out and data collected. Personnel were trained to operate the system during the remainder of the month.

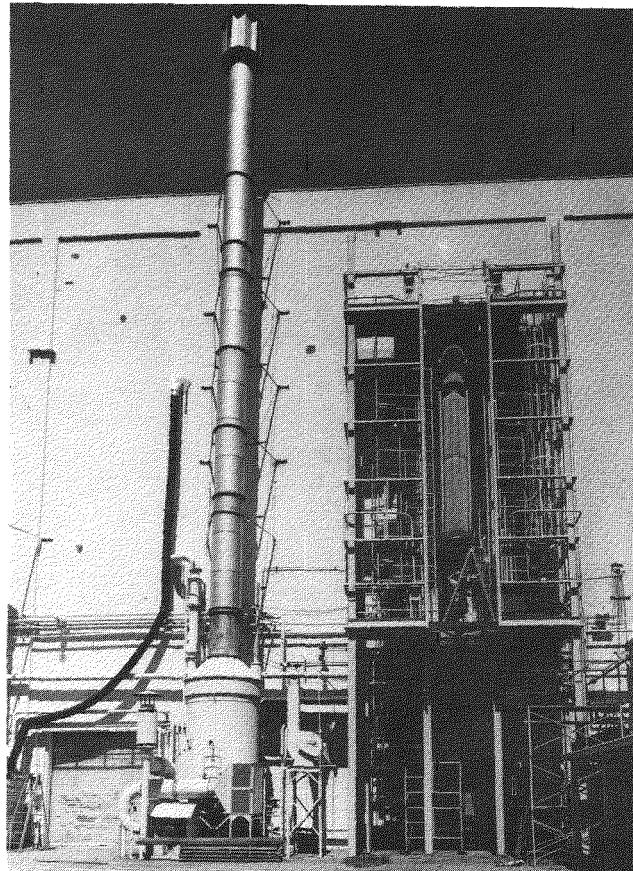
## XIV. BOILER TUBE BUNDLE AND BURNER MODULE TESTS WITH POTASSIUM

OAK RIDGE NATIONAL LABORATORY  
OAK RIDGE, TENNESSEE

### INTRODUCTION

Boiler fuel consumption can be reduced by increasing the efficiency of thermodynamic cycles. Little has been done to increase efficiencies since the upper practicable temperature limit (about 1000° F) for the steam cycle was reached more than 25 years ago. Thermodynamic efficiency is directly related to the absolute temperatures at which heat enters and leaves the process. Thus, to increase thermal efficiency further, temperatures must be higher, which implies the use of other working fluids. A leading candidate for an advanced thermodynamic cycle is a potassium or cesium vapor cycle. Oak Ridge National Laboratory (ORNL) is conducting tests of a boiler tube bundle module and burner assembly with potassium.

The approach proposed by ORNL involves raising the peak temperature of the thermodynamic cycle by using a potassium vapor Rankine topping cycle that operates with a turbine inlet temperature of 1,500° F to 1,600° F and a condenser temperature of about 1,100° F. This topping cycle is superimposed on a conventional steam cycle with a turbine inlet temperature of about 1,000° F by transferring the "waste" heat rejected from the condensing potassium vapor to the boiler water of the steam cycle. The combined cycle is similar to the mercury-steam binary vapor cycle used in seven plants built in the United States between 1925 and 1948. However, the operating temperature of these plants was limited to 900° F because, at higher temperatures, severe corrosion of all types of steel by mercury made operation impractical. The 900° F mercury turbine inlet temperature was higher than the steam turbine inlet temperature in plants of the 1920's, but



by the late 1930's it was surpassed by new steam plants whose higher temperatures and higher thermal efficiencies made the mercury vapor system obsolete.

### PROCESS DESCRIPTION

The basic layout of the proposed power plant is shown in Figure XIV-1. Three basic systems are combined to form the power plant: a gas turbine that uses exhaust gases from the combustion chamber, the potassium vapor topping cycle, and an essentially standard steam cycle. Energy from hot gases produced

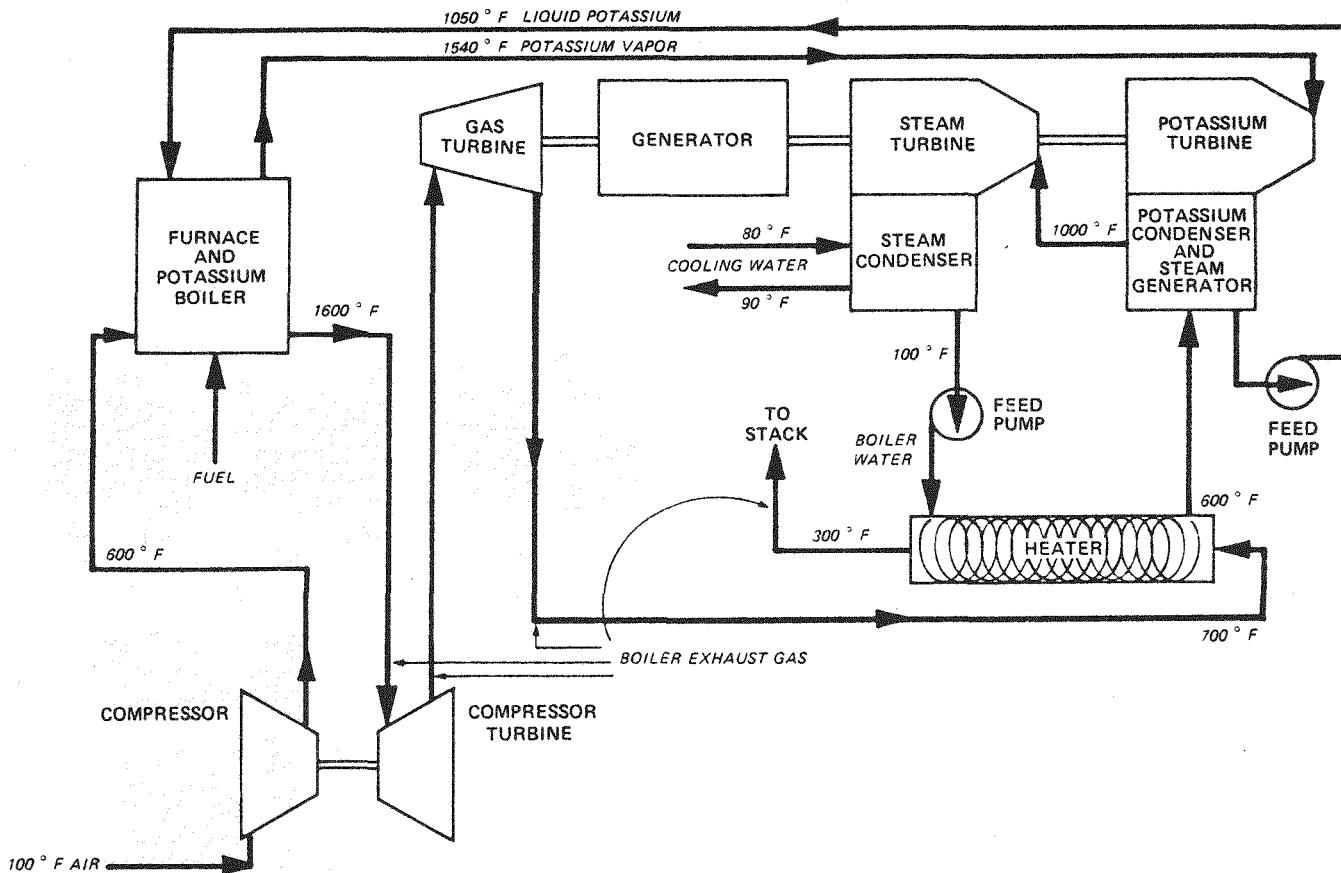


Figure XIV-1. SCHEMATIC OF POTASSIUM VAPOR COMBINED-CYCLE SYSTEM

by the combustion process is extracted by all three systems, for conversion to electricity in the generator. The most important components involving new technology are the furnace-potassium boiler and the potassium condenser-steam generator. Both use tube bundle modules as their basic unit of construction.

The ORNL gas- or oil-fired potassium boiler concept employs a basic bundle module composed of two annular rows of 1-inch-diameter stainless steel tubes arranged around a 22-inch-diameter, long, vertical, cylindrical combustion chamber. The flame from the burner directs hot gas upward through this combustion chamber. The tubes are bent at the top to provide passages between them so that the hot gas from the top of the combustion chamber can flow radially outward and then downward through an outer annulus over the outer row of tubes. To reduce the amount of heat transfer surface area required, the furnace and combustion chambers would be operated at a pressure of six to ten atmospheres. This is substantially above the two atmospheres which would be the design oper-

ating pressure of the potassium vapor system. Potassium would circulate by natural convection from a header tank at the top of the tube bundle through two downcomers, one on either side, to two ring-shaped manifolds at the bottom, and then vertically upward through the tubes back to a header drum and vapor separator at the top of the header drum and vapor separator at the top of the header tank. About 200 tube bundles of this type, grouped 19 to a furnace shell, would be required in a 600 Mw power plant.

The boiler tube bundles would be mounted in four to eight furnace shells. In this layout, the burner assemblies are independently mounted in the bottom head of the furnace shell with individual flanges so that any burner can be removed without disturbing the others. The boiler tube bundles are also independently mounted to a grid at the top, which in effect serves as the top head. The design is such that any tube bundle can be replaced independently of the others by disconnecting it and withdrawing it through either the top or the bottom of the furnace.

## HISTORY OF THE PROJECT

### Potassium Boiler

Work on alkali metal vapor cycles at ORNL began with some design studies under the Aircraft Nuclear Propulsion program in 1954 and was resumed in 1958 with studies of nuclear electric space power plants. This led to an extensive series of component and system tests, in the course of which  $\sim 200,000$  hours of boiling potassium system operation was obtained in the early and middle 1960's. When the pressing need for reductions in both fuel consumption and heat rejection to the environment became evident in 1970 a design study of a potassium vapor cycle plant was conducted under National Science Foundation (NSF) sponsorship. This plant was designed to operate on clean gaseous fuel derived from coal, the preferred fuel-of-the-future for central stations at that time. The study showed that the greatest uncertainties from both the design and cost standpoints lay in the potassium boiler, and that these could be resolved best by designing, building, and testing a full-scale tube bundle and burner module.

Funds to begin the work were made available by NSF in July, 1972 and NSF funding was continued in 1973. When ERDA was proposed in June, 1973, NSF responsibility for the potassium vapor cycle work became uncertain, with other federal agencies also having claims in this area. As a consequence of these uncertainties, the program remained unfunded through 1974, until some interim funds were made available from NSF. Funds from ERDA-FE finally became available for the program in December 1975.

An indication that the potassium boiler presents by far the most important set of uncertainties of any component in the plant, including the turbine, is indicated by the fact that in a study of advanced power systems being conducted for ERDA-FE, the initial capital cost estimate for a potassium vapor topping cycle plant yielded a cost for the potassium boiler that was greater than the sum total for all of the rest of the plant. The ORNL design yields a boiler with a much less expensive material, a weight about half as great, and a potassium liquid inventory less than 1/20 as great as was premised in the study, hence the cost should be much lower. The reason for these large differences is that the other study based the design on conventional, low pressure, horizontal tube, forced convection, steam boiler design practice, whereas the ORNL design is based on a vertical tube, natural

thermal convection boiler concept that goes well beyond established practice, although it employs a wealth of experience gained under the space power plant program.

The test program is designed to resolve the many uncertainties that have become evident in the course of the design. These uncertainties fall into four major problem areas:

- Burner performance
- Gas flow, with the associated heat transfer and temperature distribution uncertainties
- Two-phase potassium liquid-vapor flow and temperature distribution
- Vapor separator effectiveness.

All of these characteristics will be very dependent on the heat load. In many cases, the cumulative uncertainties in the analysis are substantial and can be resolved only by obtaining test data.

It is expected that data will be obtained that will give a detailed insight into these problem areas in the course of tests with water that were begun in July. In the first phase of the tests, the top of the boiler drum is open so that visual observation of the flow from the boiler tubes is possible. The boiler drum being open will make it much easier to install instrumentation that will yield a detailed picture of the flow distribution in the boiler tubes than will be the case in later tests with potassium.

### Potassium Boiler Coupled to a Fluidized-Bed

It has been evident for some time that a particularly attractive system could be obtained by coupling a potassium vapor cycle to a fluidized-bed coal combustion system. The design of a fluidized-bed coal combustion system differs in many vital respects from the design of any of the conventional types of coal-fired furnace. For good fluidization and acceptable stability of the two-phase gas-solid particle flow in the bed, the combustion air must be supplied to the base of the bed through a large number of relatively closely spaced ports orificed so that about one-third of the total pressure drop across the bed will occur at these inlet orifices. To keep the pumping power for the combustion air to a reasonable value, (around two percent of the net power output) the depth of the bed, if it is operated at atmospheric pressure, should not exceed about three feet. This in turn favors the use of horizontal tubes for the heat transfer matrix. If the

furnace is supercharged and the combustion air pumping power requirement is kept fixed, the depth of the bed can be increased in direct proportion to the furnace operating pressure. Increasing the bed depth has the advantage from the combustion standpoint of providing more time for fine particles of coal to burn; hence the amount of unburned carbon in the fines blown out of the bed can be reduced as the bed depth is increased. Increasing the bed depth also has the advantage that it makes possible the use of vertical tubes, which is particularly desirable for steam or potassium boilers where it is advantageous to employ natural thermal convection for recirculation of the liquid in the boiler. If the bed is too shallow, the tubes will be too short, the required number of tubes will increase, and the cost of making the tube-to-header joints becomes excessive.

In recent years, much attention has been given to furnaces pressurized to around ten atm, in which case pumping power requirements have been kept reasonable by making the furnace the combustion chamber for an open cycle gas turbine. Design studies of such systems have usually contemplated turbine inlet temperatures of approximately 1600° F. Unfortunately, over 30 years of experience with coal-burning gas turbines indicates that turbine bucket erosion, corrosion, and deposition have proved to be so serious that no one has yet succeeded in operating such units for more than a few hundred hours prior to a forced outage for at least a cleaning operation. This work has also shown that, if the turbine inlet temperature can be reduced to about 1000° F the problems with turbine bucket erosion, corrosion, and deposition become tractable and long turbine operating lives can be obtained. The best evidence to support this is the fact that dozens of gas turbines are in use for pressurizing blast furnaces, and these have demonstrated operating lives of the order of 100,000 hours without a need for major maintenance work.

Recent studies at ORNL indicate that a promising compromise is to operate the fluidized-bed at a pressure of three atm with a bed depth of about eight feet and an eight-foot-high plenum chamber above the bed to permit particles lifted out of the bed an opportunity to fall back into the bed and recirculate. The hot gases leaving the bed can be cooled to approximately 1000° F before being admitted to a gas turbine to give a power output just sufficient to drive the compressor. This arrangement has the additional control advantage that the gas turbine need not run at synchronous speed but rather can operate at much

reduced speeds during the startup or intermediate power conditions.

The ORNL fluidized-bed potassium boiler concept proposed follows the above approach in part for the reasons cited above, and in part to avoid the difficult creep-buckling problems associated with operating tubes, header drums, and manifolds at high temperature and under a large external pressure. This was a major factor in the large estimated boiler weight and cost in the study cited above.

## PROGRESS DURING OCTOBER-DECEMBER 1976

### Summary

All of the tasks planned for the water test, with the exception of the vapor separator test, were completed during the quarter. These tasks included measurement of the argon distribution, heat load of individual boiler tubes, boiler temperature distribution, combustion gas temperature distribution, and combustion air pressure drop.

Nearly all of the mechanical design work for the potassium system was completed this quarter. Modification of existing equipment and installation of new components for the system proceeded very well, with the piping and welding fabrication on the condenser being nearly complete.

### Water Tests

The argon distribution tests were completed during the quarter. Results indicated that the argon flow rate in all the boiler tubes was adequate to provide nucleation promotion for stable boiling of potassium.

One of the principal objectives of the water tests was to determine the stability of boiling and the uniformity of boiling heat load among the individual tubes. These measurements were also completed during the quarter. A sampler, built and installed in the boiler drum, was designed to collect the two-phase flow from one boiler tube at a time. The steam-water mixture from the tube passed through a calorimeter that was cooled by a measured flow rate of water. By measuring the change in the cooling water temperature, it was possible to determine the relative heat load of each boiler tube. The temperatures of the two-phase

mixture from the boiler tube and of the condensate leaving the calorimeter were measured to provide an indication of the quantity of steam condensed and the degree of subcooling of the condensate. Analysis of the results showed that the heat load of the outer bank of tubes was 67 percent of that for the inner bank. It was also determined that the variation for individual tubes was approximately ten percent from the average for each bank.

Boiler temperature distribution tests were also completed during the quarter. In order to minimize thermal stress in the boiler tube bundle, the boiler tubes and the liquid downcomers should operate with a difference of no more than approximately 100° F in average temperature. Data from the thermocouples on the boiler tubes during startup indicated a peak temperature difference of 45° F between the tube temperature in the inner and outer banks, with the temperature of the liquid downcomer about halfway in between. Tube temperatures measured under steady boiling conditions indicated that all of the tubes in the bundle were maintained at a temperature within a few degrees of any other tube. Consequently, no thermal stress problems should be expected.

Combustion gas temperature measurements completed during the quarter indicated a fairly uniform flue gas distribution and good heat transfer to the

boiler tubes. The combustion air pressure drop measurements also completed during the quarter were higher than predicted for the air flow passing through the burner at a given power level. This was the result of a leak across the sliding seal between the burner and boiler shroud which allowed 40 percent of the air to bypass the burner and be discharged directly into the exhaust gas stream.

#### **Potassium System Design and Fabrication**

The mechanical design work for the potassium system components was nearly completed this quarter. The condenser modification drawings were completed, as was the design work on the potassium vapor and liquid return piping. The sample box assembly and sample box potassium piping drawings were finished and released.

Fabrication of modifications and new components for the potassium system proceeded very well during the quarter, with work on piping and welding fabrication on the condenser nearly completed. Fabrication of parts for the condenser enclosure was more than 50 percent completed. Fabrication of the cylindrical portion of the drain tank was completed and welding of the dished heads to cylinder begun. Work was initiated on the potassium sampler and enclosure.



## XV. INDUSTRIAL APPLICATION OF FLUIDIZED-BED COMBUSTION PROCESSES

### INDUSTRIAL SUPERHEATED STEAM BOILERS

#### COMBUSTION ENGINEERING INC.

Sub-scale Unit Site: Windsor, Connecticut  
Demonstration Unit Site: Great Lakes, Illinois  
Contract No.: No. E(49-18)-2473  
Total Funding: \$7,679,340  
ERDA: \$5,868,400  
Industry: \$1,810,940  
Projected Start-up: February 1980

### INDUSTRIAL BOILERS

#### GEORGETOWN UNIVERSITY WASHINGTON, D.C.

Project Site: Washington, D.C.  
Contract No.: No. E(49-18)-2461  
Total Funding: \$14,181,312  
ERDA: \$9,569,350  
Industry: \$4,611,962  
Projected Start-up: April 1979

#### BATTELLE MEMORIAL INSTITUTE, COLUMBUS LABORATORIES COLUMBUS, OHIO

Project Site: Columbus, Ohio  
Contract No.: No. E(49-18)-2472  
Total Funding: \$5,256,355  
ERDA: \$3,397,131

Projected Start-up: *Industry: \$1,859,224*  
October 1979

### INDIRECT FIRED HEATERS

#### EXXON RESEARCH AND ENGINEERING COMPANY FLORHAM PARK, NEW JERSEY

Sub-scale Unit Site: Florham Park,  
New Jersey  
Contract No.: No. E(49-18)-2471  
Total Funding: \$4,008,375  
ERDA: \$3,274,757  
Industry: \$ 733,618  
Projected Start-up: June 1979

### FLUIDYNE ENGINEERING CORPORATION

Sub-scale Unit Site: Minneapolis, Minnesota  
Demonstration Unit Site: Owatonna, Minnesota  
Contract No.: No. E(49-18)-2463  
Total Funding: \$4,415,612  
ERDA: \$2,878,385  
Industry: \$1,537,227  
Projected Start-up: October 1979

### SUPPORT STUDIES

ARTHUR G. MCKEE AND COMPANY  
Contract No.: EX-76-C-01-2418  
Total Funding: \$483,400

## INTRODUCTION

During the past decade, the federal government has evaluated direct combustion of coal by the fluidized-bed combustion process. As a result of these evaluations, it has been determined that the fluidized-bed combustion process can efficiently convert coal to usable power in an environmentally acceptable manner. In order to develop the fluidized-bed combustion concept for demonstration in the industrial sector, ERDA issued Program Opportunity Notice (PON) FE-1, a part of the National Energy Research, Development, and Demonstration Program. Four categories of application were identified and defined:

Category I—An industrial steam generator capable of producing steam of the quality and quantity for back pressure turbines, industrial processes, and heating requirements.

Category II—An industrial boiler with the capability of producing steam of the quality and quantity suitable for process heating and space heating requirements of industrial or institutional facilities.

Category III—An indirect-fired heater, utilizing tubes or other heat exchange devices, designed to heat process liquids or gases.

Category IV—A direct-fired heater capable of heating process materials by direct contact between the combustion gases and the process materials.

In each of the PON contracts, the program objectives as stated in the PON are:

- Identify and conduct evaluations of industrial boiler or process heater requirements to determine the applications in which fluidized-bed combustion is technically, economically, and environmentally feasible.
- Design, construct, operate, test, and demonstrate prototype boilers or heaters to burn coal and other fuels in an environmentally acceptable manner.
- Obtain sufficient data from prototype operations to design and construct a commercial-size unit.

## PROGRAM DESCRIPTION

### General

In the fluidized-bed combustion process, crushed coal is burned in a bed of granular particles which are

maintained in suspension by an upward flow of air. Heat energy from the bed is transferred to another fluid through tubes immersed in the bed of hot granules. The overall heat transfer obtained in this manner is greater than in conventional combustion processes. If limestone is used as the granular bed material, the sulfur liberated from the coal combines with the available calcium and forms calcium sulfate, thus eliminating flue gas desulfurization requirements.

### Industrial Superheated Steam Boilers

Nearly half of the fuel used by industry is consumed in the firing of boilers for process steam, space heating, and on-site power generation. Nearly an equal amount is consumed in the generation of electricity by utilities. Coal was once the dominant fuel used for industrial boilers, but presently accounts for only about one-quarter of boiler fuel demand. Under contract No. E(49-13)-2473, Combustion Engineering, Inc. will design, construct, operate, test, and demonstrate a fluidized-bed boiler incorporating natural combustion.

### Industrial Boilers

Supplementing the general objectives of the PON, Georgetown University will design, construct, and operate an atmospheric fluidized-bed boiler using high-sulfur coal designed to function as a source of steam for Georgetown University. Also supplementing the general objectives of the PON, under Contract No. (49-13)-2472, Battelle will determine the feasibility of using fluidized-bed combustion techniques to decrease oil and gas consumption. In addition to the general objectives as expressed in the PON, the specific objectives of this contract are to:

- Extend the state-of-the-art of fluidized-bed coal combustion to higher heat release rates and air velocities by use of the multi-solids fluidized-bed concept.
- Design, construct, operate, test, and demonstrate a prototype high-velocity fluidized-bed steam generator which will burn high-sulfur coal in an environmentally-acceptable manner. The steam generator will be operated as a lead steam generator in an industrial steam plant.

### Indirect-Fired Heaters

Between four and eight percent of the crude oil processed in oil refineries is consumed to maintain the

refinery operations. Under contract No. E(49-13)-'471, Exxon Research and Engineering Company will determine the feasibility of using coal combustion processes to satisfy this energy requirement, resulting in a decrease in oil consumption. In addition to the general objectives as expressed in the PON, the specific objectives of this contract are to:

- Extend the state-of-the-art of fluidized-bed coal combustion to applications wherein oil passing through tubes immersed in the bed will absorb heat energy for subsequent refining and processing.
- Design, build, operate, test, and demonstrate a fluidized-bed indirect-fired process heater operating as an integral part of a petroleum refinery.

Supplementing the general objectives of the PON, the specific objective of FluiDyne Engineering Corporation's contract is to demonstrate that an atmospheric-pressure fluidized-bed air heater and distribution system using high sulfur coal and secondary fuels may be applied economically and efficiently to serve both the space heating and process needs of metal manufacturing plants.

The demonstration facility will be located at the Owatonna Tool Company in Owatonna, Minnesota, and will be designed to efficiently handle the various lead fluctuations that occur at the facility. The plant provides a unique opportunity to demonstrate and study the operation and interfacing of a fluidized-bed combustor (FBC) into existing systems and equipment in a variety of typical manufacturing operations.

#### **Support Studies**

Arthur G. McKee and Company was awarded a contract which is not part of the PON contracts, but is directly related to them. McKee will provide general and technical assistance to ERDA in the areas of scheduling, specification evaluation, and program review.

### **PROGRESS DURING OCTOBER-DECEMBER 1976**

#### **Industrial Superheated Steam Boilers**

*Combustion Engineering, Inc.*

Activity during the quarter was concentrated in three

major areas: cold flow test program, sub-scale unit design, and demonstration plant design.

ERDA approved the cold flow model test program and tests were begun on the two-dimensional model. Construction of the three-dimensional model also began.

The preparation of a test program for the sub-scale unit was initiated. Sub-scale design activities during the period included completion of the system mass and energy balances at various load conditions and final design of the sub-scale unit pressure parts including boiler bed tubes, economizer, and superheater sections. Engineering information forwarded to ERDA included:

- Process block diagram
- Fluidized-bed boiler design criteria
- Preliminary material and flow schematics
- List of sub-system unit major equipment
- Major equipment specifications for the forced draft and induced draft fans, cyclone, and bag filter
- Process flow diagram for coal and limestone handling system

The preliminary design of the demonstration plant was also initiated during the quarter. Preparation of the process flow diagram also began.

#### **Industrial Boilers**

#### *Georgetown University*

Work under this contract is being accomplished through a teaming arrangement with Georgetown University as the prime contractor and the Fluidized Combustion Company (FCC) as a subcontractor. FCC is a joint venture of wholly-owned subsidiaries of Pope, Evans, and Robbins, Inc. and Foster Wheeler Corporation.

A program plan was developed and accepted by ERDA at the beginning of the quarter. Thirty percent design documents were also completed and submitted for ERDA approval. Joint design review conferences were held at the 30 percent and 50 percent stage of completion. A new concept for the boiler was introduced at the 50 percent conference and approved by ERDA.

The development of the new concept was the result of evaluations intended to optimize the steam generator design. All natural circulation boiler circuitry was

incorporated in the new design instead of the forced circulation circuitry of the original design.

Performance engineering continued on the original design until November. At that time, ERDA approved the new concept and the preliminary engineering was initiated.

#### *Battelle Memorial Institute, Columbus Laboratories*

The 30 percent design of the sub-scale unit and related facilities was completed and reviewed by ERDA during the quarter. The detailed design of the combustor/boiler was completed. A bid package prepared, bids solicited, and a fabrication contract issued.

A boiler capacity of 150,000 pounds per hour of saturated steam at 250 psig was selected for the conceptual boiler design. A preliminary process flow diagram was developed and reviewed in-house.

#### **Indirect-Fired Heaters**

##### *Exxon Research and Engineering Company*

Two principal areas of technology which have been identified as being peculiar to process heater application and which are not being addressed in any ongoing boiler program concern the effects of tube size and hydrocarbon coking.

Indirect-fired process heater tubes are conventionally two to five times larger than boiler tubes. A typical crude oil heater may have a multitude of four- to eight-inch diameter tubes in the heat pick-up zones as contrasted to the one- to two-inch diameter tubes normally used in steam boilers.

Phase I of the program will consist of three laboratory experiments designed to generate data on the following:

- Effect of tube size and arrangement on bed fluidization.
- Relationships between heat flux and tube coking rate.
- Tube peripheral flux maldistribution in a fluidized bed.

Based on these data, a technical and economic evaluation of the commercial potential for this technology will be made.

Program effort during the quarter was assigned to

the planning and design of the first two laboratory units that are to be a part of the Phase I program. The first unit, a two-dimensional flow visualization unit consists of an atmospheric pressure, transparent test chamber wherein the fluidization and mixing characteristics of a fluidized-bed containing immersed tubes can be observed and quantitatively measured. The unit design was completed and construction initiated.

The second laboratory unit, the process steam coking unit, consists of four single-tube heat exchangers, an electric heat source, and a gas-fired crude preheater. The process design for the unit was completed and approved. The objective of studies conducted on the unit will be to determine what effect the high flux levels available in a fluidized-bed combustor will have on the coking rate of a hydrocarbon process stream and to determine if these coking rates can be controlled within an acceptable range of operations. Comparative rates of coking at different flux levels, fluid mass velocities, and bulk temperatures will be determined.

##### *FluiDyne Engineering Corporation*

Primary effort during the quarter concentrated on the technology support and preliminary design of the demonstration unit.

Fluidized-bed combustion performance and equipment operation tests with Iowa coal, designated as the primary fuel for the demonstration program, were completed. These tests were followed by additional performance tests with the petroleum coke and Tennessee coal, both secondary fuels.

Vertical slice test unit design and fabrication activities also continued during the reporting period. As a result of equipment delivery delays and unseasonably cold weather, however, these activities fell slightly behind schedule. The vertical slice 80 percent design package, as well as the work plan diagram for environmental assessment, and the 18-inch test plan for secondary fuels were submitted to ERDA for approval.

Preliminary design activities during this quarter were directed toward definition of the Owatonna Tool Company (OTC) plant heating load, definition of the availability and cost of different types of fuel and sorbent, definition of the type of storage and handling system required for fuel and sorbent, evaluation of reserve fuel requirements, and preparation of a preliminary site arrangement.

## XVI. MODELING OF FLUIDIZED-BED COMBUSTION PROCESSES

MASSACHUSETTS INSTITUTE OF TECHNOLOGY

Contract No.: No. E(49-18)-2295

Total Funding: \$945,000

### INTRODUCTION

The modeling of the fluidized-bed combustion of coal is planned by the Massachusetts Institute of Technology (MIT) under this program sponsored by ERDA. The specific objective of the contract is to develop a phenomenologically-based system model for the coal-fired fluidized-bed combustion process.

### PROGRAM DESCRIPTION

The 21-month program began in May 1976. Three main tasks are included in this program:

#### Task I—Data Base Establishment

A data base will be established containing all information available on fluidized-bed combustion, with emphasis directed to the use of coal as the primary fuel. All information acquired will be stored using an established, comprehensive, well-documented data storage and retrieval system.

#### Task II—Modeling

Using the data base established in Task I, a comprehensive model of the coal-fired fluidized-bed combustion process will be designed and implemented. The model will consist of five sub-models: combus-

tion, fluid dynamics, heat transfer, desulfurization, and materials.

Deficiencies of data will be documented for Task III action. Reasonable estimates will be made for information not available.

#### Task III—Documentation

Three final documents will be prepared:

- The model document will describe the status, capabilities, and deficiencies of the model developed for the coal-fired fluidized-bed combustion process.
- The planning document will provide detailed data deficiencies, the most likely sources of that data, and the rationale for the course of action and the necessary timing.
- A manual of instructions will be prepared for prospective users of the data base and computer model.

### PROGRESS DURING OCTOBER-DECEMBER 1976

The system model was constructed by integrating five sub-models. The concepts which described the phenomena within the scope of the sub-model were established. Prior-art models which would correlate the pertinent data in a meaningful manner were also identified.

A structural diagram was developed for a generalized fluidized-bed combustor (FBC) model.

Final testing of the system model using fast bubble

mechanics coupled to single-size coal particle feed was completed during the quarter. The final testing of the same model coupled to the multi-size coal particle feed was near completion.

## **XVII. FLUIDIZED-BED WASTE MATERIAL UTILIZATION: SOIL MODIFICATION**

**VIRGINIA POLYTECHNIC INSTITUTE AND  
STATE UNIVERSITY**

**Total Funding: \$1,500**

**TENNESSEE VALLEY AUTHORITY**

**Contract No.: E(49-18)-2411**

**Total Funding: \$29,000**

**UNITED STATES DEPARTMENT OF AGRICULTURE**

**Contract No.: E(49-18)-2488**

**Total Funding: \$1,766,548**

**UNITED STATES DEPARTMENT OF  
TRANSPORTATION**

**Contract No.: E(49-18)-2491**

**Total Funding: \$42,750**

**DR. L. JOHN MINNICK**

**Contract No.: EF-77-C-01-2549**

**Total Funding: \$259,530**

### **INTRODUCTION**

When coal, containing three percent sulfur and 12 percent ash, is burned in fluidized-bed boilers along with a quantity of limestone sufficient to maintain a molar ratio between 2:1 and 3:1 of calcium to sulfur, between 400 and 600 pounds of waste bed material is generated for each ton of coal burned. About 50 percent of this waste material is drawn from the

fluidized-bed, the rest being discharged as fly ash. The material drawn from the bed usually consists of 25 to 35 percent unhydrated lime, 50 to 60 percent calcium sulfate, and varying amounts of silica, aluminum, iron, and magnesium oxides. ERDA has funded various studies to demonstrate the effectiveness of using this fluidized-bed combustion (FBC) waste for agricultural purposes, as a liming material, and as a soil stabilizer.

## PROGRAM DESCRIPTION

Virginia Polytechnic Institute and State University will continue studies which began two years ago using the atmospheric FBC waste bed material as a nutrient source of calcium for crops.

The Tennessee Valley Authority will demonstrate the use of FBC waste bed material in agriculture and as a liming source in a program consisting of four tasks:

- Field experiments studying the utilization of FBC waste material as a nutrient source of calcium and sulfur for crops.
- Pot experiments evaluating FBC waste as a source of sulfur and micronutrients, and as a liming material.
- Field experiments determining the maximum non-toxic loading rates for soils having various textures and for selected crops.
- Field experiments determining the amount of waste material required to neutralize acid mine spoils and the subsequent effect on plant growth.

The Agriculture Research Service, United States Department of Agriculture, will evaluate the solid wastes from FBC processes for potential use in agriculture by detailed chemical and physical analysis of the material, followed by extensive greenhouse, growth chamber, and field studies.

The Federal Highway Administration, United States Department of Transportation, will assess the utilization of FBC waste bed material for remedial treatment of soils. The objective of this study is to determine whether FBC waste bed material can be used for soil stabilization. The program consists of four tasks:

- Physical, chemical, and mineralogical properties of FBC bed waste material will be determined.
- Twenty soil samples will be selected from areas where FBC installations will likely be located.
- Various mixtures of the soils and the waste material will be tested to evaluate the effectiveness of

this waste material relative to conventional stabilization additives.

- Tests will be performed as in the previous tasks, but various additives such as fly ash, lime, and waste cement kiln dust will also be tested.

## PROGRESS DURING OCTOBER-DECEMBER 1976

### Virginia Polytechnic Institute and State University

An especially high rate of fluidized-bed combustion (FBC) material, 2,400 pounds per acre, was applied to farm acreage in tests completed during the quarter. The FBC material appeared to be equivalent to anhydrite; however, only a limited number of production situations were researched.

No phytotoxicity was detected from application of the FBC material, however, possible toxicity problems with repeated usage should be researched more extensively.

### Tennessee Valley Authority

A field experiment was initiated during the quarter to compare 10, 20, and 40 metric tons per hectare rates of fluidized-bed waste (FBW) with 5, 10, and 20 tons of ground limestone, and 10, 20, 40, 160, and 320 tons of limestone scrubber sludge for alfalfa. A pot experiment was also initiated in August to measure liming effects of FBW on acid strip mine spoil and is currently in progress.

### Agriculture Research Service

Studies of the chemical analysis of spent solid waste material continued. Leaching studies were initiated to determine the rate of elemental release under controlled environmental conditions.

## **XVIII. COMBINED-CYCLE ELECTRIC POWER GENERATION USING PRESSURIZED FLUIDIZED-BED COMBUSTION**

**CURTISS-WRIGHT CORPORATION**

**WOOD-RIDGE, NEW JERSEY**

**Plant Site:** **Wood-Ridge, New Jersey**

**Contract No.:** **E(49-18)-1726**

**Total Funding:** **\$27,500,000**

### **INTRODUCTION**

Curtiss-Wright Corporation, under the sponsorship of ERDA, is conducting a program to design, construct, operate, and evaluate a coal-fired combined-cycle pilot plant for electric utility power plant applications using pressurized fluidized-bed (PFB) technology and high-sulfur coals. The program was initiated on March 1, 1976. The pilot plant program is a five-year, four-phase effort. Phase I is a 14-month program to provide:

- Conceptual design of a commercial coal-fired 300-500 Mw combined-cycle generating station using the PFB combustion technique.
- Pilot plant design which is representative of the commercial concept.
- Pilot plant site and environmental assessment study.
- Technology support programs which provide data on the performance of the selected PFB design.

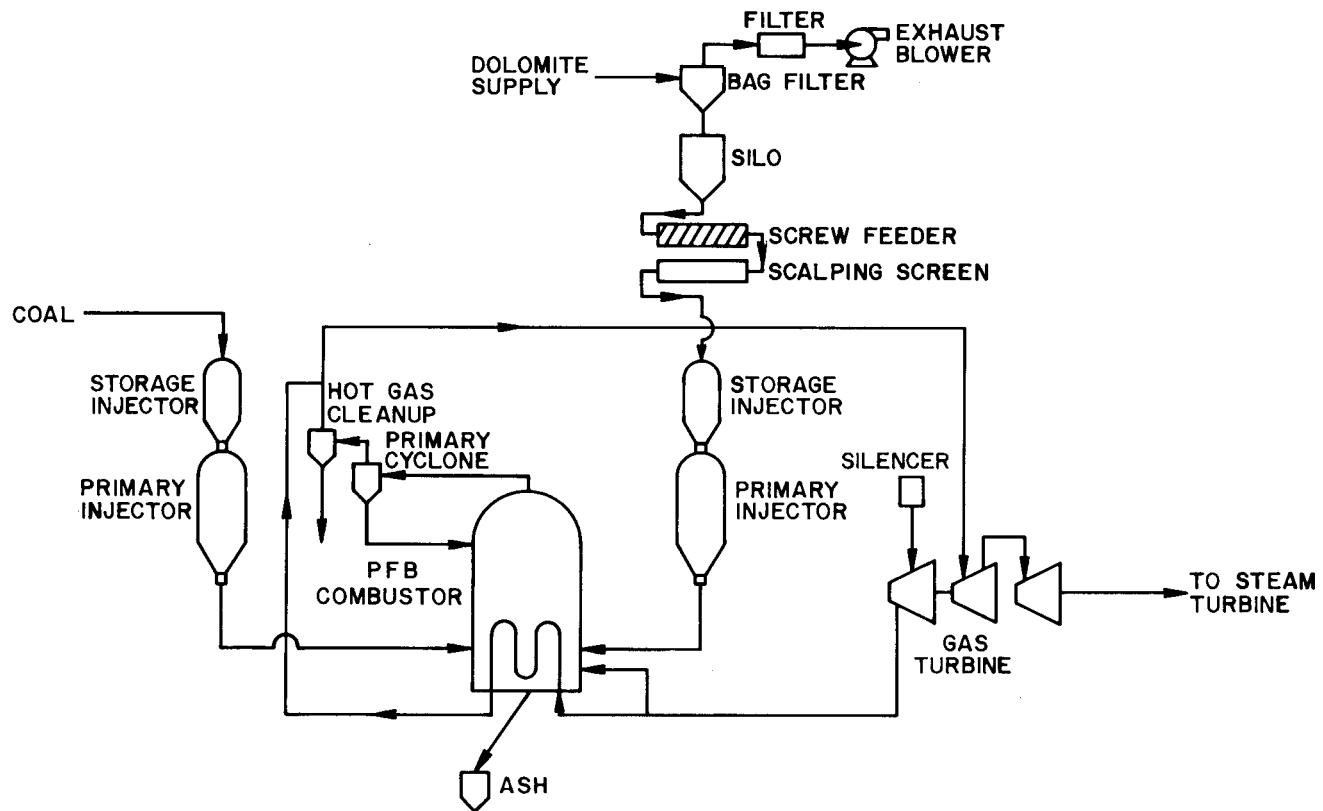
Phase II is an eight-month effort to complete the detail design drawings and specifications of the pilot plant, prepare a construction bid package, and obtain bids for evaluation. Phase III is a 20-month construction period for the manufacturing, build-up, and installation of the pilot plant. The final phase is a 24-month effort to operate the pilot plant and to evaluate operating parameters and durability using

several coal types. At the conclusion of this phase, a reassessment of the commercial plant conceptual design will be conducted.

### **PROCESS DESCRIPTION**

The pilot plant will be designed and constructed by converting an existing power generating station located at Curtiss-Wright's Wood-Ridge, New Jersey facility. This station consists of a gas turbine-driven alternator and a waste heat recovery boiler. The station currently provides the facility's requirement for electric power and steam for processing and heating. The gas turbine's liquid or gas fuel combustor will be replaced with a pressurized fluidized-bed combustor capable of operating on crushed coal feed.

A flow diagram of the projected pilot plant is shown in Figure XVIII-1. The PFB process involves the combustion of coal in the presence of a sulfur sorbent material, such as limestone or dolomite, at a temperature below 1750° F. Bed temperature is controlled by extracting heat from the bed with a tubular heat exchanger using air as the coolant in the tubes. Approximately one-third of the air flow from the compressor is used for combustion and the remainder is used as the bed coolant. The coolant air is heated nearly to bed temperature and is mixed with the combustion gas



**Figure XVIII-1. SCHEMATIC OF CURTISS-WRIGHT PRESSURIZED FLUIDIZED-BED COMBUSTION/ COMBINED-CYCLE PILOT POWER PLANT**

from the bed prior to entering the turbine. The large quantity of air flow which bypasses the direct combustion process improves turbine durability by minimizing the corrosive and erosive effects of particulates and alkali salts in the combustion gas stream.

The bed and heat exchanger are supported by a distributor plate which is used for injecting the fluidizing air from the compressor. Coal and sorbent material are separately metered by a pressurized lock-hopper injection system and are fed into the combustor bed zone. The bed level is maintained by periodically removing spent material from the bottom of the bed. This ash is fed into a solids cooler and lock-hopper system for eventual disposal.

Ash entrained in the combustion gas leaving the bed is removed in the primary and secondary cyclones. The ash from the primary unit is recycled to the PFB and that from the secondary unit is directed to the solids cooler for disposal.

turbine on a liquid or gaseous fuel fed to an auxiliary combustor. Another auxiliary combustor is operated to heat the PFB. When the bed temperature is sufficiently high, coal is injected into the PFB and ignition and combustion occurs. The auxiliary combustors are gradually shut off as the coal flow is increased to full operating conditions.

A power turbine, not mechanically coupled to the gas turbine, drives a 50 or 60 Hz alternator and produces approximately two-thirds of the combined-cycle total power. The gas leaving the power turbine enters a waste heat recovery boiler in which steam is generated to drive a steam turbine/alternator set. The total power generated by the combined-cycle system is produced at a thermal efficiency significantly higher than either the gas turbine cycle or the steam turbine cycle can provide separately.

Because of the relatively low combustion outlet temperatures, emissions of oxides of nitrogen can be controlled to a level below the current emission standard of 0.7 pounds of  $\text{NO}_2$  per million Btu. In addition,

the use of the sulfur sorbent material in the bed allows emissions of sulfur oxides to be below the current standards of 1.2 pounds of SO<sub>2</sub> per million Btu.

## HISTORY OF THE PROJECT

Fluidized-bed technology was first used commercially in the fields of mining and metallurgy in the 1940's, and more recently in chemical processing, heat-treating, and combustion systems. During the 1960's, work was initiated in both Britain and the United States on the development of fluidized-bed coal combustion systems for the generation of electric power. The systems under development are:

- Atmospheric—in which the combustion takes place at or near atmospheric pressure.
- Pressurized—in which combustion occurs at pressures up to ten atmospheres.

First generation fluidized-bed combustors have been used primarily as steam boilers. The steam produced is used to drive a conventional steam turbine coupled to an electric generator. More advanced power systems, which offer higher thermal efficiency in converting heat energy to electrical power, are currently under investigation. The most technically developed of these advanced systems is the combined gas turbine-steam turbine cycle. Combined-cycle systems are currently in use by utilities, burning petroleum fuels, to provide intermediate and peaking electrical load service.

Recognizing that the combination of pressurized fluidized-bed technology and the gas turbine-steam turbine combined-cycle power system offers the opportunity for the production of clean, cost-competitive electric power from the combustion of high-sulfur coal, ERDA contracted with the Curtiss-Wright Corporation to design, construct, and operate a pilot electric power plant. Phase I of the program, initiated on March 1, 1976, includes the following tasks:

- Task 1—Preliminary Engineering
- Task 2—Pilot Plant Preliminary Design
- Task 3—Site Evaluation
- Task 4—Pilot Plant Environmental Analysis
- Task 5—Technology Rigs
- Task 6—Management
- Task 7—Reliability and Quality Assurance
- Task 8—Documentation and Reporting

## PROGRESS DURING OCTOBER-DECEMBER 1976

The conceptual design of the commercial electric power generation plant using the pressurized fluidized-bed (PFB) combustion process continued during the quarter for the 300-500 Mw central station. The complete station includes three 100 Mw gas turbine double-end modules and one steam turbine (470 Mw total).

Major component and equipment design is nearing completion. Continued design evaluation of the PFB combustor and heat exchanger concepts identified preferred and alternate design configurations. The interconnecting gas piping for gas turbine/PFB combustor/cleanup system components was defined. The plant arrangement of all equipment is nearing completion. Instrumentation and control features were defined and all flow diagrams were prepared. The cost analysis of the commercial plant is continuing.

PFB pilot plant conceptual design and performance analysis continued during the reporting period. Conceptual design of the pilot plant PFB combustor and first stage gas cleanup system was initiated. The recommendations report for the PFB pilot plant, based on the performance analysis and conceptual designs, is being prepared. Pilot plant site evaluation was completed and a draft report was submitted to ERDA for approval. The pilot plant environmental assessment was initiated.

Technology support evaluation is continuing in several major areas. Tube fabrication development for the PFB heat exchanger finned tubes has proceeded along two paths. Brazed assemblies of finned tube segments have been produced and work is progressing toward brazing trials on full length tube assemblies. Casting trials of integral fin and tube segments have been initiated and will be directed toward producing three-foot-long tube sections which can be welded together to provide the full-length tube assemblies. The instrumentation drawing for the heat exchanger test module was completed and fabrication continued. Heat exchanger tube specimens, including bare tubes plus three finned tube geometries were tested in the Dorr-Oliver 12-inch atmospheric pressure fluidized-bed combustor, accumulating over 300 hours of test time. Tests are also continuing at reduced fin heights.

Design and instrumentation definition for the small gas turbine/PFB operating parameters rig is essentially complete. Manufacturing of the PFB combustor and

the coal and dolomite handling systems continued. Site preparation has begun and required existing materials

handling equipment and storage facilities have been serviced and reactivated.

# **XIX. EVALUATION OF A PRESSURIZED FLUIDIZED-BED COMBUSTION (PFBC) COMBINED CYCLE POWER PLANT CONCEPTUAL DESIGN**

**BURNS AND ROE INDUSTRIAL SERVICE**

**PARAMUS, NEW JERSEY**

**Contract No.: E(29-18)-2371**

**Total Funding: \$1,385,052  
(100% ERDA)**

## **INTRODUCTION**

Under the terms of this contract, Burns and Roe Industrial Service will provide an evaluation of a coal-fired combined-cycle power plant conceptual design. The design will use a pressurized fluidized-bed (PFB) combustor air heater cycle with a unique supplemental fuel-fired atmospheric fluidized-bed (AFB) heat recovery boiler for obtaining high efficiency. Improvement in the cycle will be achieved by reheating the gas turbine effluent in the PFB or by additional heating of the gas turbine effluent in the AFB.

## **PROGRAM DESCRIPTION**

The contractor will perform administrative services in the following areas:

- Commercial plant design definition
- Commercial plant requirements definition
- Design trade-off studies
- Reliability and maintainability evaluation
- Environmental analysis
- Economic analysis
- Alternate plant approaches evaluation and comparisons

Four viable system configurations utilizing gas turbines, a waste heat steam bottoming system, and pressurized fluidized-bed combustion will be studied to determine which system exhibits the highest overall efficiency. The four systems to be studied are:

- Case 1—Basic combined cycle (no reheat or exhaust firing).
- Case 2—Exhaust-fired combined cycle.
- Case 3—Reheat at power turbine inlet.
- Case 4—Reheat at low-turbine inlet plus exhaust firing.

## **PROGRESS DURING OCTOBER-DECEMBER 1976**

### **Summary**

Performance data on the four basic configurations of pressurized fluidized-bed (PFB) power plant arrangements were compiled into a set of tables entitled "PFB Combined Cycle Comparison." Preliminary cost data of major equipment for the different schemes were also compiled during the quarter. Preliminary design for a PFB with a pressure ratio of ten and a 2.5-atm reheat PFB were completed.

### **Commercial Plant Requirement Studies**

A set of tables entitled "PFB Combined Cycle Comparisons" was prepared to provide control of the commercial plant duty cycle and design evaluations. The tables will be extended and revised as necessary.

In order to select performance data for the comparison, a series of performance estimates were made for the four basic configurations of PFB plants. The results indicated that the four configurations fall into relatively distinct efficiency ranges. Case 1, the straight waste-heat recovery combined cycle was in the 37.38 percent range. Case 2, the direct fired combined cycle was in the 40-41 percent range. Case 3, the power-turbine reheat combined cycle displayed the highest overall efficiency of 43.1 percent. Case 4, the compressor turbine reheat combined cycle was in the 42 percent range.

As the 38 percent efficiency of the simpler waste-heat recovery system was significantly lower than the other systems, the capital cost of the system would have to be considerably lower to offset the efficiency difference.

Preliminary cost data of major equipment for the different schemes was also compiled during the quarter.

### **Commercial Plant Design Studies**

A preliminary stress analysis review of PFB vessels was begun to determine the feasibility of field-erected units with diameters in the 20 to 25-foot range, using the present concept of surface arrangement and support. A preliminary design for a PFB Combustor for a pressure ratio of ten was completed. Preliminary arrangements of a 2.5-atmosphere reheat PFB with horizontal tubes and a steam-cooled atmospheric pressure fluidized-bed were completed. Information was also obtained on materials handling systems, and particulate removal systems.

### **Design Trade-off Studies**

Cyclic calculations were completed to assess the sensitivity of cycle performance to such parameters as pressure ratio steam cycle configuration, gas turbine leakage/cooling flows, condenser pressure, combustion pressure drop, and steam cycle pressure drops.

## XX. COAL-FIRED COMBINED-CYCLE DEVELOPMENT PROGRAM

GENERAL ELECTRIC ENERGY SYSTEMS—  
TECHNOLOGY DIVISION

SCHENECTADY, NEW YORK

Contract No.: E(49-18)-2357

Total Funding: \$4,382,396  
(100% ERDA)

### INTRODUCTION

A Coal-Fired Combined-Cycle (CFCC) power plant conceptual design is being developed under this contract with General Electric Company. The combined steam and gas power cycle utilizes a pressurized fluidized-bed (PFB) combustor burning coal.

The Energy Systems Program Department (ESPD) of General Electric leads the program, performing the required program management, system engineering, reliability, and environmental effort. Foster-Wheeler, under subcontract to GE, is responsible for the combustor/steam generator design activity and technology support. Exxon is supplying experimental support, using their miniplant facility and integrating the testing with ongoing Environmental Protection Agency-sponsored work. Within General Electric, ESPD will be supported by Corporate Research and Development for hot-gas cleanup technology, by the Gas Turbine Division for gas turbine design/technology, and by the Projects Engineering Operation of the Installation and Service Engineering Business Division for commercial power plant balance-of-plant design and costing.

### PROGRAM DESCRIPTION

The CFCC approach provides cooling of the fluid-

ized-bed combustor through the use of steam tubes in the bed, which supply a steam turbine-generator. The partially cooled combustion gases exiting from the combustor drive a gas turbine generator after passing through a hot-gas cleanup train.

The objective of this program is to evaluate the CFCC design and to conduct a supporting development program. The program is necessary to evaluate the pressurized fluidized-bed combustor concept, for developing engineering correlations to be used in optimizing the commercial plant concept, and for evaluating the combustor/steam generator, the hot-gas cleanup, and advanced gas turbine materials for this application. The results of this program will provide for PFBC technology advancement and also provide a backup concept and program for commercialization of pressurized fluidized-bed combustion.

The work is organized into six major tasks:

- Commercial plant evaluation
- Combustor/steam generator development
- Gas turbine technology
- Hot gas cleanup technology
- Experimental support
- Project management

Several component and system design options over a range of system parameters will be studied at a conceptual level for the purpose of tradeoff evaluation. After a formal commercial plant design review, a single

system and component design approach will be defined in detail, and a design evaluation report prepared.

The supporting technology tasks will be conducted in parallel with the commercial plant definition activity. Certain key technology uncertainties have been previously identified and will be studied. These include combustor effluent characterization, cyclone and granular bed filter performance, combustor hot-gas ducting evaluation, gas turbine materials and bucket cladding development for increased corrosion resistance, advanced particulate cleanup equipment development, and combustion chemistry modifications.

Performance data will be acquired from Curtiss-Wright for commercially available cyclone separator equipment, from Exxon for currently available granular bed filter performance, from the Fireside Corrosion Task 2 Program for turbine materials performance, and from Combustion Systems Limited for tube bundle performance. Integration of the technology work with the commercial plant evaluation activity will be achieved by guiding the testing plans on the basis of the system requirements as established, and by determining test parameter ranges by the system tradeoff studies. The system tradeoff studies will also be employed to establish recommended extensions/modifications for related government technology programs in support of CFCC needs.

## **HISTORY OF THE PROJECT**

Beginning in January 1974, a study team represent-

ing General Electric, Foster-Wheeler Energy Corporation, Exxon Research and Engineering Company, and Combustion Systems Limited evaluated the CFCC approach. On the basis of these studies, it appeared that the CFCC approach offered the following advantages over alternative approaches:

- Higher power plant efficiency in the range of interest
- Reduced corrosion potential, due to low fluidized-bed tube temperature (air in tube cycle)
- Reduced hot-gas cleanup flow rate (uncooled combustor cycle)

## **PROGRESS DURING OCTOBER-DECEMBER 1976**

The Commercial Plant Design Requirements Report was submitted to ERDA during the quarter. Several analysis and trade-off studies were initiated to identify value of parameters listed in the requirements report. Design studies for multiple approaches to the combustor/steam generator were also started in order to identify and reconcile their impact on the system design. The studies included preliminary assessments of the impact of system reliability and system control modes on the design of all subsystems.

General Electric completed the preliminary efflux characterization model after receiving data from Exxon Research and Engineering (ER&E). During the first month of effort on the pressurized fluidized-bed mini-plant, ER&E also contributed data.

## GLOSSARY

**absorption**—an imprecise term suggesting the taking up of one substance by another by either a physical process or a chemical combination.

**acceptor**—calcined carbonate that absorbs carbon dioxide evolved during gasification, liberating heat.

**acid gas removal**—the process of selectively removing hydrogen sulfide and carbon dioxide from a gas stream.

**activated carbon**—carbon obtained by carbonization in the absence of air, preferably in a vacuum; has the property of absorbing large quantities of gases, solvent vapors; used also for clarifying liquids.

**adiabatic**—any process where heat is neither given off nor absorbed.

**adsorption**—the process by which the surface of a solid or liquid attracts and holds any atom, molecule, or ion from a solution or gas with which it is in contact.

**agglomerate**—assemblage of ash particles rigidly joined together, as by partial fusion (sintering).

**anthracite coal**—hard coal containing 86 to 98 percent fixed carbon and small percentages of volatile material and ash.

**API**—American Petroleum Institute.

**API gravity**—a scale adopted by the API for measuring the

141.5

density of oils;  ${}^{\circ}\text{API} = \frac{141.5}{\text{Specific gravity, } 60^{\circ}\text{F}/60^{\circ}\text{F}} - 131.5$

**aromatic hydrocarbon**—a cyclic hydrocarbon containing one or more six-carbon (benzene) rings.

**ash**—solid residue remaining after the combustion of coal.

**ASTM**—American Society for Testing Materials.

**autoclave**—a vessel, constructed of thick-walled steel, for carrying out chemical reactions under high pressures and temperatures.

**bench-scale unit**—a small-scale laboratory unit for testing process concepts and operating parameters as a first step in the evaluation of a process.

**binder**—carbon products, tars, etc., used to impart cohesion to the body to be formed; a coal-extract binder may be used to prepare formed-coke pellets from non-coking coals.

**bituminous coal**—a broad class of coals containing 46 to 86 percent fixed carbon and 20 to 40 percent volatile matter.

**blow down**—periodic or continuous removal of water from a boiler to prevent accumulation of solids.

**bottoming cycle**—the lower temperature thermodynamic power cycle of a combined-cycle system.

**Btu**—British thermal unit, the quantity of energy required to raise the temperature of one pound of water one degree Fahrenheit.

**BTX**—benzene, toluene, xylene; aromatic hydrocarbons.

**caking**—the softening and agglomeration of coal as a result of the application of heat.

**cination**—the process of heating a solid to a high temperature to cause the decomposition of hydrates and carbonates.

**calorific value**—the quantity of heat obtained by the complete combustion of a unit mass of a fuel under prescribed conditions.

**carbon fiber**—fine filaments of carbon about eight microns in diameter which are used in composite materials, being bound with resins.

**carbonization**—destructive heating of carbonaceous substances with the production of a solid, porous residue, or coke, and the evolution of a number of volatile products. For coal, there are two principal classes of carbonization, high-temperature coking (about  $900^{\circ}\text{C}$ ) and low-temperature carbonization (about  $700^{\circ}\text{C}$ ).

**catalyst**—a substance that accelerates the rate of a chemical reaction without itself undergoing a permanent chemical change.

**centrifuge**—an apparatus rotating at high speed which utilizes the centrifugal force generated to separate materials of different densities, e.g., undissolved residue from coal solution in the SRC process.

**char**—the solid residue remaining after the removal of moisture and volatile matter from coal.

**Claus process**—industrial method of obtaining elemental sulfur through the partial oxidation of gaseous hydrogen sulfide in air followed by catalytic conversion to molten sulfur.

**coal**—a readily combustible rock containing more than 50 weight percent and more than 70 volume percent of carbonaceous material including inherent moisture, formed from compaction and induration of variously altered plant remains similar to those in peat.

**coalification**—metamorphosis of vegetable debris into coal.

**coke**—strong porous residue consisting of carbon and mineral ash formed when bituminous coal is heated in a limited air supply or in the absence of air. Coke may also be formed by thermal decomposition of petroleum residues.

**coke breeze**—the fine screenings of crushed coke usually passing a  $1\frac{1}{2}$ -inch or  $3\frac{1}{4}$ -inch screen opening.

**combined cycle**—two sequential thermodynamic power conversion systems operating at different temperatures.

**combustion gas**—gas formed by the combustion of coal, e.g., burning.

**combustor**—a vessel in which combustion takes place.

**coupon**—a polished metal strip used to measure the rate of corrosion of the metal in a specific gaseous or liquid environment.

**cracking**—the partial decomposition of high-molecular-weight organic compounds into lower-molecular-weight compounds, generally as a result of high temperatures.

**crude gas**—impure gas produced in a gasifier.

**culm**—the waste or slack from anthracite mines or preparation plants consisting of fine coal, coal dust, and dirt.

**cyclone separator**—essentially a settling chamber to separate solid particles from a gas, in which gravitational acceleration is replaced by centrifugal acceleration.

**degasification**—a process for removing naturally occurring methane from coal seams.

**delayed coking**—a process wherein coal is subjected to a long period of carbonization at moderate temperatures to form coke.

**deminerlization**—removal of mineral matter (ash) from coal by solvent extraction, usually under hydrogen atmosphere.

**depolymerization**—the change of a large molecule into simpler molecules usually accompanied by the substitution of hydrogen for oxygen in the molecular structure.

**destructive distillation**—the distillation of coal accompanied by its thermal decomposition.

**desulfurization**—the removal of sulfur from hydrocarbonaceous substances by chemical reactions.

**devolatilization**—the removal of a portion of the volatile matter from medium- and high-volatile coals.

**diatomaceous earth**—a yellow, white, or light-gray, siliceous porous deposit made up of opaline shells of diatoms; used as a filter aid, paint filler, adsorbent, abrasive, and thermal insulator. Also known as kieselguhr.

**diatomite**—See Diatomaceous Earth.

**dissolution**—the taking up of a substance by a liquid with the formation of a homogeneous solution.

**distillation**—a process of vaporizing a liquid and condensing the vapor by cooling; used for separating liquids into various fractions according to their boiling points or boiling ranges.

**dolomite**—a carbonate of calcium and magnesium having the chemical formula  $\text{CaMg}(\text{CO}_3)_2$ .

**Dowtherm**—trademark for a series of eutectic mixtures of diphenyl oxide and diphenyl used as high-temperature heat-transfer fluids.

**ebullated bed**—gas containing a relatively small proportion of suspended solids, bubbles through a higher density fluidized phase with the result that the system takes on the appearance of a boiling liquid.

**economizer**—heat exchanging mechanism for recovering heat from flue gases.

**effluent gas**—gas given off from a process vessel.

**elutriation**—the preferential removal of the small constituents of a mixture of solid particles by a stream of high-velocity gas.

**endothermic reaction**—a process in which heat is absorbed.

**enthalpy change**—the increase or decrease in heat content of a substance or system which accompanies its change from one state to another under constant pressure.

**entrained bed (flow)**—a bed in which solid particles are suspended in a moving fluid and are continuously carried over in the effluent stream.

**eutectic**—that combination of two or more components which produces the lowest melting temperature.

**exothermic reaction**—a process in which heat is liberated.

**extraction**—a method of separation in which a solid or solution is contacted with a liquid solvent (the two being essentially mutually insoluble) to transfer components into the solvent.

**extractive coking**—similar to delayed coking process, with the emphasis on high tar yields to produce liquids.

**filter aid**—finely divided solids used to increase efficiency of filtering.

**filter cake**—the moist residue remaining from the filtration of a slurry to produce a clean filtrate.

**filtrate**—a liquid free of solid matter after having passed through a filter.

**filtration**—the separation of solids from liquids by passing the

mixture through a suitable medium, e.g., cloth, paper, diatomaceous earth.

**Fischer assay**—method for determining the tar and light yields from coal or oil shale; conducted in a retort under an inert atmosphere with a prescribed increase in temperature to 500° C.

**Fischer-Tropsch catalyst**—catalysts developed for the catalytic synthesis of liquid fuels from coal-derived synthesis gas; catalysts contain principally iron, cobalt, nickel, or ruthenium.

**Fischer-Tropsch process**—method of hydrogenating mixtures of carbon monoxide and hydrogen produced from coal, lignite, or natural gas by means of steam, at 1–10 atmospheres and 360–410° F to yield liquid and gaseous fuels, and a wide spectrum of industrial chemicals.

**fixed-bed**—stationary solid particles in intimate contact with fluid passing through them.

**fixed carbon**—the solid residue, other than ash, obtained by destructive distillation; determined by definite prescribed methods.

**flash carbonization**—a carbonization process characterized by short residence times of coal in the reactor to optimize tar yields.

**flue gas**—gaseous combustion products.

**fluidization (dense phase)**—the turbulent motion of solid particles in a fluid stream; the particles are close enough as to interact and give the appearance of a boiling liquid.

**fluidization (entrained)**—gas-solid contacting process in which a bed of finely divided solid particles is lifted and agitated by a rising stream of gas.

**fluidized-bed**—assemblage of small solid particles maintained in balanced suspension against gravity by the upward motion of a gas.

**fly ash**—a fine ash from the pulverized coal burned in power station boilers, or entrained ash carried over from a gasifier.

**fractionation**—distillation process for the separation of the various components of liquid mixtures.

**freeboard**—the space in a fluidized-bed reactor between the top of the bed and the top of the reactor.

**free swelling index**—a standard test that indicates the caking characteristics of coal when burned as a fuel.

**Friedel-Crafts reaction**—a substitution reaction, catalyzed by aluminum chloride in which an alkyl (R-) or acyl (RCO-) group replaces a hydrogen atom of an aromatic nucleus to produce a hydrocarbon or a ketone.

**fuel cell**—a galvanic cell in which the chemical energy of a conventional fuel is utilized to produce electricity.

**fuel gas**—low heating value (150–350 Btu/scf) product generally utilized on site for power generation or industrial use.

**gasification of coal**—the conversion of solid coal into a gaseous form by various chemical reactions with steam.

**gasifier**—a vessel in which gasification occurs, usually utilizing fluidized-bed, fixed-bed, or entrained-bed units.

**heat capacity**—quantity of heat required to raise the temperature of one pound of a substance one degree Fahrenheit.

**high-Btu gas**—a gas having a heating value of 900 to 1,000 Btu per standard cubic foot, which approaches the value for natural gas.

**higher-heating value (HHV)**—the heat liberated during a combustion process in which the product water vapor is condensed to a liquid and the heat of condensation is recovered.

**hydroclone**—a small cyclone extractor for removal of suspended solids from a flowing liquid by means of the centrifuga.

**forces set up when the liquid is made to flow through a tight conical vortex.**

**koking**—coking of tars, SRC, etc., under hydrogenating conditions to form liquid products.

**hydrocracking**—the combination of cracking and hydrogenation of organic compounds.

**hydrogasification**—gasification that involves the direct reaction of fuels with hydrogen to optimize formation of methane.

**hydrogenation**—chemical reactions involving the addition of gaseous hydrogen to a substance in the presence of a catalyst under high temperatures and pressures.

**hydrogen donor solvent**—solvent, such as anthracene oil, tetralin (tetrahydronaphthalene), decalin, etc., which transfers hydrogen to coal constituents causing depolymerization and consequent conversion to liquid products of lower boiling range which are then dissolved by the solvent.

**hydrotreating**—a process to catalytically stabilize petroleum or other liquid hydrocarbon products and/or remove objectionable elements from products or feedstocks by reacting them with hydrogen.

**ideal gas**—any gas whose equation of state is expressed by the ideal gas law, namely  $PV = nRT$  where  $P$  is the pressure,  $V$  is the volume,  $R$  is the gas constant,  $T$  is the absolute temperature, and  $n$  = number of moles.

**ignition temperature**—the minimum temperature necessary to initiate self-sustained combustion of a substance.

**industrial gas**—See Fuel Gas.

**inerts**—constituents of a coal which decrease its efficiency in use, e.g., mineral matter (ash) and moisture in fuel for combustion.

**in situ**—in its original place, e.g., underground gasification of a coal seam.

**intermediate-Btu gas**—synthesis gas product with a higher heating value between 350 and 500 Btu per standard cubic foot.

**lignite**—brownish-black coal containing 65–72 percent carbon on a mineral-matter-free basis, with a rank between peat and subbituminous coal.

**limestone**—sedimentary rock containing 50 percent carbonate ( $CO_3$ ) of lime or magnesia. Chemical formula (for calcite limestone) is  $CaCO_3$ .

**liquefaction**—conversion of a solid to a liquid; with coal, this appears to involve the thermal fracture of carbon-carbon and carbon-oxygen bonds, forming free radicals. These radicals abstract hydrogen atoms yielding low molecular weight gaseous and condensed aromatic liquids.

**liquefied petroleum gas (LPG)**—those hydrocarbons that have a vapor pressure (at 70° F) slightly above atmospheric (such as propane and butane); kept in liquid form under a pressure higher than 1 atm.

**lock hopper**—a mechanical device that permits the introduction of a solid into an environment of different pressure.

**low-Btu gas**—a gas having a heating value up to 350 Btu per standard cubic foot.

**lower heating value**—the heat liberated by a combustion process assuming that none of the water vapor resulting from the process is condensed, so that its latent heat is not available.

**MAF**—moisture and ash-free; a term that relates to the organic fraction in coal.

**mesh**—measure of fineness of a screen, e.g., a 400-mesh sieve has 400 openings per linear inch.

**methanation**—the production of methane ( $CH_4$ ) from carbon monoxide or dioxide and hydrogen.

**methane**— $CH_4$ , a colorless, odorless, and tasteless gas, lighter than air; the chief component of natural gas.

**methanol**—methyl alcohol,  $CH_3OH$ .

**micron**—a unit of length equal to one millionth of a meter;  $10^{-6}$  meter.

**moving bed**—particulated solids in a process vessel that are circulated (moved) either mechanically or by gravity flow.

**natural gas**—naturally occurring gas extracted from sedimentary structures consisting mainly of methane and having a higher heating value of approximately 1,050 Btu per standard cubic foot.

**noncoking coal**—a coal that does not form coke under normal coking conditions.

**olefinic hydrocarbon**—a class of unsaturated hydrocarbons containing one or more double bonds and having the general chemical formula  $C_nH_{2n}$ .

**open cycle**—a thermodynamic power cycle in which the working fluid passes through the system only once and is then exhausted to the atmosphere.

**peat**—an unconsolidated, hydrophilic, yellowish-brown to brownish-black, carbonaceous sediment, formed by accumulation of partially fragmented and decomposed plant remains in swamps and marshes which retains more than 75 percent inherent moisture and less than 12 percent mineral matter in saturated natural deposits.

**petrochemicals**—those derived from crude oil or natural gas, or their coal-derived substitutes; they include light hydrocarbons such as butylene, ethylene and propylene, the raw materials for the production of plastics by polymerization.

**phenols**—a group of aromatic compounds having the hydroxyl (OH) group directly attached to the benzene ring.

**pilot plant**—a chemical process plant containing all the processes of a commercial unit, but on a smaller scale, for the purpose of studying the technical and economic feasibility of the process.

**pipeline gas**—a methane-rich gas that conforms to certain standards and has a higher heating value between 950 and 1,050 Btu per standard cubic foot.

**plenum chamber**—an enclosed space through which air is forced for slow distribution through ducts.

**precoat**—layer of suitable filtering medium, e.g., diatomaceous earth, laid down on a rotary filter cloth prior to operation.

**prilling tower**—a tower that produces small solid agglomerates by spraying a liquid solution in the top and blowing air up from the bottom.

**process development unit**—a system used to study the effects of process variables on performance; sized between a bench-scale unit and a pilot plant.

**proximate analysis**—analysis of coal based on the percentages of moisture, volatile matter, fixed carbon (by difference), and ash, using prescribed methods. Reported on different bases, such as as-received (or as-fired), dry, mineral-matter-free (mmf), and dry mineral-matter-free (dmmf).

**purification**—removal of a wide range of impurities present in gases from coal gasification.

**pyrolysis**—thermal decomposition of organic compounds in the absence of oxygen.

**quenching**—cooling by immersion in oil, water bath, or water spray.

**Raney nickel catalyst**—specially prepared nickel catalyst used in the hydrogenation of organic materials and the methanation of synthesis gas to methane.

**raw gas**—See Crude Gas.

**reactivity**—susceptibility to chemical change; for example, in coal liquefaction, the reactivity of the coal for conversion to liquid products is a function of the coal rank, among other things.

**reactor**—vessel in which coal-conversion reactions take place.

**Rectisol process**—a process for the purification of coal-gasification gas based on the capability of cold methanol to absorb all gas impurities in a single step; gas naphtha, unsaturated hydrocarbons, sulfur compounds, hydrogen cyanide, and carbon dioxide are removed from the gas stream by the methanol at temperatures below 0° C.

**reducing gas**—a gas which, at high temperatures, lowers the state of oxidation of other chemicals.

**reforming processes**—a group of proprietary processes in which low-grade or low molecular weight hydrocarbons are catalytically converted to higher grade or higher molecular weight materials; also applies to the endothermic reforming of methane, for the production of hydrogen, by the reaction of methane and steam in the presence of nickel catalysts.

**refractory**—a material capable of withstanding extremely high temperatures and having a relatively low thermal conductivity.

**residence time**—time spent by a typical particle in a particular zone.

**saturated hydrocarbon**—a carbon-hydrogen compound with all carbon bonds filled; that is, there are no double or triple bonds as in olefins and acetylenes.

**scrubber**—apparatus in which a gas stream is freed of tar, ammonia, and hydrogen sulfide.

**seam coal**—coal which is intermediate in rank between bituminous coal and anthracite; contains 8 to 22 percent volatile matter and from 91 to 93 percent carbon.

**semi-water gas**—a mixture of carbon monoxide, carbon dioxide, hydrogen, and nitrogen, obtained by passing an air-steam mixture through a hot bed of coke, having a higher heating value of about 120 Btu per standard cubic foot.

**sensible heat**—that heat which results in only the elevation of the temperature of a substance with no phase changes.

**shift conversion**—process for the production of gas with a desired carbon monoxide content from crude gases derived from coal gasification; carbon monoxide-rich gas is saturated with steam and passed through a catalytic reactor where the carbon monoxide reacts with steam to produce hydrogen and carbon dioxide, the latter being subsequently removed in a scrubber employing a suitable sorbent.

**sintering**—the agglomeration of solids at temperatures below their melting point, usually as a consequence of heat and pressure.

**slag**—molten coal ash composed primarily of silica, alumina, iron oxides, and calcium and magnesium oxides.

**slurry**—a suspension of pulverized solid in a liquid.

**solvation**—the association or combination of molecules of solvent with solute ions or molecules.

**solvent**—that component of a solution which is present in excess; liquid used to dissolve a substance.

**solvent extraction**—selective solution of coal constituents from finely divided coal particles into a suitable solvent after intimate mixing, usually at high temperatures and pressures in the presence of hydrogen, with or without a catalyst, followed by phase separation.

**solvent refined coal (SRC)**—a coal extract derived by solvent extraction; a brittle, vitreous solid (m.p. 300° F to 400° F) containing about 0.1 percent ash and about 10 percent of sulfur in the original coal feedstock; calorific value is a 16,000 Btu per pound; may be used as a clean fuel for power generation by combustion; utilized for the production of high-grade metallurgical coke, anode carbon, and activated carbon by coking, or hydrogenated to produce synthetic crude oil.

**space velocity**—volume of a gas (measured at standard temperature and pressure) or liquid passing through a given volume of catalyst in a unit time.

**specific gravity**—ratio of the weight of any volume of a substance to the weight of an equal volume of water at 4° C.

**specific heat**—heat capacity of a substance as compared with the heat capacity of an equal weight of water.

**standard cubic foot (SCF)**—the volume of a gas at standard conditions of temperature and pressure. The American Gas Association uses moisture-free gas at 60° F and 30 inches of mercury (1.0037 atm) as its standard conditions. The pressure standard is not universal in the gas industry: 14.7 psia (1.000 atm) and 14.4 psia (0.980 atm) are also used. The scientific community uses 32° F and 1 atm as standard conditions.

**stoichiometry**—the definite proportions in which molecules react chemically to form new molecules.

**stripping**—the removal of the more volatile components from a liquid mixture of compounds.

**subbituminous coal**—the rank of coal between bituminous and lignite, classified by ASTM as having a range of heating values between 8,300 and 11,000 Btu per pound on a moisture and mineral-matter-free basis.

**substitute natural gas (SNG)**—a gas produced from coal, oil sands, or oil shale conforming to natural gas standards.

**superficial velocity**—the linear velocity of a fluid flowing through a bed of solid particles calculated as though the particles were not present.

**superheater**—a heat exchanger which adds heat to the saturated steam leaving a boiler.

**syncrude**—synthetic crude oil; oil produced by the hydrogenation of coal, coal extracts, oil sands, or oil shale, which is similar to petroleum crude.

**synthesis gas**—a mixture of hydrogen and carbon monoxide which can be reacted to yield a hydrocarbon.

**tail gas**—a gas issuing from a gas-treatment unit which may be recycled to the process or exhausted.

**tar (coal)**—a dark brown or black, viscous, combustible liquid formed by the destructive distillation of coal.

**therm**—a unit of heat used as a basis for the sale of natural gas; equal to 100,000 Btu.

**topping cycle**—the higher temperature thermodynamic power cycle of a combined-cycle system.

**turndown ratio**—the minimum ratio of actual flowrate to design flowrate at which a process unit can be operated.

**ultimate analysis**—the determination by prescribed method of carbon and hydrogen in the material as found in the gaseous products of its complete combustion, the determination of sulfur, nitrogen, and ash in the material as a whole and the estimation of oxygen by difference; may be reported on different bases, such as as-received (or as-fired), dry, min matter-free (mmf), and dry mineral-matter-free (dmmf).

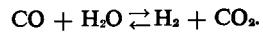
**Venturi scrubber**—a gas cleaning device which involves the injection of water into a stream of dust-laden gas flowing at high velocity through a contracted portion of a duct, thus transferring the dust particles to the water droplets which are subsequently removed.

**volatile matter**—those constituents of coal, exclusive of moisture, that are liberated from a sample when heated to 1750° F for seven minutes in the absence of oxygen.

**water gas**—gas produced by the reaction of carbon (in coal or

coke) and steam to yield mixtures of carbon monoxide and hydrogen; similar to synthesis gas.

**water gas shift**—the reaction between water vapor and carbon monoxide to produce hydrogen and carbon dioxide or the reverse:



**working fluid**—a gas stream which directly does work, e.g., powering a gas turbine.