

Contents

Preface	xiii
Acknowledgments	xv
1. Introduction to Fuel Blending	1
1.1. Overview	1
1.2. Fuel Blending for Solid Fuels	1
1.2.1. Blending System Considerations	1
1.2.2. Where Blending Can Occur	2
1.3. Objectives for Blending	5
1.3.1. Economic Considerations with Fuel Blending	7
1.3.2. Environmental Considerations with Fuel Blending	8
1.3.3. Historical and Technical Considerations for Fuel Blending	11
1.4. Blending for the Steel Industry—The Development of Petrology	13
1.4.1. Basics of Macerals	14
1.4.2. Petrography Applied to the Steel Industry	15
1.4.3. Conclusions on Blending for the Steel Industry	16
1.5. Typical Fuel Blends	16
1.5.1. Coal–Coal Blends	16
1.5.2. Coal–Biomass Blends	18
1.5.3. Coal–Opportunity Fuel Blends	21
1.6. Blends and Firing Systems	22
1.6.1. Types of Firing Systems	23
1.6.2. Types of Boilers	26
1.7. Conclusions	27
References	27
2. Principles of Solid Fuel Blending	31
2.1. Introduction: Blending for Dollars	31
2.2. Designing the Most Favorable Fuel	32
2.3. Influences on the Most Favorable Fuel Blend	34
2.3.1. Firing Method Considerations	34
2.3.2. Market Considerations	36
2.4. Developing a Fuel Blending Strategy	36
2.4.1. Blend Fuel Considerations	37
2.4.2. Combustion Characteristics of Binary and Ternary Blends	37
2.4.3. Reactivity, Ignition, and Flame Characteristics of Fuel Blends	42

2.5.	Formation of Pollutants	48
2.6.	Fuel Blending Characteristics Influencing Deposition	53
2.7.	Fuel Blending and Corrosion	55
2.8.	Blending's Impact on the Physical Characteristics of Solid Fuels	59
2.9.	Management and Control of Fuel Blending	62
2.10.	Conclusions	66
	References	66
3.	Blending Coal on Coal	71
3.1.	Introduction and Basic Principles	71
3.2.	Blending of Coal for Combustion and/or Gasification Purposes	75
3.3.	Combustion and Gasification Processes	77
3.3.1.	Combustion Processes and Fuel Blending	78
3.3.2.	Coal Blending and the Combustion Process	80
3.3.3.	Gasification Processes	84
3.4.	Coals Used in Commercial Applications and Their Blending Potential	84
3.4.1.	Characteristics of Various Commercially Significant Coals	84
3.4.2.	Relationship of Chemical Composition to Petrography	93
3.4.3.	Chemical Composition and Calorific Value	96
3.5.	Kinetics and the Analysis of Coal Blend Reactivity	97
3.5.1.	Devolatilization Kinetics	97
3.5.2.	Reactivity and Ignition Temperature of Coal Blends	102
3.5.3.	Char Oxidation Kinetics	102
3.6.	The Behavior of Inorganic Constituents	103
3.6.1.	Slagging and Blended Coals	104
3.6.2.	Fouling and Blended Coals	109
3.6.3.	Quantifying the Inorganic Interaction	111
3.7.	Managing the Coal-on-Coal Blending Process	113
3.7.1.	Where Blending Can Occur	113
3.7.2.	Influence of Blending on Materials Handling Issues	115
3.7.3.	How Coal Blends Can Be Managed	116
3.7.4.	Other Considerations	118
3.8.	Conclusions	119
	References	120
4.	Blending Coal with Biomass: Cofiring Biomass with Coal	125
4.1.	Introduction	125
4.2.	Biomass and Coal Blending	125
4.2.1.	Properties of Biomass and Coal	126
4.3.	Cofiring: Reducing a Plant's Carbon Footprint	134
4.3.1.	The Carbon Cycle	135
4.3.2.	The Role of Biomass for Coal-Fired Plants	135

4.4.	Other Reasons for Cofiring	135
4.4.1.	SO ₂ Management	136
4.4.2.	NO _x Management	137
4.5.	Cofiring in the United States and Europe	137
4.6.	Characteristics of Biomass	138
4.6.1.	Types of Biomass	138
4.6.2.	Standard Characteristics of Biofuels	142
4.6.3.	Fuel Porosity and Its Implications	144
4.6.4.	Proximate and Ultimate Analysis and Higher Heating Value	145
4.6.5.	Ash Elemental Analysis	145
4.6.6.	Trace Elements	146
4.7.	Reactivity Measures for Biomass	146
4.7.1.	Reactivity of Combustibles	146
4.7.2.	Structure and Reactivity	148
4.7.3.	Drop Tube Kinetics	149
4.8.	Ratios from Other Measures	152
4.9.	Comparisons of Biomass to Coal	156
4.9.1.	Central Appalachian Bituminous Coal	156
4.9.2.	Illinois Basin Coal	156
4.9.3.	Powder River Basin Coal	156
4.9.4.	Lignite	157
4.10.	The Chemistry of Cofiring	157
4.10.1.	Reactivity and Cofiring	157
4.10.2.	Evolution of Specific Elements and Compounds	160
4.11.	Burning Profiles of Biomass–Coal Blends	161
4.12.	Implications for Biomass–Coal Cofiring Systems	169
4.12.1.	Biomass–Coal Blend Issues	171
4.12.2.	Biomass–Coal Blend Systems	173
4.12.3.	Cofiring Methods and Equipment—Mechanical Systems	176
4.13.	Case Studies in Cofiring	178
4.13.1.	Cofiring Experiences	178
4.14.	Conclusions	195
	References	195
5.	Waste Fuel–Coal Blending	201
5.1.	Introduction	201
5.2.	Tire-Derived Fuel	201
5.2.1.	Overview	201
5.2.2.	Typical Composition	202
5.2.3.	Physical Characteristics	204
5.2.4.	Types of Tire-Derived Fuel	205
5.2.5.	Preparation and Handling Issues	205
5.2.6.	Combustion Considerations	210
5.2.7.	Case Studies	210
5.2.8.	Conclusions Regarding Tire-Derived Fuel as a Blend Fuel	215

5.3. Petroleum Coke	216
5.3.1. Fuel Characteristics of Petroleum Coke	218
5.3.2. Petroleum Coke Issues	219
5.3.3. Petroleum Coke Utilization in Boilers	221
5.3.4. Petroleum Coke Utilization in Other Systems	230
5.4. Waste Plastics and Paper	232
5.4.1. Waste Plastic Composition	233
5.4.2. Waste Plastic and Paper Preparation	235
5.4.3. Waste Plastic Utilization	237
5.5. Hazardous Wastes	238
5.5.1. Fuel Characteristics of Hazardous Wastes	238
5.5.2. Combustion of Hazardous Wastes in Rotary Kilns	239
5.5.3. Waste Oil Utilization	241
5.6. Conclusions	243
References	244
6. Environmental Aspects of Fuel Blending	249
6.1. Introduction	249
6.2. Regulatory Climate as It Influences Blending and Cofiring	249
6.3. Blending for Environmental and Economic Reasons	250
6.4. Areas of Concern	250
6.4.1. Particulates	250
6.4.2. Sulfur Dioxide	251
6.4.3. Nitrogen Oxides	251
6.4.4. Mercury	251
6.4.5. Fossil CO ₂	252
6.5. Ash Management for Power Plants	252
6.5.1. Bottom Ash	252
6.5.2. Flyash	252
6.6. Blending for Emission Benefits	253
6.6.1. Blending PRB Coal with Other Solid Fuels	253
6.6.2. Emission Aspects	254
6.6.3. Selected Case Studies	258
6.7. Cofiring Biomass with Coal	260
6.7.1. Emission Aspects	260
6.7.2. Cofiring in Europe	262
6.7.3. Selected Case Studies	262
6.7.4. Cofiring with Waste	264
6.7.5. Emission Aspects	264
6.7.6. Selected Case Studies	266
6.8. Conclusions	267
References	268
7. Modeling and Fuel Blending	271
7.1. Introduction	271
7.2. The Purposes of Modeling	272

7.3. Specific Applications of Modeling	272
7.3.1. Modeling to Reduce the Use of Physical Tests and Costs	273
7.3.2. Methods of Modeling	274
7.4. Principles of Physical Modeling	280
7.4.1. Some Applications of Physical Modeling	282
7.4.2. Computational Fluid Dynamics Modeling	283
7.5. The Basic Approach of Computational Fluid Dynamics Modeling	284
7.5.1. Computational Fluid Dynamics Modeling of Combustion Processes	285
7.5.2. Products of Combustion Modeling	288
7.5.3. Other Applications of Computational Fluid Dynamics Modeling	290
7.6. Modeling for Blending Purposes	290
7.6.1. The Traditional Approach to Blending Analysis	290
7.6.2. The Detailed Analytical Approach to Blending	291
7.7. Limitations of Modeling	291
7.8. Conclusions	291
References	292
8. Institutional Issues Associated with Coal Blending	295
8.1. Introduction	295
8.2. Institutional Issues Associated with Fuel Blending	297
8.3. Economic Considerations Associated with Blending	300
8.3.1. Fuels Availability	300
8.3.2. Fuel Procurement	304
8.3.3. Fuel Transportation	305
8.4. Process Modifications	309
8.4.1. Coal Handling and Storage	309
8.4.2. Coal Blending	310
8.4.3. Pulverizer Performance	310
8.4.4. Furnace Effects	311
8.4.5. Convective Pass	312
8.4.6. Emissions	312
8.5. Future U.S. and World Coal Production	313
8.6. Conclusions	320
References	320
Index	323