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Operating experience of a 50kwth methane chemical looping reactor

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US Department of Energy

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National Energy Technology Laboratory



Motivation for this work





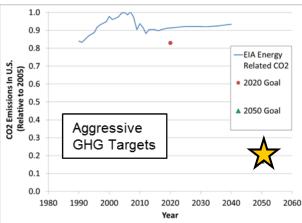
- Domestic importance of fossil fuels
 - Need fossil fuel options that produce minimal GHGs
- CLC technology has "potential" to achieve DOE goals

Cost	Fe ₂ O ₃ (\$/MWh)	CaSO₄ (\$/MWh)	Conventional PC BBR Case 12					
Capital	49.6	53.4	73.1					
Fixed	11.3	12.2	15.7					
Variable	25.7	8.4	13.2					
Maintenance materials	3.2	3.5	4.7					
Water	0.4	0.4	0.9					
Oxygen carrier makeup *	18.7	1.1	N/A					
Other chemicals & catalyst	1.9	1.7	6.4					
Waste disposal	1.4	1.7	1.3					
Fuel	28.4	30.8	35.3					
Total	115.1	104.7	137.3					

Exhibit ES-3 Cost of electricity breakdown comparison

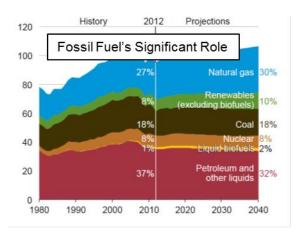
*Fe $_2O_3$ oxygen carrier makeup: 132 tons/day @ \$2,000 per ton; Limestone carrier makeup: 439 tons/day @ \$33.5 per ton

Ref: U.S. Department of Energy (DOE), National Energy Technology Laboratory (NETL). Guidance for NETL's Oxycombustion R&D Program: Chemical Looping Combustion Reference Plant Designs and Sensitivity Studies. Pittsburgh : s.n., 2014. DOE/NETL-2014/1643



Presidential Energy-Related GHG Targets

http://www.eia.gov/environment/emissions/carbon



AEO2014 - Early Release

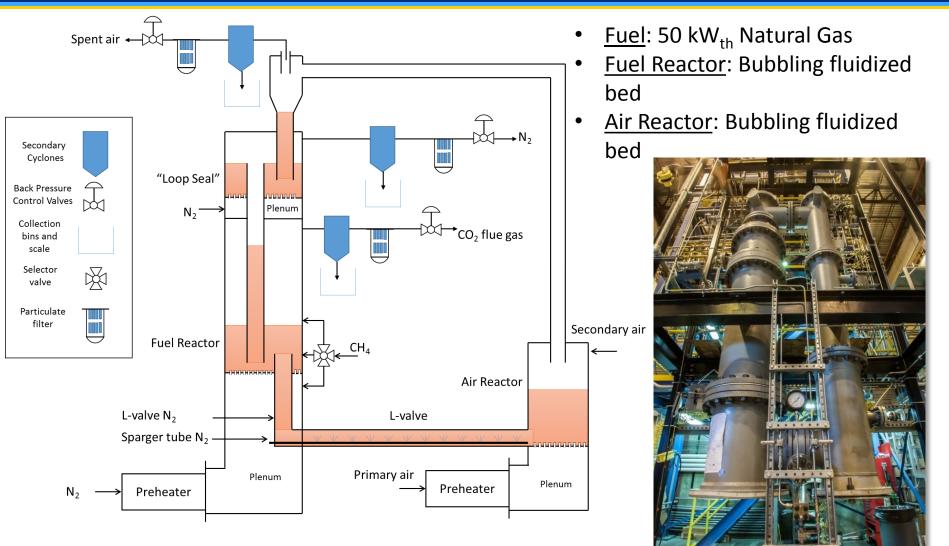
What is our end goal?

- Determine if CLC is a feasible technology for FE and worthy of additional investment/development
 - ightarrow Data and information for strategic decision making
- If it is feasible, THEN
 - Help developers overcome technical issues
 - Help technology be successful
 - Ultimately commercialization
 - ightarrow jobs and growth



Chemical Looping Reactor: Test Apparatus



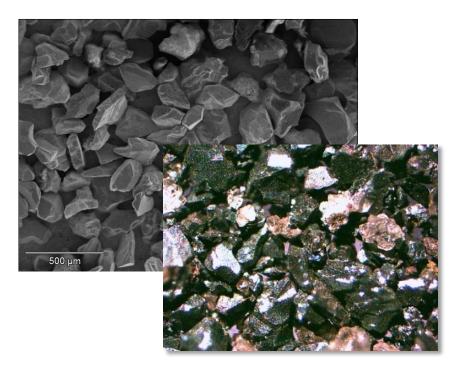


Oxygen Carrier Material: Raw Hematite

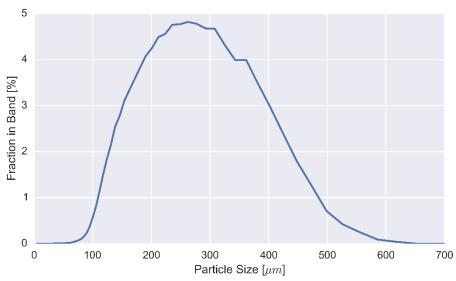


Hematite is a "baseline" oxygen carrier

<u>Material</u>: Natural Hematite Ore <u>Source</u>: Wabush Mine, Canada



SEM and light microscopy of Hematite



Particle density	4.9	g/cm ³		
Sauter Mean Diam.	210	μm		
D ₅₀	238	μm		
Sphericty	0.876			
U _{mf} (at 298 K)	8.55	cm/s		

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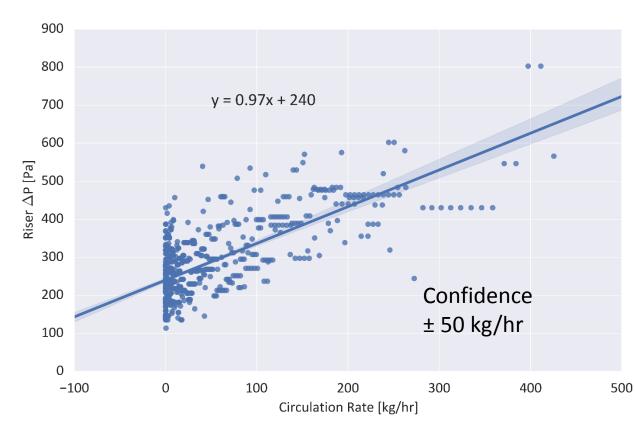
Determination of Solids Circulation Rate



L-valve cutoff tests were performed to measure the • solids circulation rate Shutting off L-valve causes solids to build up in fuel dm A dP $\overline{dt} = \overline{g} \cdot \overline{dt}$ reactor and exit the air reactor The pressure drop in the air and fuel reactors can be $\Delta P(t) = P_1 + (P_0 - P_1)e^{-k(t-t_0)}$ fit to an exponential to determine solids flow rate 14 80 1000 Air Reactor Riser Sparger 70 900 12 Fuel Reactor Aeration 60 800 10 Gas Flow [SLPM] 50 700 [Pa] ∆P [kPa] 8 ressure 40 600 30 500 4 20 400 2 10 300 0 200 0 16:58 16:51 16:54 16:55 16:56 16:57 Time Time National Energy

Circulation Rate Estimation Correlation



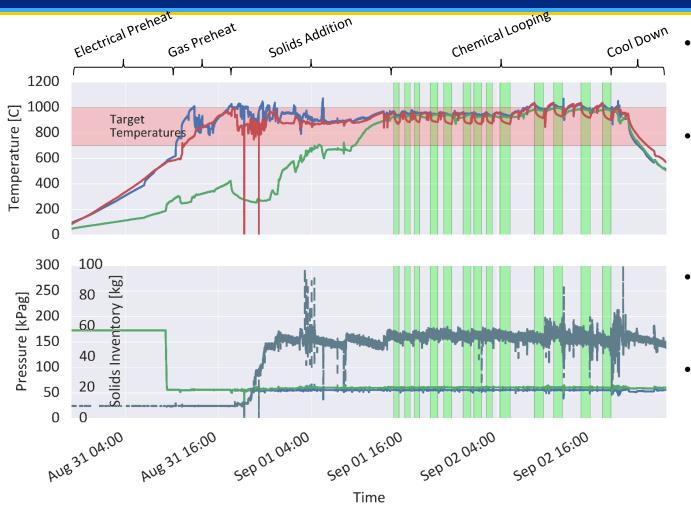


- Correlation created from riser pressure drop data and the calculated circulation rate from the L-valve cutoff tests
- Used for finding solids flow rate during trials based on riser pressure drop
- Standard error of data results in confidence of +/- 50 kg/hr
- Compares well with relation based on solids holdup

$$\dot{\mathbf{m}}_{s} = \frac{\left(U_{g} - U_{term}\right)A_{riser}}{gh_{riser}}\Delta P$$

Chemical Looping Test Campaign





Test Duration: 3 days, 4 hours and 48 minutes

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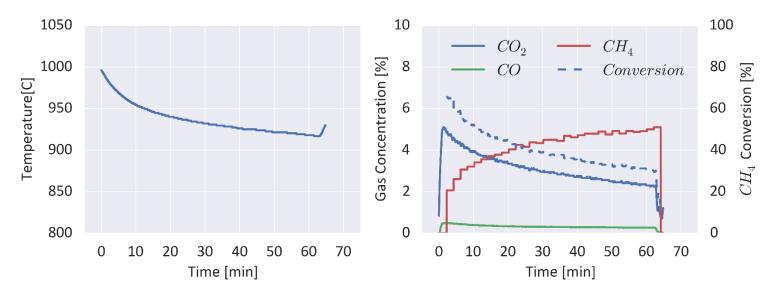
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Electric preheat

- Room temperature →
 Auto-ignition
 temperature
- Natural gas augmented preheat
 - 1200F to 2000F
 - Gas phase combustion in both reactors
- Carrier addition
 - Reduce gas flows
 - Add carrier in batches via lockhopper
- Chemical looping combustion
 - Transition from air to
 N2 as fluidizing gas in
 FR
 - Adjust natural gas flow for CLC

Typical Chemical Looping Period





- Chemical looping tests began by transitioning from combustion mode in the fuel reactor (replacing air with nitrogen)
- Temperature in Fuel Reactor decays rapidly due to significant heat losses from the system and the endothermic reactions between CH₄ and hematite.
- Outlet gas concentration of CH₄ increases and the concentration of CO₂ decreases, and the methane conversion decreases (see Figure 7)

Performance Parameters



- 12 chemical looping tests periods
- 12.8 hrs of chemical looping
- **Circulation** rates ranged from 387 to 434 kg/hr
- Carbon balance ranged from 89 – 99%
- Methane conversion between 9-41%

Methane Conversion

Test	1	2	3	4	5	6	7	8	9	10	11	12
Duration [min]	41	40	59	62	59	61	47	78	70	69	74	66
Average FR Temperature [C]	895	894	892	881	881	880	886	884	936	944	936	922
Gas residence Time [s]	1.55	1.57	0.81	0.81	0.77	1.58	0.79	1.58	1.47	1.59	0.75	0.71
Methane Inlet Concentration	7%	14%	7%	14%	14%	14%	7%	7%	7%	14%	7%	15%
Circulation Rate [kg/hr]	389	400	434	431	415	387	419	390	398	434	431	411
Carbon Balance	92%	97%	97%	95%	99%	91%	98%	91%	89%	97%	97%	99%
CH4 Conversion	35%	26%	18%	9%	11%	27%	18%	27%	41%	35%	24%	15%

Carbon Balance

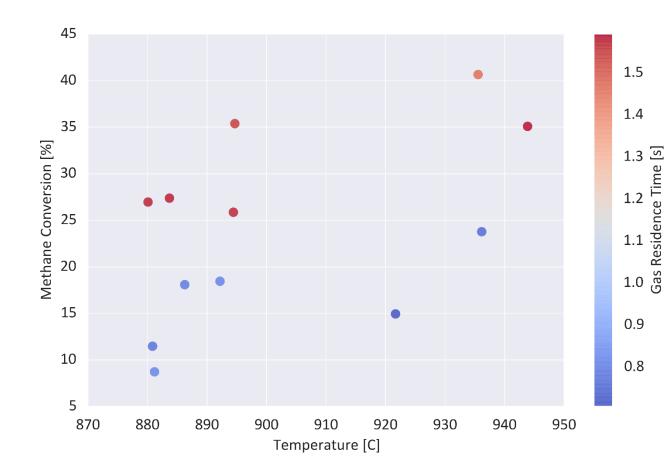
 $X_{CH_4} = \frac{\chi_{CO_2,out}}{\chi_{CH_4,in}} \qquad C_{\text{balance}} = \frac{\chi_{CO_2,out} + \chi_{CO,out} + \chi_{CH_4,out}}{\chi_{CH_4,in}}$

Mean Gas Residence Time

$$\pi = \frac{h_{bed}}{V_{gas}} , \quad h_{bed} = \frac{\Delta P}{\rho_s g(1-\varepsilon)}$$

Effect of Fuel Reactor Temperature



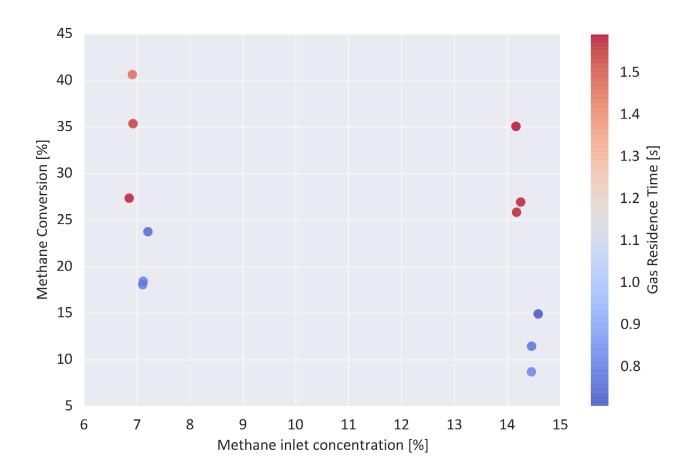


- Average temperature in fuel reactor has a strong effect on conversion
 Trials with similar
- Trials with similar gas residence times show increase in conversion with
 - temperature
- Scatter due to variability in solids circulation rate

Effect of Inlet Methane Concentration

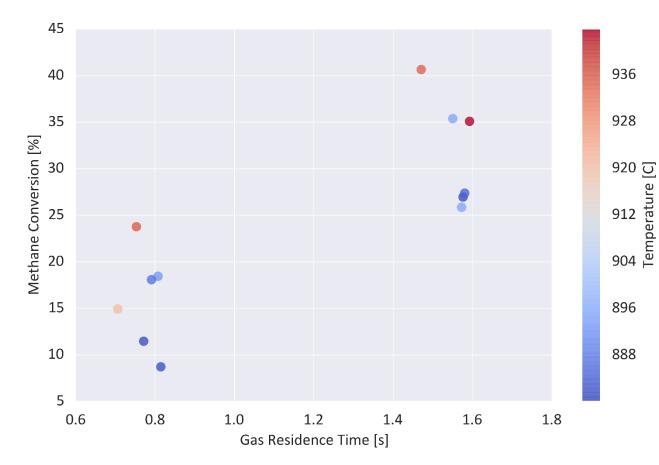
NETL

- For similar gas residence times, greater methane inlet concentrations result in lower methane conversions
- Scatter due to variance in solids circulation rate



Gas Residence Time

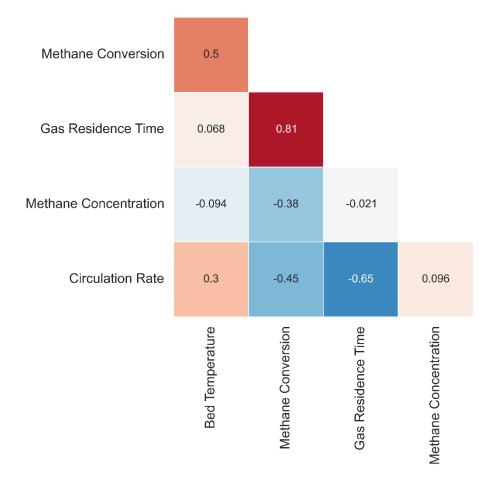




- As the gas residence time increases, the methane conversion increases.
- The data is scattered because the temperature and solid circulation rates are changing between conditions.

Pearson Correlation Matrix





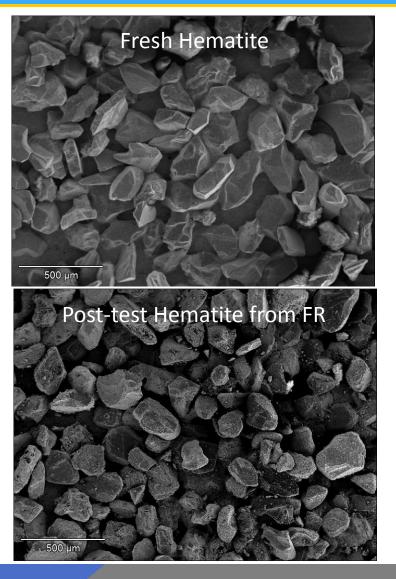
- Pearson correlation coefficients were calculated for the various combination of experimental parameters
- Strongest relationship identified between gas residence time and methane conversion (r_{pearson} =0.81)
- A strong relationship between the bed temperature and the methane conversion is identified(r_{pearson} =0.5)
- The inverse relationship between the inlet methane concentration and the methane conversion is also identified (r_{pearson} = -0.38)

Post Test Analysis





• Carrier agglomeration in Fuel Reactor near bubble caps







- Chemical looping tests utilized a natural hematite ore that has a relatively low reactivity, conducted at temperatures that ranged from 850 – 1000°C.
- The oxygen carrier circulation rates for these tests were on the order of 400 kg/hr, and the conversion of methane to carbon dioxide ranged from 9-41%.
- The fuel reactor temperature and the bulk gas residence time through the fuel reactor bed are two factors that have a significant effect on the observed fuel conversion.
- The hematite oxygen carrier material seems to be a very durable mineral for chemical looping combustion applications, but the reactivity is very poor.
- There are also some indications that this material could experience some agglomeration issues if the operating temperature exceeds 1000°C.

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