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Cranfield
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Simulation of Oxy-combustion co-firing Coal and Biomass with ASU and Steam Turbine using Aspen Plus

Nelia Jurado

(n.jurado@cranfield.ac.uk)

Hamid G Darabkhani

(h.g.darabkhani@cranfield.ac.uk)

John E Oakey

(j.e.oakey@cranfield.ac.uk)

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<http://www.cranfield.ac.uk>



Scope and Aims

Study the oxy-combustion process, co-firing blends of coal and biomass, through a rate-based simulation model.

The validated model will be used as a tool to select future test parameters

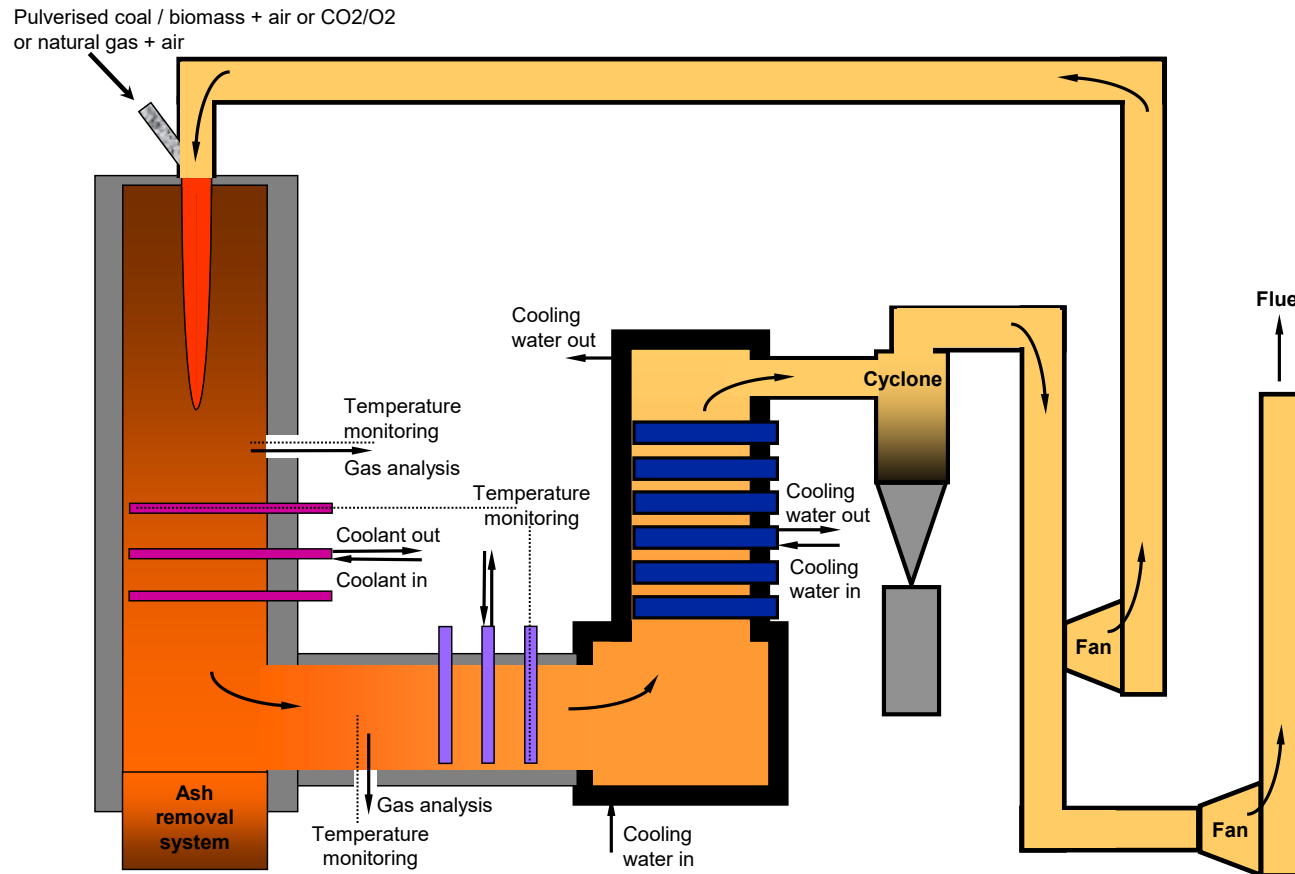
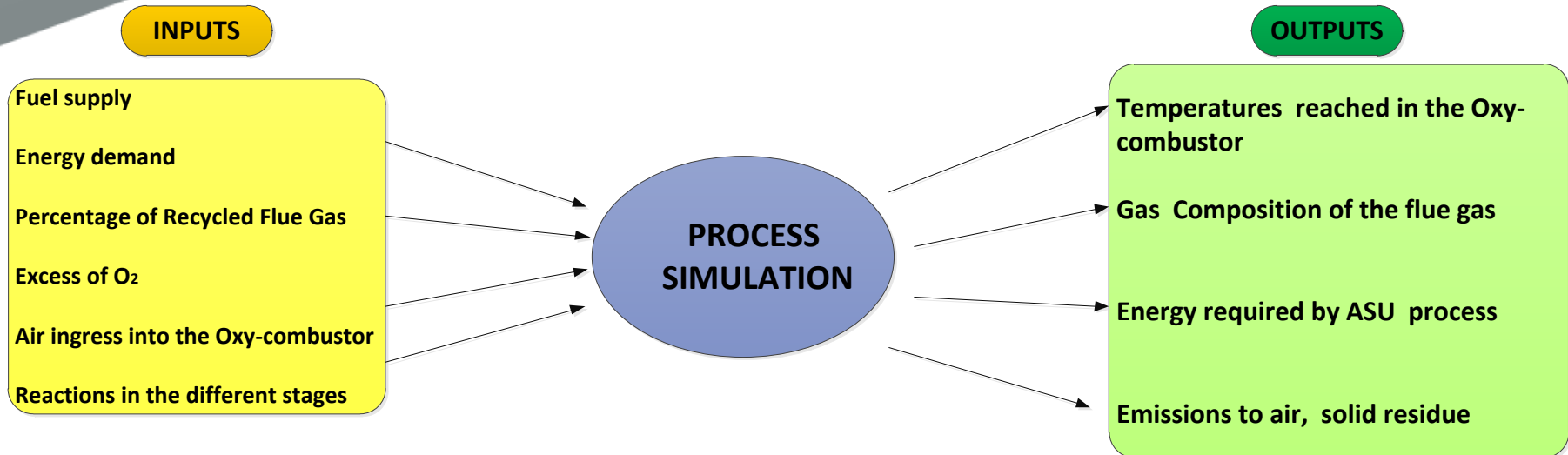


Diagram of 100kWth Multi-fuel Oxy-Combustor at CERT

Simulation Process BASICS



Limitations of Aspen Plus

- ✓ Prediction of adiabatic flame temperature (without considering composition of the gas for the heat transfer)
- ✓ Solid residue same composition as ash defined as input (inability to simulate reaction involving solid phase)

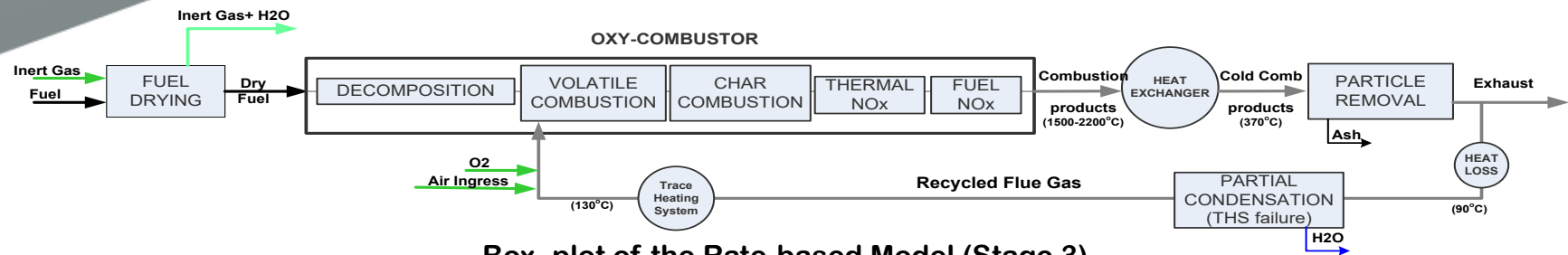
Simulations using Aspen Plus® STAGES

KINETIC MODEL

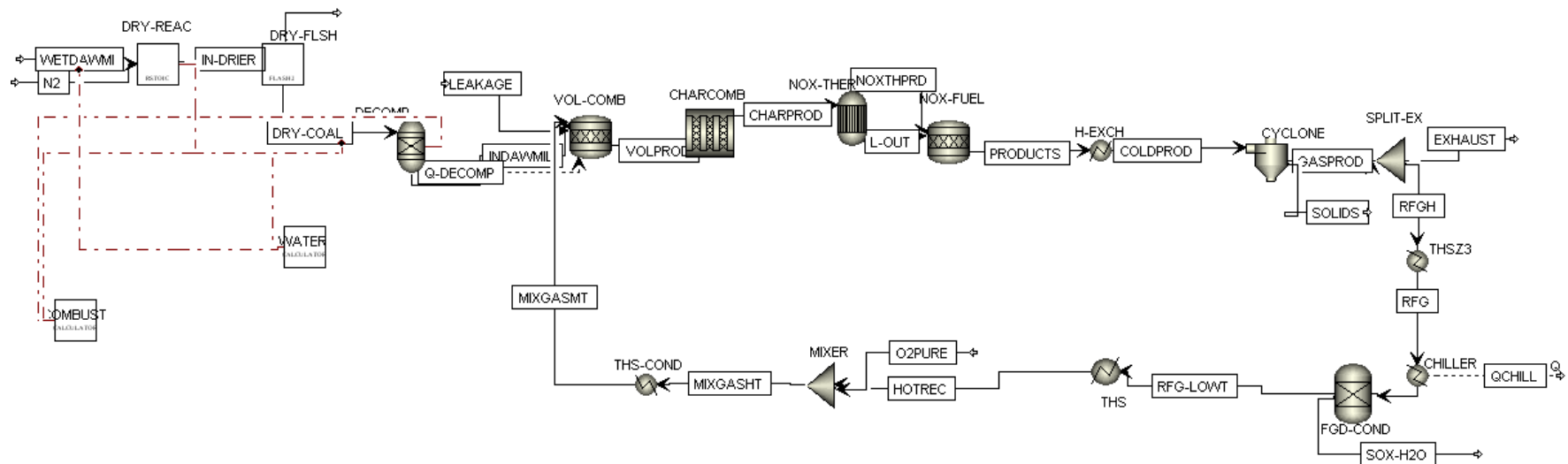
	STAGE 1 Air-firing case	STAGE 2 Oxy-firing case with wet recirculation, heat loss and air leakage	STAGE 3 Oxy-firing case with partial condensation in RFG, heat loss and air leakage	STAGE 4 Oxy-firing case with dry recirculation, heat loss, air leakage	STAGE 5 Air-firing case with power generation unit	STAGE 6 Oxy-firing case with dry recirculation, heat loss, air leakage, ASU and power generation unit
AIR/ OXY-FIRING	Air -firing	Oxy -firing	Oxy -firing	Oxy -firing	Air -firing	Oxy -firing
RFG (%)	--	55, 60, 65, 70	55, 60, 65, 70	55, 60, 65	--	55, 60, 65
O ₂ Exc (%) (v/v)	21	0,5,10	0,5	0,5	21	0,5
T _{RFG} (°C)	--	130	75,90	130	--	130-200
Air Leakage (% of Total Gas fed)	--	1.7	0, 2, 10, 18	10	--	10
Fuel	Coal	Coal (El Cerrejon, Daw Mill), Biomass(Cereal Co-Product, Miscanthus), blends of coal and biomass (75/25; 50/50; 25/75)	Daw Mill coal, Cereal Co-Product biomass, blends of coal and biomass (75/25; 50/50; 25/75)	El Cerrejon coal, Cereal Co-Product biomass, blends of coal and biomass (75/25; 50/50; 25/75)	Coal	El Cerrejon coal, Cereal Co-Product biomass, blends of coal and biomass (75/25; 50/50; 25/75)
RFG Purification	Particle removal	Particle removal	Particle removal	Particle removal, acid species and water vapour condensation	Particle removal, acid species and water vapour condensation	Particle removal, acid species and water vapour condensation

- ✓ Establish reference cases (Stages 1 and 5)
- ✓ Validation of the model by applying similar conditions to experiments (Stage 3)
- ✓ Simulations with condenser implemented to include dry RFG (Stage 4)
- ✓ Simulation of the entire system including ASU and steam turbine (Stage 6)

Simulations using Aspen Plus®: MODEL VALIDATION



Box-plot of the Rate-based Model (Stage 3)



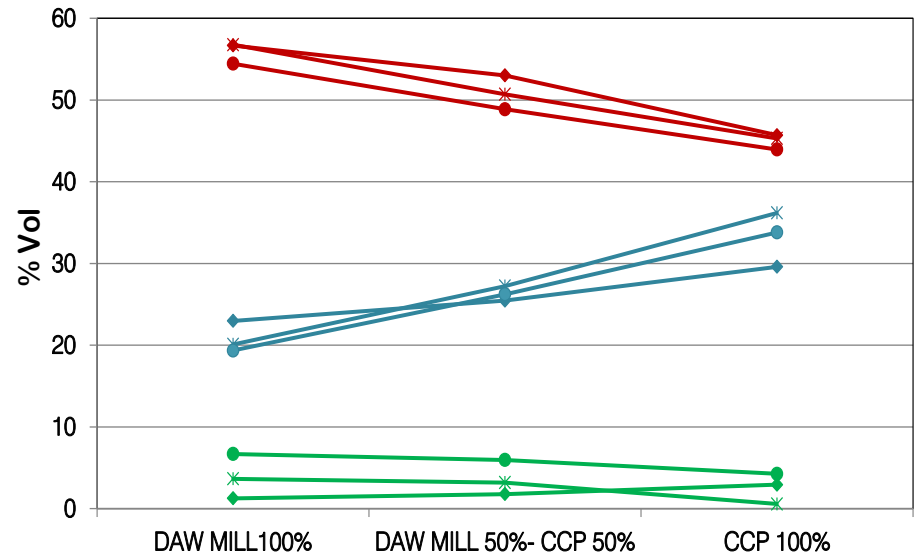
Interface of the rate-based model with partial condensation on the RFG in Aspen Plus (Stage 3)

Simulations using Aspen Plus®:

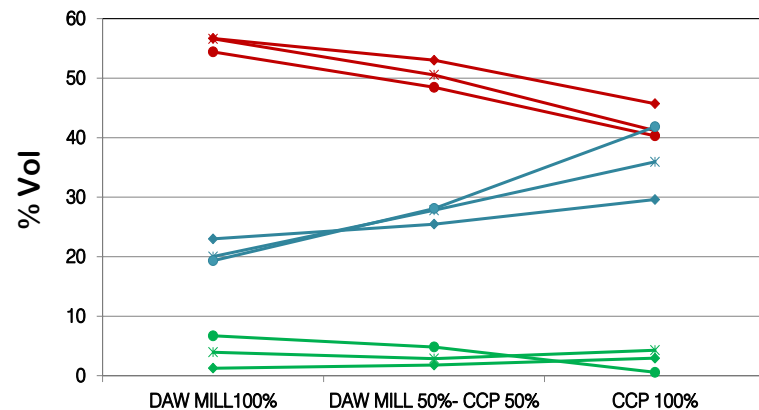
AIR INGRESS COMPARISON

CO2 EXP H2O EXP EXP O2 EXP
 CO2 out 0%exc O2 H2O out 0%exc O2 O2 out 0%exc O2
 CO2 out 5%exc O2 H2O out 5%exc O2 O2 out 5%exc O2

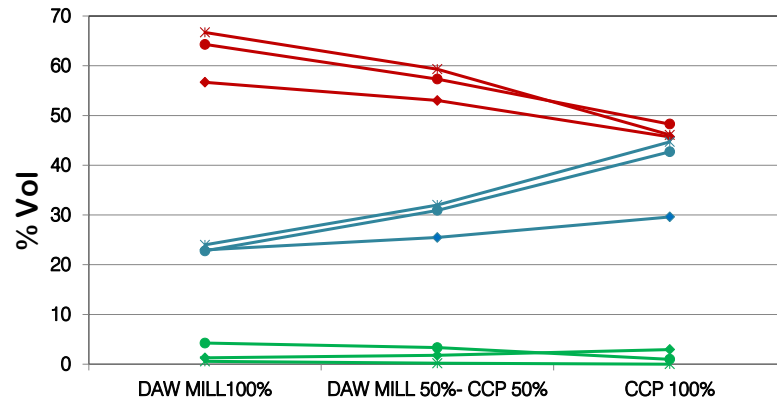
10% AIR INGRESS and PARTIAL CONDENSATION



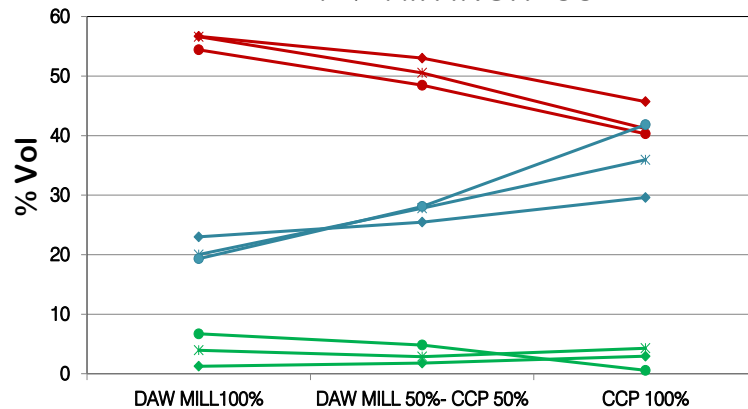
18% AIR INGRESS



2% AIR INGRESS



10% AIR INGRESS



On-going modifications in the Pilot Plant: WATER AND ACID SPECIES REMOVAL

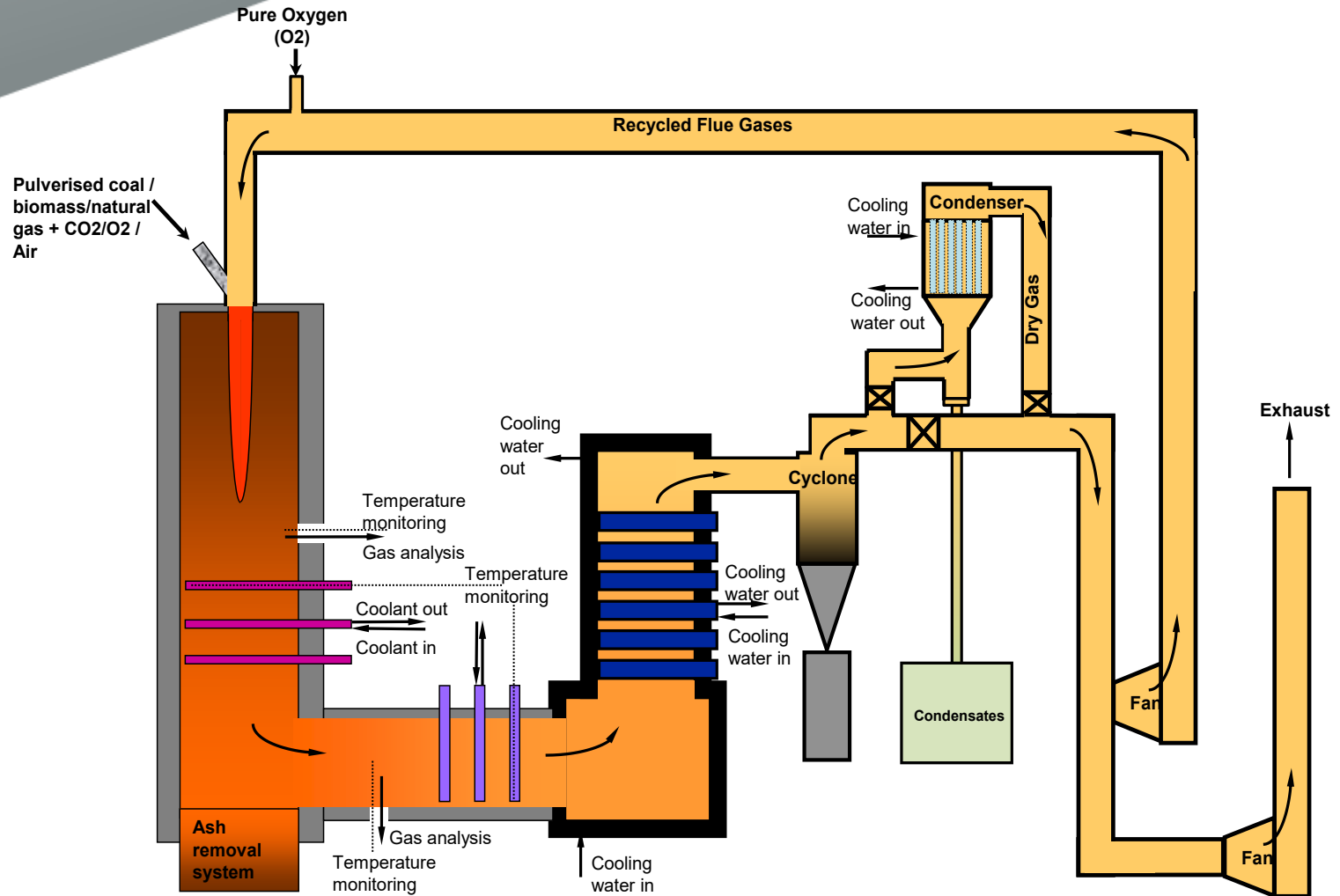
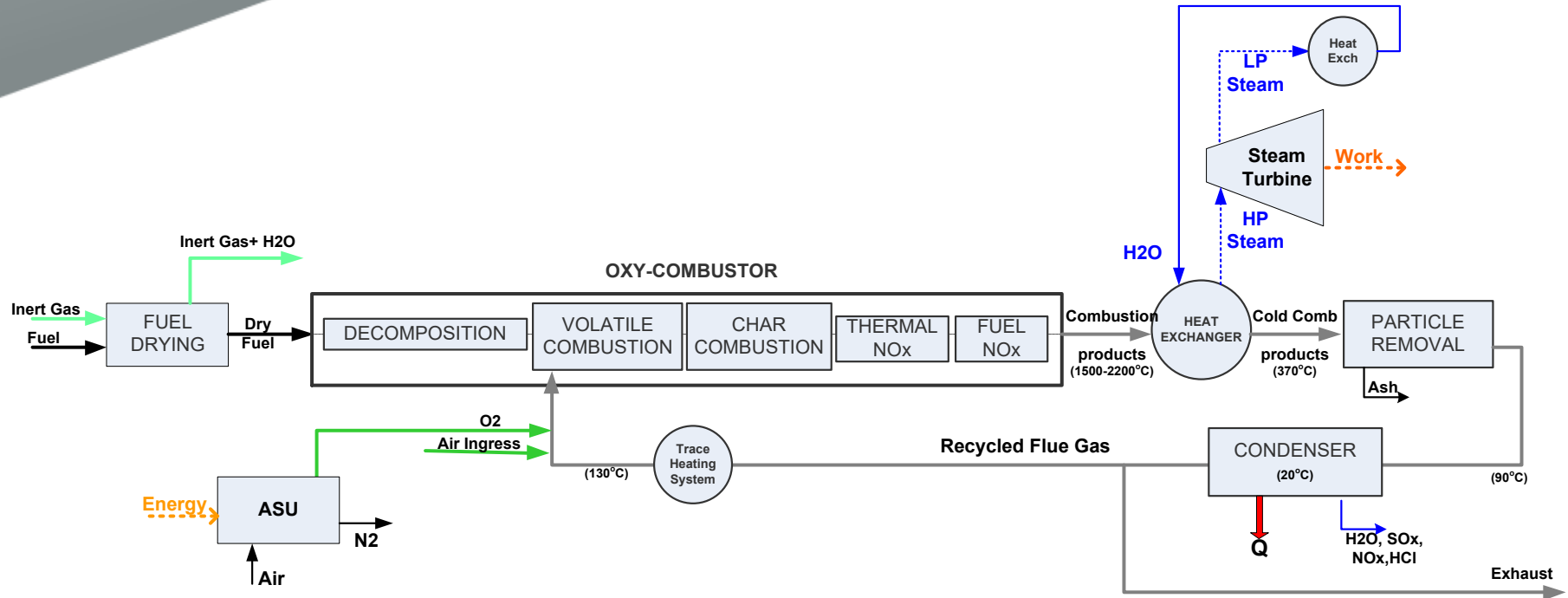


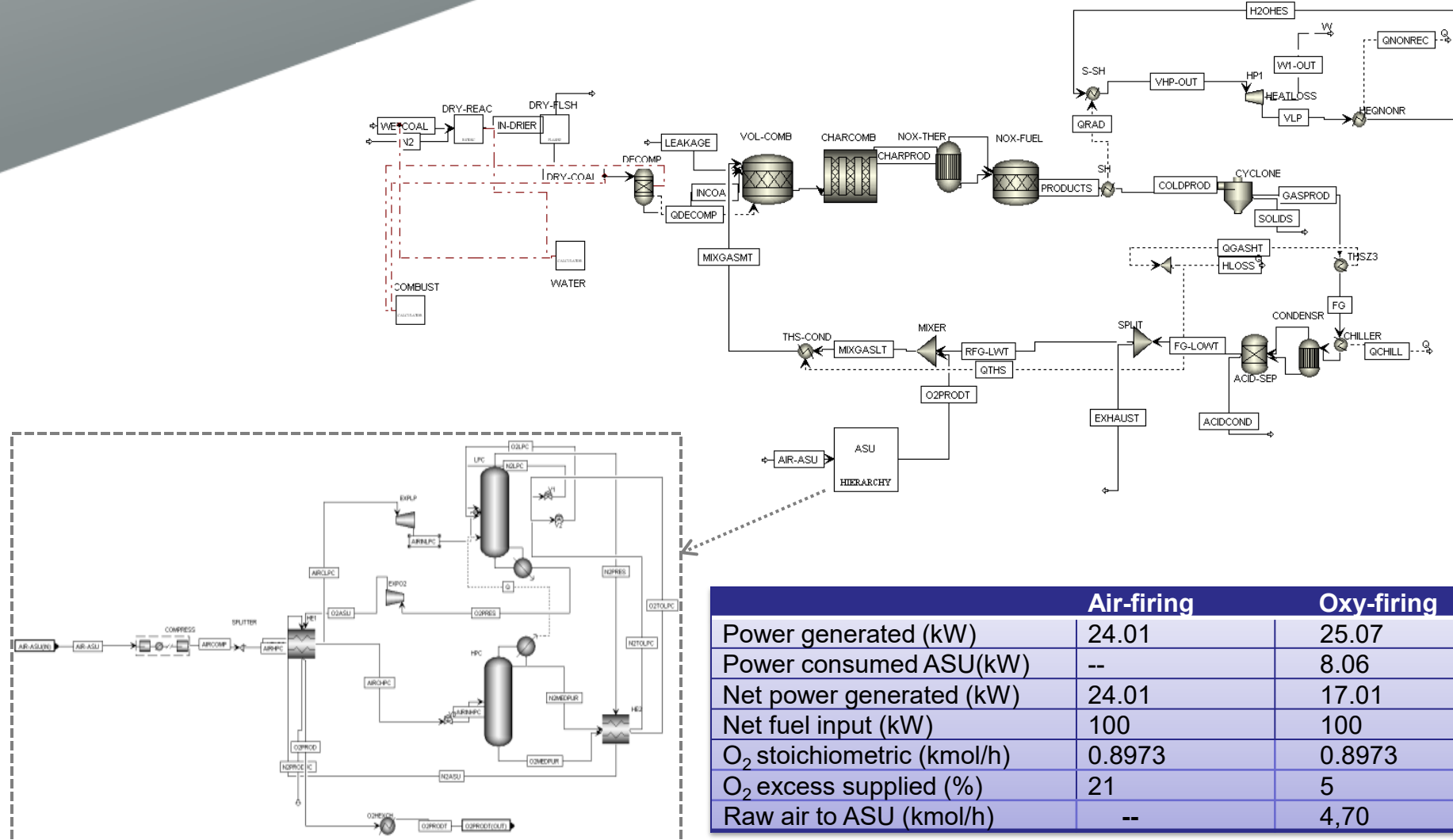
Diagram of 100kWth Oxy-Combustor with Condenser

Simulations: OXY-COMBUSTION PLANT



Box-plot of the ASU, oxy-combustor and steam turbine (Stage 6)

Simulations: OXY-COMBUSTION PLANT



	Air-firing	Oxy-firing
Power generated (kW)	24.01	25.07
Power consumed ASU(kW)	--	8.06
Net power generated (kW)	24.01	17.01
Net fuel input (kW)	100	100
O ₂ stoichiometric (kmol/h)	0.8973	0.8973
O ₂ excess supplied (%)	21	5
Raw air to ASU (kmol/h)	--	4,70

Simulation results for air and oxy-firing base case

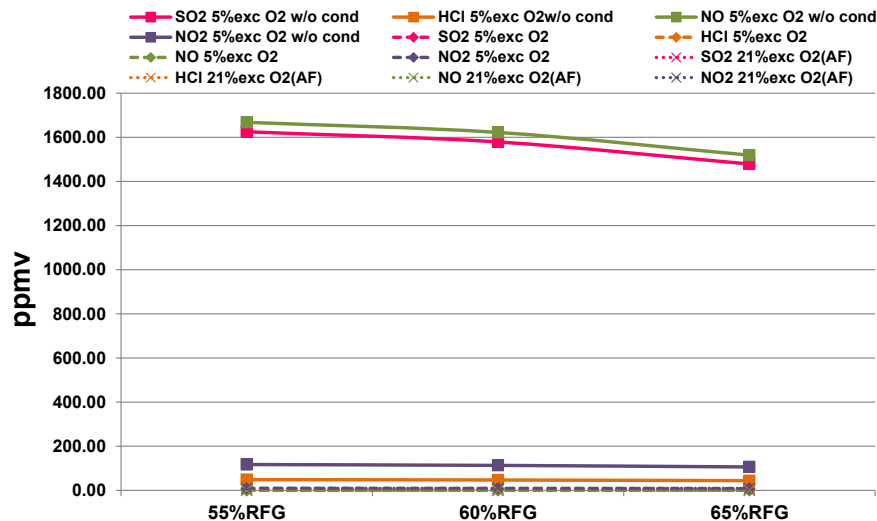
Dry recycle flue gas

EFFECT ON THE EXHAUST

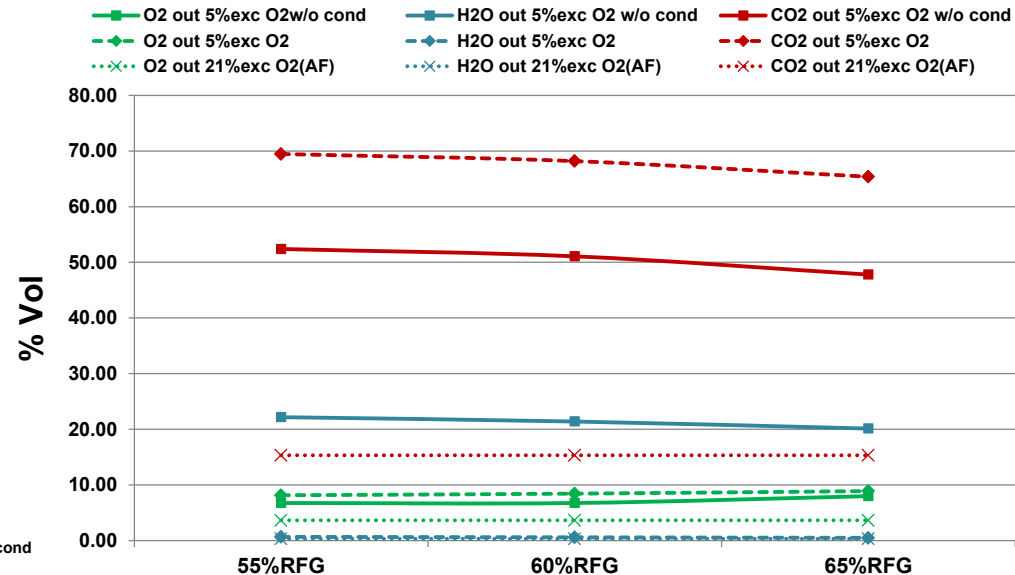
EL CERREJON COAL

- CO₂ increases 20% (v/v) as consequence of implementation of the condenser
- H₂O decreases at the same proportion to the increase of CO₂
- All minor species drop to near zero content in the exhaust gas, in the cases where the condenser was used

EL CERREJON: MINOR SPECIES-Exhaust Gas



EL CERREJON: MAIN SPECIES- Exhaust Gas



	CO ₂ (%)	H ₂ O (%)	O ₂ (%)
El Cerrejon (CC)	15.32	0.32	3.64
El Cerrejon (OC)	68.18	0.58	8.43
El Cerrejon50%-CCP50% (OC)	66.12	0.85	8.54
Cereal Co-Product (OC)	72.46	1.48	3.47

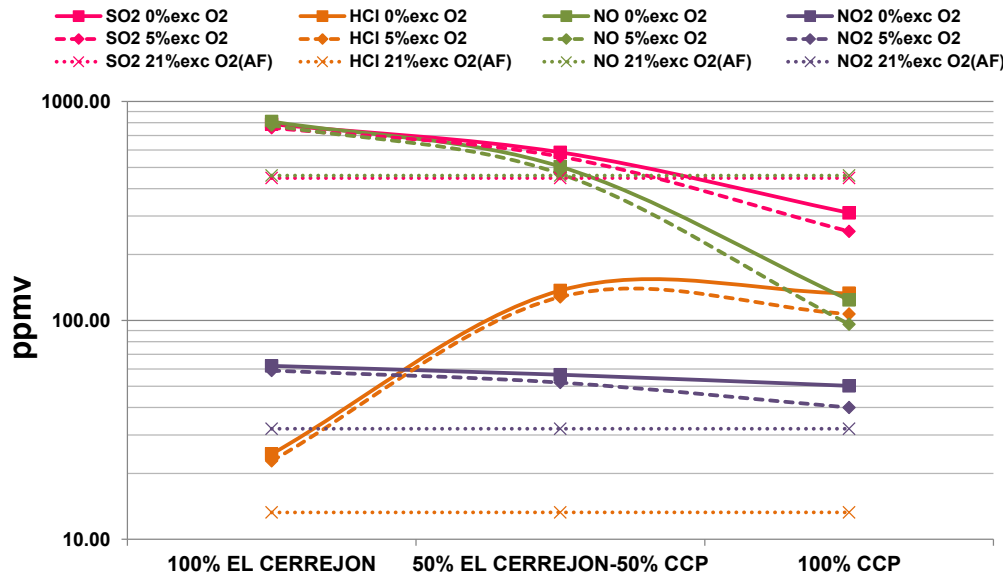
Dry recycle flue gas

EFFECT ON COMBUSTION PRODUCTS

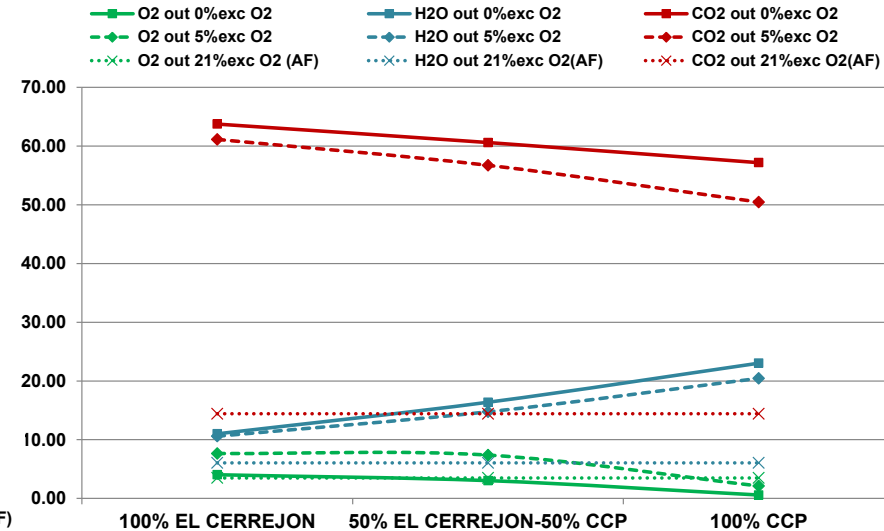
FUEL COMPARISON

- Max. CO₂ decreases in the combustion products with higher content of biomass oxy-fired
- H₂O content when burning CCP increases:
 - By 10% comparing to oxy-firing 100% coal
 - By 14% comparing to air-firing case

MINOR SPECIES-COMB PROD-60%RFG



MAIN SPECIES-COMB PROD-60%RFG



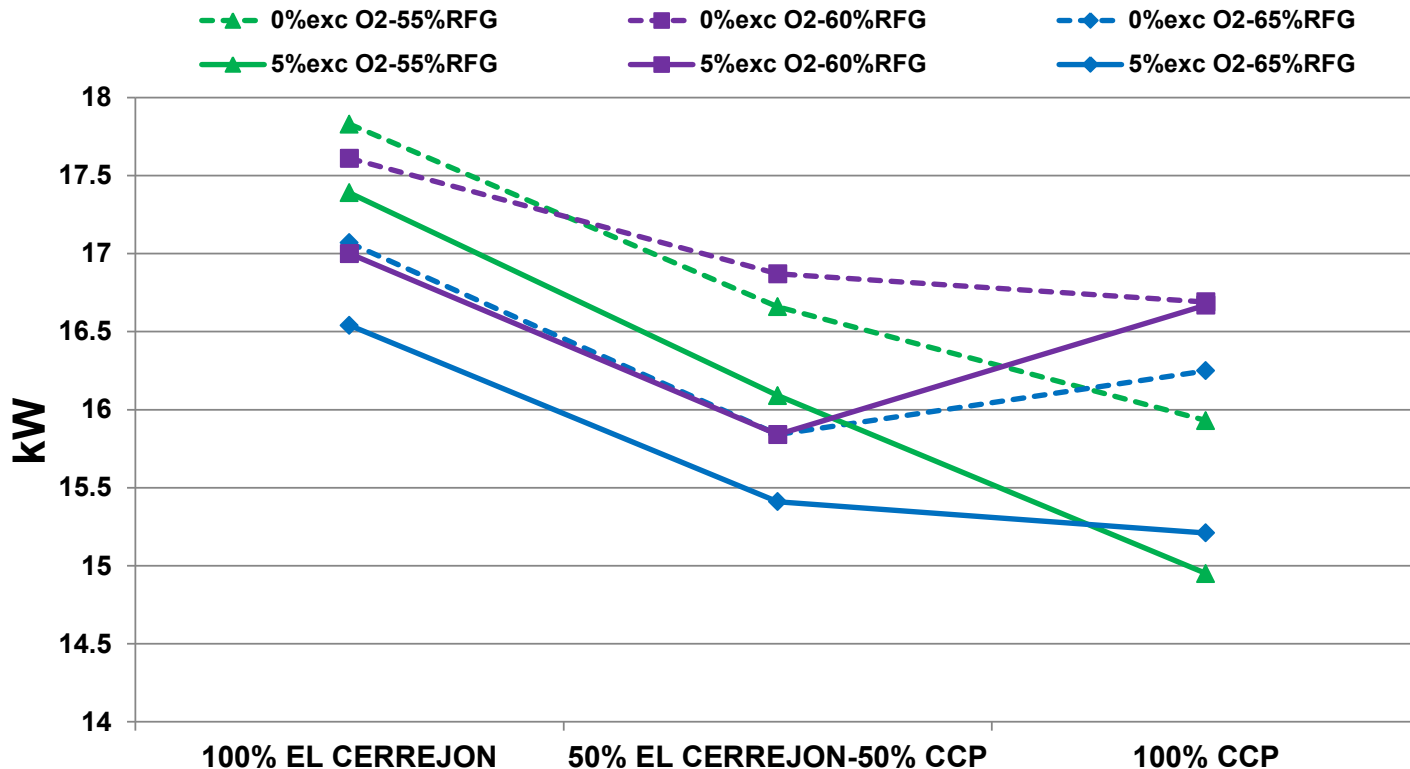
- Marked decrease for SO₂ and NO contents when increasing the percentage of biomass
- Increase in the HCl content as result of the higher content of Cl in the elemental analysis of the biomass (0.17% (w/w) in CCP vs 0.02 % (w/w) El Cerrejon)
- No significant variation for NO₂ contents

Power generation

FUEL COMPARISON

- ✓ Power generated decreases generally with higher content of biomass (exception: 60% RFG and 5%exc O₂)
- ✓ Power generation is enhanced when a lower %RFG is used
- ✓ Higher power levels achieved when burning without excess of oxygen

POWER GENERATION



Summary

- ⊕ Kinetic Simulation Model has been developed with acceptable agreement with experimental results
- ⊕ Model validation has been carried out and helped to deduce the amount of air ingress into the process (10% of the total flue gas fed to the combustor)
- ⊕ Simulation model including equipment for CO₂ purification predicts remarkable increase of the %CO₂ contents
- ⊕ Last step fulfilled for simulations: delivering of kinetic model including dry RFG, ASU, and steam turbine. Study the effects caused by the variation of the fuel and %RFG on the power generated

References

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Thanks for your
attention

Any
questions?

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DSpace

<https://dspace.org/>

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Jurado Pontes, Nelia; Gohari Darabkhani, Hamidreza; Oakey, John

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