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Desulfurization of High-Sulfur Lignites (Çan, Çanakkale-Turkey) by the Meyers Method

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Abstract: The uses of high-sulfur coals in burning processes are limited because of environmental pollution. In the world, the reserves of high quality coal are decreasing as well as Turkey where coal reserves are mainly lignite and almost 60% of the known reserves contain high sulfur coals therefore it is important to evaluate the low-quality lignites. Most of the produced lignite is utilized at the coal power stations where low-sulfur content is required. The polluting gases containing sulfur dioxide (SO_2) after burning of low quality coals are the main reason for air pollution, acid rain and some respiratory systems diseases. For instance, a typical un-controlled coal plant emits 14.000 tons of SO_2 per year. In this study, the Meyers (Fe^{3+} salts) method was applied to Çan lignite with high sulfur content. In the first stage, the leaching experiments using Fe^{3+} salts were carried out following Yates experimental design. The effects of particle size, temperature, time and $Fe(NO_3)_3 \cdot 9H_2O$ concentration were investigated for the removal of sulfur. Later, optimization tests were applied taking into consideration effective parameter. Optimum conditions were 0.5 M of Fe^{3+} salts concentration, 70 °C temperature, $d_{100} = 75 \mu m$ particle size and 30 minutes of reaction time.

Keywords: Lignite, Meyers method, Desulfurization, Coal yield, Reaction Time

I. INTRODUCTION

Turkey has important lignite reserves (7.38 billion tons) and Çan (Çanakkale) lignite deposit is an important place in the north-western Turkey. Turkey lignite is not suitable nor as a fuel for home and neither for industry but very suitable for thermal power plants. The quality of Çan lignite reserves is not appropriate for the sulfur content. High amounts of sulfur cause problems, particularly environmental pollution. For this reason, it is extremely important to reduce sulfur from coal prior to application in power plants. Sulfur removal involves physical, biological and chemical methods. In the experimental test procedure, chemical method preferred due to more effective in removing both organic sulfur and inorganic sulfur than other methods. One of the most powerful practices for studying operate attitude is the factorial-design test with analysis of variance (ANOVA) from which information can be used for optimization aims. Statistical design is a significant of tool in understanding process behavior. The statistical-design general notion has been used successfully in leaching studies [1-6].

In this study, removing sulfur from Çan lignite was carried out by Meyers method. The effects of different parameters were investigated by 24 factorial design using the Yates method for leaching tests..

II. MATERIALS AND METHODS

A. Materials

The representative sample (approximately 100 kg) was taken from Çan – TKİ (Turkish Coal Enterprises) Çanakkale, Turkey. Proximate and ultimate analyses of the representative sample were defined according to standard methods. The total sulfur of the coal sample was measured using an ELTRA CS 580 model instrument. The air-dried sample was ground to -125 μm size then it was dried in an oven at 105 °C for 4 h to use for the experimental study. Typical properties of the lignite sample were given in Table 1.

Table I

Proximate And Ultimate Analysis Of Lignite Sample (Dry Basis) (Wt%)

| | Particle size | | |
|---------------------------------------|---------------|----------------|-----------------|
| | < 75 μm | 75-106 μm | 106-125 μm |
| <i>Proximate analyses (dry basis)</i> | | | |
| Ash | 48.19 | 47.14 | 44.22 |
| Volatile matter | 33.02 | 33.01 | 33.07 |

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| | | | |
|-------------------------------|-------|-------|-------|
| Fixed carbon | 18.79 | 19.85 | 22.71 |
| Ultimate analysis (dry basis) | | | |
| Carbon | 30.45 | 31.86 | 33.45 |
| Hydrogen | 3.35 | 3.37 | 3.62 |
| Nitrogen | 2.12 | 2.15 | 2.19 |
| Oxygen | 15.89 | 15.48 | 16.52 |
| Ash | 48.19 | 47.14 | 44.22 |
| Total sulfur | 4.99 | 5.07 | 5.10 |

B. Methods

The impact of factors including a kind of dimensional fractions, temperature, time, and reagent concentration on the degree of desulfurization were researched using the ANOVA Yates test technique. Several tests were performed for estimation the effects of operating conditions. The Yates algorithm [7] for 2^4 experiments was used for statistical design and analysis of the experimental results. Combining the Yates technique with ANOVA (Tables 2 and 3) eases the determination of considerable differences. Experiments were done in a beaker with a magnetic and temperature was measured by a thermometer. In these experiments 5 g of the coal sample were soaked and mixed with distilled water to 50 mL volume. The glass cover was used to avoid evaporation in leaching experiments. The desulfurization of coal by Meyers process with acidic $\text{Fe}(\text{NO}_3)_3 \cdot 9\text{H}_2\text{O}$ solution. The leaching test were performed at $d_{100} = 75 \mu\text{m}$, $-106+75 \mu\text{m}$, $-125+106 \mu\text{m}$ particle sizes, concentration of $\text{Fe}(\text{NO}_3)_3 \cdot 9\text{H}_2\text{O}$ (0.10, 0.25, 0.5 M), leaching time (30, 60, 90 min.) and temperature (30, 50, 70 °C).

Table II Leaching Parameter Levels

| Description | Factor | Low level | Base level | High level |
|--|--------|-----------|------------|------------|
| Particle size (μm) | A | <75 | 75-106 | 106-125 |
| Temperature (°C) | B | 30 | 50 | 70 |
| Time (min) | C | 30 | 60 | 90 |
| $\text{Fe}(\text{NO}_3)_3 \cdot 9\text{H}_2\text{O}$ (M) | D | 0.10 | 0.25 | 0.50 |

Table III

Leaching experimental design of anova-yates test technique

| Yates arrangements | A Particle size (μm) | B Temperature (°C) | C Time (min.) | D $\text{Fe}(\text{NO}_3)_3 \cdot 9\text{H}_2\text{O}$ (M) |
|--------------------|---|--------------------------|---------------------|--|
| 1 | < 75 | 30 | 30 | 0.10 |
| a | 75-106 | 30 | 30 | 0.10 |
| b | < 75 | 70 | 30 | 0.10 |
| ab | 75-106 | 70 | 30 | 0.10 |
| c | < 75 | 30 | 90 | 0.10 |
| ac | 75-106 | 30 | 90 | 0.10 |
| bc | < 75 | 70 | 90 | 0.10 |
| abc | 75-106 | 70 | 90 | 0.10 |
| d | < 75 | 30 | 30 | 0.50 |
| ad | 75-106 | 30 | 30 | 0.50 |
| bd | < 75 | 70 | 30 | 0.50 |
| abd | 75-106 | 70 | 30 | 0.50 |
| cd | < 75 | 30 | 90 | 0.50 |
| acd | 75-106 | 30 | 90 | 0.50 |
| bcd | < 75 | 70 | 90 | 0.50 |
| abcd | 75-106 | 70 | 90 | 0.50 |
| Medium 1 | 106-125 | 50 | 60 | 0.25 |
| Medium2 | 106-125 | 50 | 60 | 0.25 |
| Medium3 | 106-125 | 50 | 60 | 0.25 |

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The statistical design of leaching test is used when it can be desired to learn fundamental and impact of coaction used experimental parameters [8-13]. The leaching test was conducted to determine mostly the effect of the studied factor on the desulfurization process. Four parameters were taken into account in the experimental tests particle such as size (A), temperature (B), time (C) and concentration of $\text{Fe}(\text{NO}_3)_3 \cdot 9\text{H}_2\text{O}$ (D) were set at their highest levels. Four parameters were determined and analysis of variance (ANOVA, Yates method) was employed using 2^n design (n = number of parameters, 4). The 2^k adverts to designs with k factors where each factor has just two levels. In the present state, it was $2^4 = 16$ where $k = 4$.

The three factors, considered important to the operation, were particle size (X_1), temperature (X_2), reaction time (X_3) and $\text{Fe}(\text{NO}_3)_3 \cdot 9\text{H}_2\text{O}$ concentration (X_4). The particle size, temperature, reaction time and $\text{Fe}(\text{NO}_3)_3 \cdot 9\text{H}_2\text{O}$ concentrations can all be changed continuously along their respective scales, from a low to a high setting.

Besides the leaching tests that composed the central point of the experimental design, assigned by arithmetic means of the high and low levels. The higher level term was described as '+' and lower level term as '-'. The four experiments were performed at the base level to estimate error and standard deviation. The stirring speed was kept constant during the leaching tests. The ANOVA experimental parameter levels and experimental design were given in Tables 4 and 5. High-level and low-level are typically terms used to classify, describe and point to specific goals of a systematic operation.

The all possible factor combinations mean that we can estimate all the main and interaction effects. There are four main effects, four-three factor interactions, and a four-factor interaction, all of which appear in the full model as follows:

The regression equation with interactive terms can be composed as:

$$Y = b_0 + b_1X_1 + b_2X_2 + b_3X_3 + b_4X_1X_2 + b_5X_1X_3 + b_6X_2X_3 + b_7X_1X_2X_3$$

The model created for removal of sulfur using the impact of changeable significance at the greater reliance interval is given bellows:

C. For Removal Sulfur

$$Y = 26.81 + 2.216258X_1 + 7.87625X_2 + 8.20625X_4 + 6.98X_2X_4$$

The correlation coefficient, R^2 , is used to control the model's ability to predict the answer completely. The empirical models were discovered to estimate accurately the response variable, as define by the R^2 value, which was 0.9895. The residual analysis for removal of sulfur was given in Figure 2.

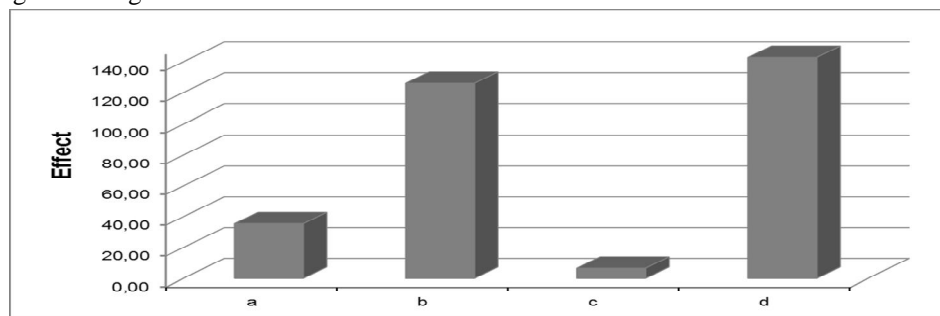


Fig.1 Main effects of variables active ratio. a = particle size (μm); b = temperature ($^\circ\text{C}$); c = reaction time (min); d = $\text{Fe}(\text{NO}_3)_3 \cdot 9\text{H}_2\text{O}$ concentration (M).

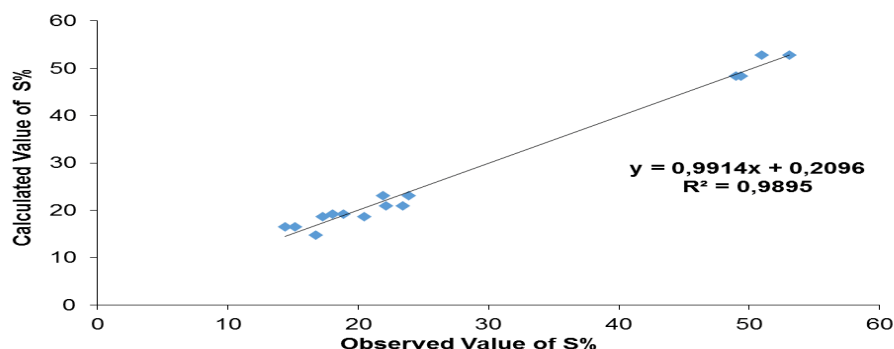


Fig. 2 Removal of sulfur values between observed and fitted responses for Meyers Method.

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Table IV
Fe(NO₃)₃.9H₂O leaching results for desulfurization

| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | 15 | 16 | 17 |
|--------------------|-----------------------------------|--------|--------|--------|--------|---------|----|-------------|---------------------|----------|----------------|----------------|----------------|----------------|------------------|------------|
| Yates arrangements | Experimental results (S% removal) | I | II | III | IV | MS | DF | F (Calc.) | F (Table) 1;16;0.05 | Decision | X ₁ | X ₂ | X ₃ | X ₄ | Y (Calculations) | Coal yield |
| 1 | 14.33 | 32.32 | 68.85 | 143.03 | 428.88 | 464.34 | 1 | 32.52014679 | 4.49 | Active | -1 | -1 | -1 | -1 | | 89.24 |
| a | 17.99 | 36.53 | 74.18 | 285.85 | 35.46 | 78.59 | 1 | 5.503942398 | 4.49 | Active | 1 | -1 | -1 | -1 | 19.19875 | 89.57 |
| b | 14.42 | 35.61 | 142.31 | 21.75 | 126.02 | 992.57 | 1 | 69.51449437 | 4.49 | Active | -1 | 1 | -1 | -1 | 16.55875 | 88.44 |
| ab | 22.11 | 38.57 | 143.54 | 13.71 | 8.04 | 4.04 | 1 | 0.282949229 | 4.49 | Inactive | 1 | 1 | -1 | -1 | 20.99125 | 87.06 |
| c | 16.77 | 42.38 | 11.35 | 7.17 | 6.56 | 2.69 | 1 | 0.188366686 | 4.49 | Inactive | -1 | -1 | 1 | -1 | 14.76625 | 87.02 |
| ac | 18.84 | 99.93 | 10.40 | 118.85 | 5.86 | 2.15 | 1 | 0.150311306 | 4.49 | Inactive | 1 | -1 | 1 | -1 | 19.19875 | 87.03 |
| bc | 15.12 | 41.12 | 3.45 | 10.29 | 2.50 | 0.39 | 1 | 0.027357502 | 4.49 | Inactive | -1 | 1 | 1 | -1 | 16.55875 | 84.94 |
| abc | 23.45 | 102.42 | 10.26 | -2.25 | -1.24 | 0.10 | 1 | 0.006730383 | 4.49 | Inactive | 1 | 1 | 1 | -1 | 20.99125 | 85.30 |
| d | 20.48 | 3.66 | 4.21 | 5.33 | 142.82 | 1274.85 | 1 | 89.28417193 | 4.49 | Active | -1 | -1 | -1 | 1 | 18.65875 | 85.33 |
| ad | 21.90 | 7.69 | 2.96 | 1.23 | -8.04 | 4.04 | 1 | 0.282949229 | 4.49 | Inactive | 1 | -1 | -1 | 1 | 23.09125 | 83.44 |
| bd | 48.95 | 2.07 | 57.55 | -0.95 | 111.68 | 779.53 | 1 | 54.59429073 | 4.49 | Active | -1 | 1 | -1 | 1 | 48.37125 | 91.63 |
| abd | 50.98 | 8.33 | 61.30 | 6.81 | -12.54 | 9.83 | 1 | 0.688321746 | 4.49 | Inactive | 1 | 1 | -1 | 1 | 52.80375 | 96.80 |
| cd | 17.28 | 1.42 | 4.03 | -1.25 | -4.10 | 1.05 | 1 | 0.073580737 | 4.49 | Inactive | -1 | -1 | 1 | 1 | 18.65875 | 85.27 |
| acd | 23.84 | 2.03 | 6.26 | 3.75 | 7.76 | 3.76 | 1 | 0.263584495 | 4.49 | Inactive | 1 | -1 | 1 | 1 | 23.09125 | 86.28 |
| bcd | 49.36 | 6.56 | 0.61 | 2.23 | 5.00 | 1.56 | 1 | 0.109430007 | 4.49 | Inactive | -1 | 1 | 1 | 1 | 48.37125 | 87.51 |
| abcd | 53.06 | 3.70 | -2.86 | -3.47 | -5.70 | 2.03 | 1 | 0.142215237 | 4.49 | Inactive | 1 | 1 | 1 | 1 | 52.80375 | 78.82 |

a: particle size (μm), b: temperature (°C), c: time (min), d: Fe(NO₃)₃.9H₂O (M)

F (Calculation): (MS/DF)

Y: Calculated value of S% extra

III. OPTIMIZATION DESIGN

Optimization tests were carried out the steepest ascent method in which the set of value sequentially chose to correspond to the product of the factor. The objective function was estimated as much as optimum period was achieved that values on the way to destination were incremented and decreased [12].

The significance of each parameter on the efficiency of desulfurization was assessed using a, b, c and d exponents. ANOVA- Yates test technique showed that temperature and Fe(NO₃)₃.9H₂O concentration was the least influential parameter when compared with other parameters for removal sulfur of the high – sulfur lignite. The optimization test terms were elected with respect to Table 4.

As a result of the optimization process, the removal of sulfur from the coal was further reduced from 5.10 %S to 2.10 %S. The removal of sulfur of the coal increased to 60.16% same as the yield of the coal increased to 94.36% (Table 5).

Table V
Optimization test conditions

| Variable | Fe(NO ₃) ₃ .9H ₂ O (M) | Temperature (°C) |
|---------------------------------------|--|------------------|
| Principal level Z _{jo} | 0.50 | 70.00 |
| Increment, delta Z _j | 0.20 | 20.00 |
| Coefficient, b _j | 8.21 | 7.87 |
| Delta Z _j * b _j | 1.64 | 157.40 |
| Normal steps | 0.10 | 5.00 |

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Table VI
Results of optimization parameters

| Experiments | Temperature (°C) | Fe(NO ₃) ₃ .9H ₂ O (M) | Sulfur removal (%) | Coal yield (%) |
|-------------|------------------|--|--------------------|----------------|
| 1 | 60 | 0.3 | 26.25 | 87.08 |
| 2 | 60 | 0.4 | 42.10 | 89.71 |
| 3 | 60 | 0.6 | 45.53 | 87.91 |
| 4 | 60 | 0.7 | 46.65 | 88.60 |
| 5 | 65 | 0.3 | 42.01 | 92.50 |
| 6 | 65 | 0.4 | 41.63 | 88.62 |
| 7 | 65 | 0.6 | 47.86 | 88.60 |
| 8 | 65 | 0.7 | 51.27 | 87.86 |
| 9 | 75 | 0.3 | 36.88 | 94.43 |
| 10 | 75 | 0.4 | 39.21 | 95.75 |
| 11 | 75 | 0.6 | 51.87 | 84.28 |
| 12 | 75 | 0.7 | 50.91 | 85.52 |
| 13 | 80 | 0.3 | 44.50 | 91.67 |
| 14 | 80 | 0.4 | 42.50 | 95.80 |
| 15 | 80 | 0.6 | 51.42 | 92.10 |
| 16 | 80 | 0.7 | 60.16 | 94.36 |

IV. RESULTS AND DISCUSSION

The parameters investigated in the experimental work were: Fe(NO₃)₃.9H₂O concentration (0.5, 0.25, 0.10 M), temperature (30, 50 and 70 °C), reaction time (30, 60 and 90 min.) and particle size. The ANOVA-Yates technique for 24 experimental test was used for statistical evaluation of the tests result. The most sulfur removal was acquired by reaction time and Fe(NO₃)₃.9H₂O concentration. The effect of each variable for desulfurization was ("bd" of ANOVA factor) where d100 = 75 µm, 70 °C, 30 min. reaction time and 0.50 M Fe(NO₃)₃.9H₂O. The optimization step of experimental conditions was selected with respect to using the steepest ascend method. The highest sulfur removal value was obtained at 80 oC and 0.7 M Fe(NO₃)₃.9H₂O concentration with 60.16% sulfur removal and 94.36% coal yield.

A. The Influence of Experimental Tests

To understand the effect of the particle size on sulfur removal from the coal, d₁₀₀ = 75 µm, -106+75 µm and -125+106 µm particle sizes were used in the leaching experiments. The results showed that the removal of sulfur increased with decreasing particle size. The reaction of Fe(NO₃)₃.9H₂O concentration was investigated using 0.10, 0.25, 0.30, 0.4, 0.50, 0.6 and 0.6 M Fe(NO₃)₃.9H₂O liquor. The results of ANOVA and optimization tests show that the removal sulfur increased with increasing chemical concentration. The effect of reaction time was altered from 30 to 90 min. It was observed that leaching time had no effect. The leaching temperature were studied in the range of 30 - 70 °C. The desulfurization increased as the temperature was increased and achieved its peak sulfur removal at 80 °C.

V. CONCLUSIONS

The experimental work showed that the removal of sulfur was 60.16% for the coal taken from Çan-TKİ, Çanakkale, Turkey at the optimum conditions of chemical leaching where 0.70 M of Fe(NO₃)₃.9H₂O, 80 °C, 30 min. of leaching time and d100 = 75 µm.

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