

## Industrial scale anaerobic digestion of brewery effluent

Tanja Radu, Richard Blanchard, Vincent Smedley, and Andrew Wheatley

Unilever AD facilities process brewery effluent using EGSB. Here, we report operational experiences over the period of three years. The process performance and stability is closely monitored by a range of parameters, including COD, pH, and suspended solids. Ripley's ratio and volatile fatty acids, are the most successful to control. The feed COD concentration averages 15000 mg/l and is reduced to 120 mg/l in the effluent (99.2% COD reduction). Suspended solids concentrations are reduced from 2400 mg/l in the effluent to 55 mg/l. Biogas is being produced at an average of 80 m<sup>3</sup>/h, with 70±9% methane content. We pay special attention to the issues of gas/liquid separation.