

1987 INTERNATIONAL
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FLUIDIZED BED
COMBUSTION

Vol. 1

Proceedings of the



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FBC COMES OF AGE

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edited by

JOHN P. MUSTONEN



THE AMERICAN SOCIETY OF MECHANICAL ENGINEERS
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FOREWORD

The Ninth International Conference on Fluidized Bed Combustion is intended to promote the exchange of technical, economic and scientific information pertaining to all aspects of fluidized bed combustion (FBC) in support of increasing applications and scale-up of this technology for the clean and economical combustion of coal and other fuels.

The theme of the conference is "FBC Comes of Age" and the many technical papers included in these proceedings report on a number of significant developments which have occurred since the last International FBC Conference (March 1985) bringing FBC technology closer to full commercialization.

The proceedings include approximately 180 papers presented formally or in poster session addressing the following general subjects:

AFBC AND PFBC Applications

Fuels

Sorbents

R&D Fundamentals

FBC Plant Components

Environmental

Advanced Concepts

The Conference is sponsored and coordinated this year for the first time by the American Society of Mechanical Engineers, Advanced Energy System and Division which has assumed this responsibility from the U.S. Department of Energy. Co-sponsoring the Conference, as in recent years, are the Electric Power Research Institute and the Tennessee Valley Authority, in cooperation with American Institute of Chemical Engineers, the Council of Industrial Boiler Owners, and the U.S. Department of Energy.

Our appreciation is extended to J.W. Byam, U.S. Department of Energy, who was Chairman of the Eighth International Conference on Fluidized Bed Combustion held in March, 1985. Mr. Byam provided enthusiastic support and benefit of his prior experience to the organizers of the Ninth International and generally eased the primary conference sponsorship responsibility transition from the U.S. Department of Energy to the American Society of Mechanical Engineers.

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The nine Topic Coordinators arranged the actual sessions and coordinated the review of the technical papers within their topical areas. Our appreciation is extended to them as follows:

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And a most special thanks to A.M. Manaker who in addition to his role as a Topic Coordinator, also devoted endless hours of work as the Secretary of the Steering Committee and organized all of the sessions into a cohesive conference technical program.

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In addition to chairing the various technical sessions of the conference, the task of reviewing all of the technical papers was shared by the Session Co-Chairman with the assistance of the papers review coordinator, G. Weth, U.S. Department of Energy. Our appreciation is extended to:

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CONTENTS

ATMOSPHERIC FLUIDIZED BED APPLICATIONS

Design, Performance and Cost of Atmospheric Fluidized Bed Combustion Power Plants <i>C. R. McGowin, S. Tavoulaareas, and W. C. Howe</i>	1 Vol. 1
Evaluation and Design Process Leading to Selection of Fluidized Bed Combustion Boilers for A.E. Staley Cogeneration Facility <i>J. W. Davison, R. J. Thompson, and G. L. Gould</i>	12
Comparison of Bubbling and Circulating Fluidized Bed Industrial Steam Generation <i>B. N. Gaglia and A. Hall</i>	18
The Modular Modeling System (MMS) Code Applied to a Circulating Fluidized Bed Demonstration Plant Project <i>D. S. Weber, D. M. Dimenstein, W. Howe, and S. Tavoulaareas</i>	26
Guidelines for Specifying AFBC Boilers for Utility Applications <i>W. C. Howe</i>	33
Technical Assessment on the Ahlstrom Pyroflow Circulating and Conventional Bubbling Fluidized Bed Combustion Systems <i>J. T. Tang and F. Engstrom</i>	38
Market Potential for Small Coal-Fired Fluidized-Bed Combustion Boilers <i>H. Feibus, P. Muchunas, and J. Shang</i>	55
Design and Operation of the 115 T/H FBC-Boiler for AKZO-Holland <i>F. Verhoef</i>	61
The Lardet-Babcock/Cerchar 2.5 MWth Package Fluidized Bed Boiler <i>G. Marlair, R. Puff, V. Vernotte, A. Petrovic, and J. -P. Barriere</i>	70
Fluidized Bed Retrofit Potentials in Yugoslavia <i>I. S. Jugoinspekt and T. Stringfellow</i>	76
The Pyroflow Boiler at BFGoodrich Company – The First Eighteen Months of Steaming, Henry, Illinois <i>B. Hutchinson</i>	85
Circulating Fluidized Bed Combustion Via Multi-Solid Fluidized Beds (MSFB) in the Industrial Sector <i>W. J. Place</i>	91
Design of the Scott Paper CFB <i>S. L. Darling, H. Lienhard, J. M. Dougherty, and E. Liu</i>	99
Advanced Circulating Fluidized Bed Boiler <i>J. A. Garcia-Mallol, V. Seshamani, and M. G. Alliston</i>	103
The NSP Reference Plant Concept Using Fluidized Bed Combustors <i>R. J. Jensen and A. E. Swanson</i>	109
Feasibility of Circulating Fluid Bed Design for Utility Boiler Retrofit <i>G. C. Stegmann, R. J. Zychal, and D. Gandhi</i>	112
80MW Fluidized Bed Retrofit for Montana-Dakota Utilities Company – What Changed? What Didn't? <i>R. L. Correll, T. J. Haynes, and D. L. Knighton</i>	120
Utility Applications of AFBC <i>J. W. Regan and H. Beisswenger</i>	125
Overview of the AFBC Demonstration Projects <i>M. M. DeLong, K. J. Heinschel, C. C. Lawrence III, and A. M. Manaker</i>	132
Electric Utilities' Largest Circulating Fluidized Bed Boiler – Construction Update <i>A. H. Gregory</i>	140
Overview of the Utility Development of AFBC Technology Tennessee Valley Authority (TVA) <i>J. W. Bass III, J. L. Golden, B. M. Long, R. L. Lumpkin, Jr., and A. M. Manaker</i>	146
Startup Activities at the Black Dog AFBC Conversion <i>R. E. Follett, M. Friedman, D. Parham, W. J. Larva</i>	153

Development of Studsvik CFB From Prototype to Commercial Status <i>H. Kobro and M. Morris</i>	161	Vol. 1
Colorado Ute Electric Association CFB Test Program <i>T. J. Boyd, W. C. Howe, and M. A. Friedman</i>	168	
Demonstration Test Program of the 50-MWe AFBC Boiler in Japan <i>Y. Nakabayashi</i>	177	
AFBC Retrofit at Black Dog: A Project Overview <i>G. M. Goblirsch, T. L. Weisbecker, and S. M. Rosendahl</i>	185	
PRESSURIZED FLUIDIZED BED APPLICATIONS		
Coal-Water Mixture Testing in the Grimethorpe PFB Test Facility <i>J. W. Byam, Jr. and S. J. Wright</i>	191	
PFBC Design Integration – ASEA Babcock PFBC’s Approach <i>D. K. McDonald, P. S. Weitzel, and P. Thornblad</i>	200	
Analysis of Abnormal Operating Conditions for the Turbocharged PFBC-Boiler of RWTH Aachen <i>G. H. Dibelius, R. Croonenbrock, R. U. Pitt, and H. K. Rauhut</i>	208	
Part-Load Operation of Pressurised Fluidised Bed Combustors: A Review <i>H. R. Hoy, A. G. Roberts, G. A. Sparham, J. E. Stantan, D. M. Wilkins, and J. D. McClung</i>	217	
Experimental Investigations on NIT PFBC Test Facility for High Ash Coal <i>Fan Congzhen, Lin Aiming, Yao Weiwen, Liu Qianxin, Zhang Mingyao, Tang Chuming, Shen Yiangln, Zhao Yiyu, Li Fuan, Jiang Shouguo, Tang Huifen, Chen Xiangyong, Xu Yuenian, and Yao Zhibiao</i>	226	
Operating Experience in a Sub-Pilot Scale Pressurized Fluidized-Bed Combustor <i>H. Clisset, K. M. Sellakumar, P. K. Gounder, A. Ganesh, V. Zakkay, and J. D. McClung</i>	233	
An Up-Date on Test Experience From the ASEA PFBC Component Test Facility <i>S. A. Jansson</i>	242	
The Pressurized Fluidized Bed Combustor at Aachen Technical University <i>G. von Wedel, U. Renz, S. Michelfelder, and H. Steven</i>	250	
TIDD PFBC Demonstration Plant: Combined Cycle PFBC Clean Coal Technology <i>M. J. Mudd and D. A. Bauer</i>	256	
The PFBC Plant in Vartan, Stockholm <i>P. Almqvist</i>	261	
The Escatron PFBC Project <i>K. K. Pillai, J. Rubio, and J. Tome</i>	266	
Design Concept for a PFBC Commercial Plant <i>J. B. Hury, B. Wickstrom, and B. Rederstorff</i>	272	
Spain Takes to Pressurized Fluid Bed Combustion: A View to ENDESA’s 80 MW Demonstration Plant <i>E. Menendez, V. Bencomo, and M. A. Cuenca</i>	278	
FUELS		
Bed Agglomeration and Ash Disposal for Anthracite-Fired Fluidized-Bed Combustors <i>P. L. Rozelle and A. W. Scaroni</i>	284	
A New Method for AFBC Fuels Characterization <i>R. R. Chandran, J. N. Duqum, M. A. Perna, H. C. Jafari, D. R. Rowley, E. M. Petrill, and W. A. Hansen</i>	292	
A Performance Code for AFBC Scale-Up: Part I: In-Bed Combustion <i>R. R. Chandran, J. N. Duqum, and E. M. Petrill</i>	300	
Influence of Fuel Reactivity on the Fluidized Combustion of Chars <i>N. O. Lemcoff</i>	307	
Combustion Performance, Sulphur Capture and Vanadium Balance Trials With Syncrude Petroleum Coke in a Circulating Fluidized Bed Combustor <i>D. L. Desai, F. Engstrom, W. B. Alderton, S. H. Vayda, C. E. Wood, and F. D. Friedrich</i>	312	

Bubbling Fluidized Bed Combustion of Syncrude Coke <i>E. J. Anthony, H. A. Becker, R. K. Code, R. W. McCleave, and J. R. Stephenson</i>	322	Vol. 1
Western U.S. Coal Performance in a Pilot-Scale Fluidized Bed Combustor <i>B. J. Zobeck, M. D. Mann, D. R. Hajicek, and R. J. Kadrmas</i>	330	
Circulating Fluidized Bed Combustion of Different Ranking Coals With Limestone Sorbents <i>P. F. Salib, S. K. Barua, K. R. Robson, and R. K. Kissell</i>	340	
Sulfur Retention by Mineral Matter in Lignite During Fluidized Bed Combustion <i>A. T. Yeh, Y. Y. Lee, and W. E. Genetti</i>	345	
Special Plant Features and Their Effect on Combustion of Waste Coals in a Fluidized-Bed Combustor <i>C. M. Eleftheriades and B. North</i>	353	
Belgian Industrial Experience in Power Generation From Coal Mine Waste <i>J. E. Hulsboch, A. J. Maufort, and A. F. Scailteur</i>	360	
Development and Pilot Plant Experience of Fluidized Bed Chemical Recovery Boiler <i>Y. Takeshita, H. Itoh, C. Nagai, and M. Nakura</i>	368	
Operational Experience With a Fluidized Bed Boiler Burning Waste Material <i>O. J. Geisler, F. Heinrich, and U. Urban</i>	378	
Design and Construction of a Wood-Fired Circulating Fluidized Bed Boiler <i>R. F. Johns and R. E. Wascher</i>	385	
A 10 MWe Fluidized Bed Power Plant for Paddy Straw <i>S. Rajaram and K. T. U. Malliah</i>	392	
Study on Fluidized Bed Combustion of Washery Tailings in an Industrial-Scale Boiler <i>Cen Kefa, Ni Mingliang, Yang Jialin, Tao Tao, Huang Guoquan, Xiang Qian, Luo Zhongyang, and Yao Dan</i>	398	
Fuel Evaluation and Operating Experiences of Babcock Hitachi Multiple Fuel Fluidized Bed Boiler in Japan <i>S. Kawada, T. Shikata, K. Oki, N. Takamoto, K. Fujiwara, S. Takada, Y. Takahashi, and N. Fujiwara</i>	405	
Modelling the Combustion of Coal-Water-Paste in a Pressurised Fluidised Bed Coal Combustor <i>K. K. Pillai and M. C. Andersson</i>	415	
Operating Experience in Fluidized Bed Boilers With Deep/Shallow Bed in Korea <i>Jae Soo Cho and Sang Kyu Lee</i>	424	
Coal Water Mixture vs. Dry Coal Feed Effect on Pressurized FBC Plant Performance and Economics <i>L. N. Rubow, M. Borden, T. L. Buchanan, and B. Nick Gaglia</i>	430	
FBCBAL and the Fuels Flexibility Database: Tools for Utility Decision Makers <i>R. J. Divilio and E. M. Petrill</i>	437	
Measures of Improving Combustion Efficiency of Fluidized Bed Combustion Boilers <i>Liu Dechang, Lin Zhijie, Liu Huancai, Zhu Cemin, Wu Waiheng, and Huang Wendi</i>	443	
Design and Operation of a Fluidized Bed Boiler Fired With Olive Pits <i>G. F. Heath and M. R. Carroll</i>	446	

SORBENTS

Limestone Calcination and Sulfation Microstructure, Porosity and Kinetics Under AFBC Environments <i>H. T. Kim, J. M. Stencel, and J. R. Byrd</i>	449
Evaluation of SO ₂ Sorbents in a Fluidized-Bed Reactor <i>C. A. Hamer</i>	458
A Chemical Reaction Model of Porous CaO Particles and SO ₂ Gas, When the Intergrain Gas Diffusion Controls the Overall Rate <i>P. T. Daniell and H. O. Kono</i>	467
AFBC Pilot Plant Test of Six Kentucky Limestones <i>L. S. Barron, J. C. Z. Wang, J. L. Schaefer, T. M. Jones, J. R. Hasler, D. J. Collins, and T. L. Robl</i>	474
Evaluation of the Properties of Natural Sorbents for Fluidized-Bed Combustion <i>M. Z. Haji-Sulaiman and A. W. Scaroni</i>	481

Sulfation Characteristics of Twelve Canadian Limestones <i>M. F. Couturier, H. A. Becker, and R. K. Code</i>	487	Vol. 1
Model Predictions of Combustion and Sulfur Capture Processes in AFBC <i>J. L. Hodges, G. D. Jukkola, and P. P. Kantasaria</i>	494	
Review of Methods for Characterizing Sorbents for AFBCs <i>D. Celentano, P. Estey, J. Stallings, and E. Petrill</i>	501	

RESEARCH AND DEVELOPMENT

Scaling the Hydrodynamics of Fluidized Bed Combustors With Cold Models: Experimental Confirmation <i>L. R. Glicksman, T. Yule, A. Dyrness, and R. Carson</i>	511	
Influence of Immersed Heat Exchange Surfaces on Fluid Mechanics and Solids Mixing in Fluidized Beds <i>J. Werther, D. Bellgardt, H. Groenewald, and K. Hillgardt</i>	515	
Fluid Dynamics and Elutriation of Circulating Fluidised Beds <i>Qinghang Jian and Cen Kefa</i>	523	
Experimental Research on Hydrodynamical Properties of Circulating Fluidized Bed <i>Cen Kefa, Luo Zhongyang, Ni Mingjing</i>	529	
Particle Elutriation in Fluidized Bed Combustors <i>J. E. Son and J. H. Choi</i>	535	
Lateral Solid and Thermal Dispersion in Fluidized Bed Combustors <i>T. F. Salam, Y. Ren, and B. M. Gibbs</i>	541	
Lateral Dispersion of Large Coal Particles in an Industrial-Scale Fluidised Bed Combustor <i>Xiang Qian, Huang Guoquan, Ni Mingjiang, Cen Kefa, and Tao Tao</i>	546	
The Effect of Bed Material on in Bed Heat Transfer and the Design and Operation of Bed Management Systems to Control Bed Inventory <i>R. K. Chakraborty, R. L. Dando, C. Foster, and M. A. Vickers</i>	554	
Pulsation Phenomena in Fluidized Bed Boilers <i>W. J. G. Little</i>	561	
Dynamic Forces on Tubes Immersed in Bubbling AFBC <i>R. Q. Vincent, D. E. Hart, and W. F. Siddall</i>	567	
Measurements of the Bubble Behaviour and the Oxygen Distribution in a Pilot Scale Pressurized Fluidized Bed Burning Coal <i>A. -E. Almstedt and E. B. Ljungstrom</i>	575	
Fluidization Characteristics and Elutriation in a Fluidized Bed With a Concave Distributor <i>Zhao Changsui, Lu Yong, Yao Weiwen, and Fan Congzhen</i>	586	
Heat Flow Measurements in Fluidized Bed Boilers <i>B. -A. Andersson, F. Johnsson, and B. Leckner</i>	592	
In-Bed Tube Bundle Testing <i>W. R. Carson, J. M. Castleman III, and L. R. Glicksman</i>	599	
A Predictive Model for the Freeboard Performance in a Fluidized Bed Combustor Operating in the Bubbling Mode <i>V. B. Dixit, M. L. Holmes, and W. R. Carson</i>	604	
Some Aspects of Hydrodynamics, Heat Transfer and Gas Combustion in Circulating Fluidized Beds <i>A. Feugier, C. Gaulier, G. Martin</i>	613	
Heat Transfer Characteristics of the FBC at Aachen Technical University <i>U. Renz, G. von Wedel, and A. Reinartz</i>	619	
Heat Transfer to Submerged Tubes in Pressurized Gas/Solid Fluidized Beds <i>O. Molerus and J. Schweinzer</i>	624	
Materials and Component Performance in the TVA 20 MW AFBC Pilot Plant <i>V. K. Sethi, R. Q. Vincent, D. R. Wilson, E. Puentes, and R. G. Corey</i>	629	Vol. 2
The Erosion-Corrosion of Heat Exchanger Tubes in Fluidized Bed Combustors <i>A. V. Levy, Man Yong-Fa, and N. Jee</i>	637	

The Role of Carburization in the In-Bed Corrosion of Alloys in FBC <i>Jia-Sheng Lin, D. A. Stevenson, and J. Stringer</i>	656
Corrosion/Erosion Resulting From the Fluidized Bed Combustion of Low-Rank Coals <i>D. R. Hajicek, D. P. Kalmanovitch, M. D. Mann, and R. J. Kadrmas</i>	663
Erosion Experience of the TVA 20-MW AFBC Boiler <i>R. Q. Vincent, J. M. Poston, and B. F. Smith</i>	672
Current Information on Metal Wastage in Fluidized Bed Combustors <i>J. Stringer</i>	685
Erosion Calculations in a Two-Dimensional Fluidized Bed <i>R. W. Lyczkowski, J. X. Bouillard, G. F. Berry, and D. Gidaspow.</i>	697
Measurement of the Temperature of Burning Particles in Fluidized Beds <i>R. D. La Nauze, K. Jung, D.C. Dent, J.T. Dent, P.J. Tait, and J.M. Burgess</i>	707
Modeling of Large Scale Atmospheric Fluidized Bed Combustors <i>D. Bellgardt, F. Hembach, M. Schoessler, and J. Werthe</i>	713
Combustion Behavior and Elutriation Phenomena in Two Pre-Pilot Units Fired With the Same Coal <i>U. Arena, F. J. A. Martens, and M. Miccio</i>	723
A Mathematical Model for Coal Combustion in Pressurized Fluidized Beds <i>Zhang Mingyao, Jin Baosheng, and Fan Congzhen</i>	730
A Simplified Model for Combustion of Carbon in a Circulating Fluidized Bed Combustor <i>P. Basu, A. Sett, and E. A. M. Gbordzoe</i>	738
Chemical Equilibrium Relationships Applicable in Fluid Bed Combustion <i>H. E. Barner, H. Beisswenger, and K. E. Barner</i>	743
The D. U. T. -SURE-model: A Simple Approach in FBC Sulfur Retention Modeling <i>J. C. Schouten and C. M. van den Bleek</i>	749
Analysis of a Circulating Fluidized Bed System <i>U. Arena, L. Massimilla, and D. Pirozzi</i>	762
Theoretical Modeling of the Multi-Solids Fluidized Bed Combustor: Hydrodynamics, Combustion, and Desulfurization <i>R. W. Breault</i>	770
Experimental Dynamic Modeling of a (P)FBC <i>H. M. P. van der Looij</i>	776
Effect of Staged Combustion of Coal on Emission Levels of NO _x and SO ₂ in a Fluidised Bed <i>M. Valk, E. A. Bramer, and H. H. J. Toissant</i>	784
Alkali Measurement in PFBC and Its Control by a Granular Bed of Activated Bauxite <i>S. H. D. Lee and K. M. Myles.</i>	793
COMPONENTS	
Materials for FBC Air Heater Applications <i>K. Natesan, S. A. Miller, and W. F. Podolski</i>	802
Characterisation of Low Chromium Ferritic Steels for Use in Fluidised Bed Combustion Systems <i>A. J. Minchener, D. M. Lloyd, and J. Stringer</i>	812
Aerodynamic Characteristics of an Air Distributor With Direction Plates of Fluidized Bed Boiler <i>Liu Dechang, Zhu Cemin, Lin Zhijie, Liu Huancai, Wu Wieheng</i>	820
Development of a CFB Reactor With a Horizontal Cyclone <i>S. Ruottu, P. Sarkomaa, and R. Tammilehto.</i>	824
PFBC Materials Related Component Performance Evaluation <i>A. J. Minchener, J. Stringer, D. M. Wilkins, E. Carls, W. M. Swift, and J. S. Anderson</i>	834
DAWID-Saar: A Neat, Intra-City, Coal-Based Cogeneration Plant With Pressurized Fluidized Bed Steam Generator <i>W. Leonhardt, and F. Heinrich.</i>	846
TVA 160-MW Demonstration Plant Flowability Studies <i>T. W. Lee and H. H. Vroom.</i>	854

Development of the Seal Leg Char Recycle System <i>M. K. Hill, R. G. Mallory, and R. R. McKinsey</i>	862	Vol. 2
Coal Drying Using Cyclone Ash for Commercial AFBC Units <i>M. K. Hill, K. D. Anderson, R. R. McKinsey</i>	867	
Investigation of Spent Bed Material Coolers for Atmospheric Fluidized Bed Combustion Boilers <i>M. W. Milligan Jr., B. C. Teigen, and H. J. Wilkerson</i>	873	
Integrated Waste Handling System for TVA'S 160-MW Atmospheric Fluidized Bed Combustion Plant <i>R. G. Reynolds</i>	880	
The Venturi Type Fly Ash Flow Meter <i>J. Golabek</i>	884	

ENVIRONMENTAL ISSUES

Emissions From a Circulating and a Stationary Fluidized Bed Boiler — A Comparison <i>B. Leckner and L. -E. Amand</i>	891
Nitric Oxide Emission From Circulating Fluidized-Bed Coal Combustion <i>T. Hiram, H. Takeuchi, and M. Horio</i>	898
Trace Element Emissions From AFBC <i>I. S. C. Hughes and R. F. Littlejohn</i>	906
EPRI's Research on AFBC By-Product Management <i>S. Tavoulares, W. Howe, D. Golden, and G. Eklund</i>	916
Shawnee AFBC Demonstration Project Ash Utilization Program <i>J. L. Harness, Yung C. Chung, and D. A. Mays</i>	927
The Disposal and Utilisation of AFBC Residues <i>C. E. Carr and T. W. Price</i>	935
Production of No-Cement Concretes Utilizing Fluid Bed Combustion Waste and Power Plant Flyash <i>A. E. Bland, C. E. Jones, J. G. Rose, and M. N. Jarrett</i>	947
Leaching Studies of Solid Wastes Generated From Fluidized Bed Combustion of Low-Rank Western Coals <i>K. R. Henke, B. J. Zobeck, C. J. Moretti, and M. D. Mann</i>	954
Characterization of the Precipitation Runoff From the Combustion Residue Disposal Area at the TVA 20-MW AFBC Pilot Plant <i>K. D. Eisele, R. G. Mallory, and J. B. Brellenthin</i>	960
Disposal of Multiclone and Baghouse Catch at TVA's 20-MW AFBC Pilot Plant <i>C. E. Bazzell, R. G. Mallory, and M. W. Milligan, Jr.</i>	967
Further Particulate Control Experience After Fluidized Bed Boilers <i>S. Maartmann and K. Bradburn</i>	974
Electrostatic Precipitation Test Program at TVA's 20-MW AFBC Pilot Plant <i>W. R. Carson, W. C. Nobles, M. H. Anderson, Jr., and T.J. Boyd</i>	977
Hot Gas Cleanup Research on the Delft Pressurised Fluidised Bed Combustion Test Facility <i>J. Andries</i>	983
Process Design and Proposed Test Programme for a Filter Unit Operating in the Off-Gas Path of a Pressurised Fluidised Bed Combustor <i>C. Birkby, J. M. Wheeldon, O. J. Tassicker, and G. P. Reed</i>	993
Study of Ceramic Filter Elements for PFBC Hot Gas Cleanup <i>H. -P. Schiffer, U. Renz, O. J. Tassicker, and E. K. Reinhardt</i>	1000
Pilot Scale Development of Ceramic Filters for PFBC Power Plants <i>S. G. Drenker, J. S. Stringer, and O. J. Tassicker</i>	1008

ADVANCED CONCEPTS

Key Components for a High-Efficiency Second-Generation Pressurized Fluidized Bed Combustion Combined Cycle <i>A. Robertson</i>	1013
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Advanced Cycle Circulating Fluid Bed for Utility Applications <i>K. Atabay and H. E. Barner</i>	1021	Vol. 2
A Demonstration Plant With Air Cooled AFBC and PFBC to Develop the Combined Cycle Technology <i>O. Bellofatto, F. Grinzi, and M. Simonetta</i>	1030	
A New Concept of Operation of a Pulverized Coal Fired Boiler as Circulating Fluidized Bed Firing <i>P. Basu and P. K. Halder</i>	1035	
Application of the Pyrolyser/Combustor Fluidised Bed System to a Water Tube Boiler Design, Operation and Performance <i>A. R. Butt, R. C. Payne, and G. Wareham</i>	1044	
Reducing Emissions From FPBC by Intrafluid Technology — First Results <i>R. Kirchhoff, D. Sill, and H. D. Schilling</i>	1054	
Integrated Fluidized Bed/Cyclone Combustor With Internal Solids Recirculation <i>J. Korenberg</i>	1061	
Advanced Spouted-Fluidized Bed Combustion Concept <i>F. W. Shirley and R. D. Litt</i>	1066	
Advanced Power Cycle Utilizing Solids Circulation Air Heater/Boiler Technology <i>J. G. Ballantyne and W. B. Johnson</i>	1074	

POSTER PAPERS

Key Factors in Evaluating Bids for a Fluidized Bed Combustion Boiler <i>M. W. McComas and G. L. Gould</i>	1083	
Technology Assessment and Design of Circulating Fluidized Bed Boiler Project for Iowa State University Physical Plant <i>D. Blauw and J. O'Donnell</i>	1089	
The Experimental Investigations of Fine Ash Recycle in an AFB Burning Lean Coal <i>Lan Jixiang, Ruan Zheng, Jing Baosheng, Zhang Mingyao, Tang Huifen, Chen Xiangyong, Zhao Changsui, Lu Yong, Xu Yuenian, Yao Zhibiao</i>	1096	
Cost Sensitivity Studies for a 110 MC CFB Power Plant <i>B. St. John and S. Tavoulaareas</i>	1101	
Comparative Availability Analysis as an FBC Design Evaluation Tool <i>M. S. Johnson, T. M. Nechvatal, J. D. Roughgarden, and F. K. Selker</i>	1105	
A DDC System With the Microcomputer Used on a 35 T/H Fluidized Bed Utility Boiler <i>Zhou Peijun, Jiang Sougou, Zhao Changsui, Ding Weiming, Yao Chunli, and Lu Minning</i>	1111	
The Design and Operation of a Small Scale Circulating Fluidized Bed Combustor <i>D. T. Liang, C. A. Hammer, and J. B. Kearns</i>	1117	
Combustion Trials of Rice Hulls in a Pilot-Scale Fluidized Bed <i>F. Preto, E.J. Anthony, D. L. Desai, and F. D. Friedrich</i>	1123	
Fluid Bed Combustion of Lignocellulose Liquid Waste <i>H. A. Masson</i>	1128	
Fabric Filtration — Atmospheric Fluidized Bed Combustion Versus Pulverized-Coal Combustion <i>K. M. Cushing, P. V. Bush, T. R. Snyder, T. J. Boyd, and R. W. Carson</i>	1134	
An Experimental Study of Pulsed Fluidized Beds <i>N. A. Moussa, A. A. Fowle, and A. W. Hall</i>	1141	
Effect of Solid Loading on a Horizontal Two-Phase Jet in Parallel Fluidized Beds <i>T. F. Salam and B. M. Gibbs</i>	1147	
Evaluation of Heat Transfer Correlations for Fluidized Bed Boiler Tubes <i>N. S. Grewal, B. J. Zobeck, M. D. Mann, and D. R. Hajicek</i>	1153	
A Model and Experiments for Heat Transfer of Single Horizontal Tube in the Freeboard of Fluidized Bed <i>Guo Hongshen, Xu Yiqian, Yao Weiwen, and Lu Yong</i>	1159	
Modelling of Steady-State and Dynamic Characteristics of Multi-Zone Fluidized-Bed Boilers <i>B. Scruton, D. C. Rowe, and B. Chojnowski</i>	1165	

Experimental Verification of Analytical Methods of Determining the Minimum Superficial Velocity in a Binary FBC <i>Z. Q. Zhou, G. S. Trivett, and H. Hamdullahpur</i>	1171	Vol. 2
Coal Devolatilization in Fluidized Bed Combustors and the Distributor With Unequal Vent Area Rate <i>Zhang Xuehong, Wu Song, Cao Yuanquan, and Dong Wenbin</i>	1176	
The Effects of Sulfated Limestones on the $\text{NH}_3\text{-NO-O}_2$ Reaction <i>Y. Y. Lee, S. M. S. Soares, and A. Sekthira</i>	1184	
Calcium Sulphide Formation in Solid Wastes From Circulating Fluidized Bed Combustors <i>E. J. Anthony, J. R. Stephenson, and A. P. de Iribarne</i>	1188	
Circulating Fluidization Research at Cornell: A Study of Hydrodynamic Scale-up Effects <i>M. Y. Louge</i>	1193	
Measurements of Bubble and Particle Motion in a Two-Dimensional FB <i>Luo Weihong, Bao Guangxiang, Zheng Zengrong, Yan Jianhua, and Cen Kefa</i>	1198	
Experimental Study on Devolatilization of Large Coal Particles in a Fluidized Bed <i>J. Q. Zhang, H. A. Becker, and R. K. Code</i>	1203	

DESIGN, PERFORMANCE AND COST OF ATMOSPHERIC FLUIDIZED BED COMBUSTION POWER PLANTS

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ABSTRACT

The U.S. electric utility industry is actively supporting development and demonstration of atmospheric fluidized bed combustion (AFBC) technology for utility application. In support of the program, a design, performance, and cost evaluation was prepared for coal-fired AFBC power plants. The objective was to evaluate and compare alternate AFBC steam generation configurations, and specifically to compare AFBC boilers with underbed vs. overbed feed of coal and limestone. In addition, reference pulverized coal plants with wet limestone flue gas desulfurization systems were evaluated.

Major design assumptions included 1x200 MW and 2x500 MW plant size, East-Central U.S. plant location, high-sulfur Illinois bituminous coal, and 1979 New Source Performance Standards. After an initial screening evaluation of alternate AFBC-overbed feed boiler configurations, detailed evaluations were prepared of the design, performance, resource requirements, and capital, operation and maintenance, and leveled busbar costs of the reference PC/FGD, AFBC-underbed feed, and AFBC-overbed feed power plants. In addition, a sensitivity analysis of the impact of coal type was prepared for a range of coals, including Illinois and West Virginia bituminous, Wyoming subbituminous, and Texas and North Dakota lignites. In general, the evaluation indicated a small capital and leveled busbar cost advantage for the AFBC-overbed feed system at the 200 MW unit scale and confirmed that the AFBC technology is competitive with conventional pulverized coal technology with wet flue gas desulfurization.

INTRODUCTION

The development of Atmospheric Fluidized Bed Combustion (AFBC) technology for utility application is proceeding rapidly. Several large utility-scale AFBC pilot and demonstration plant projects are underway, including:

- o Construction and startup in 1982 of the 20 MW AFBC pilot plant at the Tennessee Valley

Authority's (TVA) Shawnee Station in Paducah, Kentucky.

- o 125 MW AFBC boiler conversion at Northern States Power Company's Black Dog Station near Minneapolis, Minnesota (1986 startup).
- o 110 MW AFBC circulating fluidized bed boiler at Colorado Ute Electric Association's Nucla Station in western Colorado (1987 startup).
- o 160 MW AFBC-bubbling bed at TVA's Shawnee Station (1988 startup).

The principal incentives for development of the AFBC technology include the ability to control both sulfur dioxide (SO_2) and nitrogen oxide (NO_x) emissions in-situ without requiring flue gas desulfurization (FGD) and special low NO_x burners, and the ability to burn a wide range of fuels including high fouling coals and waste fuels without slagging or fouling problems. These advantages are based on the following characteristics of fluidized bed combustion:

- o In-situ capture of SO_2 in a fluidized bed of limestone or other sorbent.
- o Low combustion temperatures, well below the fusion point of coal ash.
- o Reduced formation of NO_x during combustion.

Application of fluidized bed combustion also eliminates the need for coal pulverizers and produces a dry solid waste instead of wet FGD sludge.

The evaluation presented in this paper was prepared in support of the AFBC development program and the design of the three AFBC demonstration projects. The impacts of boiler design options such as overbed vs. underbed feed on balance of plant costs, boiler efficiency, auxiliary power, and reliability had not been evaluated prior to this evaluation. The results were intended to be used to assess the tradeoffs between efficiency and

capital cost in making design decisions for the demonstration projects, to support testing at the 20 MW pilot plant, and to develop a reference plant for future AFBC design evaluations.

OBJECTIVE AND SCOPE

The objective of this study was to assess the impact of using alternate boiler configurations on the efficiency, capital cost, leveled busbar cost, and resource requirements of AFBC power plants.

Conceptual designs, performance, and cost estimates were prepared for both AFBC and conventional pulverized coal-fired (PCF) power plants in both 1x200 MW and 2x500 MW plant sizes. Other major assumptions of the base case evaluation included a Kenosha, Wisconsin plant location, subcritical steam cycle (2400 psig/1000°F/1000°F), a high-sulfur Illinois bituminous coal containing 4% sulfur, and 1979 EPA New Source Performance Standards. AFBC and PCF steam generator designs and estimates were prepared by Babcock & Wilcox Company (B&W)¹, and balance of plant designs, performance, and cost estimates were prepared by Bechtel Power Corporation.²

The AFBC steam generator designs were first developed using AFBC process data available in 1982, but were later updated to account for recent performance and design data from the TVA 20 MW AFBC pilot plant and the AFBC demonstration projects.

The evaluation focused on comparing underbed vs. overbed feed of coal and limestone and was prepared in three stages. The first stage was a screening evaluation in which several AFBC designs using gravimetric, pneumatic, and mechanical overbed feed systems were compared. The second stage was a detailed evaluation of PCF, AFBC-underbed feed, and AFBC-overbed feed designs selected in the screening evaluation. The third stage was a sensitivity analysis of power plant design, performance and costs of burning a wide range of coals.

DESIGN AND ECONOMIC ASSUMPTIONS

The design and economic assumptions are based on the 1987 EPRI economic premises³ and the 1986 EPRI Technical Assessment Guide⁴.

- o Reference year of costs: End-of-year 1984 dollars
- o Plant startup: January 1985
- o 1987 EPRI Economic Premises:
 - Average inflation rate (1985-2014): 6.0%/year
 - Discount rate: 12.5%/year
 - Fixed charge rate: 17.3%/year
- o Book life: 30 years
- o O&M levelization factor: 1.748
- o Fuel levelization factor: 1.92
- o Coal cost is 1.55 \$/MBtu for Illinois coal (see table 1 for others)
- o Limestone cost: 15 \$/ton
- o Lime cost: 65 \$/ton

- o Dry waste disposal cost: 8 \$/ton dry solids
- o FGD sludge disposal cost: 9.25 \$/ton dry solids
- o Process water cost: 0.60 \$/1000 gal
- o Capacity factor: 65%
- o 1979 New Source Performance Standards:
 - 70 to 90% SO₂ Removal
 - 0.5 to 0.6 lb NO_x/MBtu
 - 0.03 lb particulate/MBtu

Coal and limestone coal properties are shown in table 1.

SCREENING EVALUATION

The feasibility of the overbed feed design appeared to be sensitive to the mechanical arrangement of silos, bunkers, and structural steel. Consequently, the screening evaluation was performed to assess the design, performance, and balance of plant cost for alternate AFBC boiler configurations using various overbed coal and limestone feeding systems for both 200 MW and 500 MW units. In addition, the reference PCF and AFBC-underbed feed plants were evaluated for comparison. The screening evaluation was based on previous TVA and EPRI studies and data from the EPRI 2 MW 6' x 6' AFBC Development Facility in Alliance, Ohio.

Initially, the number of alternate overbed feed AFBC configurations were reduced to four 200 MW designs and two 500 MW designs by eliminating those with limited practical potential, possible operating or control problems, or little or no potential improvement in performance or cost. As a result, the pneumatic overbed feed systems were eliminated due to no advantage over the pneumatic underbed feed systems, and all except one gravimetric and one mechanical spreader stoker systems were eliminated due to potential operating problems.

The remaining alternate configurations were screened based on the boiler building height, area, and volume and the balance of plant design and cost. The mechanical overbed and underbed feed configurations were selected for the 200 MW and 500 MW AFBC steam generators for detailed evaluation.

DETAILED EVALUATION

Conceptual design, performance, resource requirements, total capital requirement, operation and maintenance (O&M) cost, and leveled busbar cost estimates were prepared for 1x200 MW and 2x500 MW power plants in each of the following configurations:

- o Conventional pulverized coal with wet limestone flue gas desulfurization (PCF).
- o AFBC with underbed feed (AFBC-UB).
- o AFBC with overbed feed (AFBC-OB).

The steam generator design and performance specifications are based on Bechtel standards, modified to account for the special requirements of an AFBC boiler. The balance of plant designs were developed from EPRI Report PE-1865, "Coal-Fired Power Plant Capital Cost Estimates."⁵