

Energy saving and pollution reduction of industrial boiler by using methanol- and isopropanol-contained wastewater emulsified heavy fuel-oil

Sheng-Lan Lin and Wen-Jhy Lee*

*Department of Environmental Engineering,
National Cheng Kung University, Tainan 70101, TAIWAN
wjlee@mail.ncku.edu.tw

Keywords: emulsion, boiler, fuel oil, PM, wastewater.

With the increasing consumption of petroleum fuel, air pollutant emission was considered as a major problem. Boiler is commonly used (over 6000 sets) as a heating device in Taiwan. Three major fuel of boiler are coal, heavy fuel-oil (HFO), and natural gas when HFO is more recently considered in petroleum crisis. The annual HFO consumption in Taiwan during 1991 to 2008 is over 15 mega kiloliter (KL). Unfortunately, the annual carbon dioxide (CO_2) emission, the most considerable green house gas (GHG), from industrial HFO consumption is about 44.3 mega metric ton predicted by CO_2 emission factor of HFO (2.95 metric ton KL^{-1} -HFO) (Shih, 2001). Pollutant emission always comes along with the incompletely combustion. Improving the characteristics of fuel was the most relatively efficient and straight solution than others (optimizing combustion parameters and setting up air pollution control devices, APCDs) to drive more completely combustion and to decrease air pollutant emission. In subsequent years numerous studies were carried out on the water-in-oil (W/O) emulsification been used as an alternative fuel for combustion equipment to approach better fuel economy and less pollutants produced, such as CO , NO_x , SO_x and PM at the same time. Besides, lower combustion peak temperature caused by water quenching phenomenon also reduces the formation of NO_x (Ballester et al., 1996).

Micro-explosion phenomenon plays the most important role of emulsion spray combustion. For the purpose of breaking through the limit of combustion efficiency (5% improvement for general emulsified fuel), this study focuses on the kind and concentration of content in disperse phase of emulsified heavy fuel oil (EHFO) which had little been literature published. And 0 metric tons industrial steam boilers which consume billions liter of heavy fuel-oil (HFO) in Taiwan were the testing unit in this study when methanol- and isopropanol-contained (about 3.5 and 6 %, respectively) wastewater produced by a chemical factory was used as disperse phase to produce wastewater emulsified heavy fuel-oil (WWEHFO). Tap water emulsified heavy fuel-oil (WEHFO) and crude HFO were also tested for comparison. The addition ratio of wastewater was optimized by three temperatures preheating centrifugal stability test. After test, 20% is the feasible ratio for wastewater additive. The emulsion was produced as 20% methanol-contained

wastewater emulsified heavy fuel-oil (WWEHFO). Subsequently, 14-days stability test was held and the W/O droplet size was observed. The results show that WWEHFO has more stable state and smaller W/O droplet size. Finally, the testing fuel (HFO, WEHFO, WWEHFO) were combusted in a 10 metric ton per hour steam capacity industrial boiler as figure 1 shows to test the combustion efficiency.

As the results of boiler test, WWEHFO had a breakthrough energy efficiency improvement about 20% higher than HFO when WEHFO just increased 7%. PM, CO , NO_x and SO_x emission concentration by using WWEHFO decreased 70, 80, 15 and 20%, respectively. The above results were even better than using WEHFO not only in energy efficiency improvement, but also pollutants emission reduction. Consequently, there are several advantages of using WWEHFO as boiler fuel: (1) significantly increasing of boiler efficiency and less fuel consumption; (2) more completely combustion leads to less pollutant, such as PM, CO emission and less sediment in combustion chamber; (3) fuel SO_x emission was reduced by the ratio of (waste) water addition when NO_x was reduced by quenching phenomenon of water content; (4) reuse of wastewater to expand cleaner production and save wastewater treatment cost. Thus, methanol- and isopropanol-contained waste water emulsified heavy fuel-oil was feasible for industrial boilers.

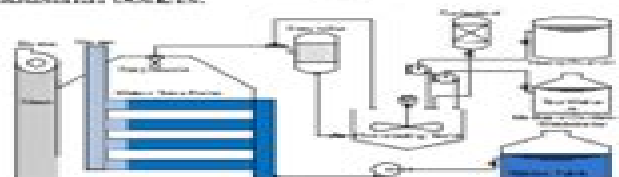


Figure 1. The boiler systems used in this study.

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Nian-Ching Shih (2001), The characteristic analysis of energy consumption and SO_x , NO_x , CO_2 road transportation sector in Taiwan, *Master Degree Thesis*, Department of Environmental Engineering, National Cheng Kung University, R.O.C.

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