

EAS-ISWA '81

5. Europäisches Abwasser- und Abfallsymposium EAS
München, 22.—26. Juni 1981

5th European Sewage and Refuse Symposium EAS
Munich, 22 to 26 June 1981

5e Symposium Européen des Eaux Usées et de
Résidus Urbains EAS — Munich, 22 au 26 Juin 1981

Symposium der Internationalen Vereinigung für Abfallbeseitigung
und Städtereinigung — ISWA

Symposium of the International Solid Wastes
and Public Cleansing Association — ISWA

Symposium de l'Association Internationale pour les Résidus solides
et le Nettoyement des Villes — ISWA

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INHALTSVERZEICHNIS

原书模糊

5. EUROPÄISCHES ABWASSER- UND ABFALLSYMPOSIUM EAS

SYMPOSIUM DER INTERNATIONAL SOLID WASTES

AND PUBLIC CLEANSING ASSOCIATION — ISWA

vom 22. bis 26. Juni 1981 in München

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Tagungsthema EAS-ISWA:

Allgemeine Probleme von EAS-ISWA: Anwendung der Abfallverbrennung zur Klärschlamm-Behandlung und -Beseitigung

Common problems EAS-ISWA: Use of refuse incineration for sewage sludge treatment or removal
Problèmes communs EAS-ISWA: Utilisation de l'incinération des ordures ménagères pour le traitement ou l'élimination des boues des stations d'épuration.

Diskussionsleiter

J. Défeche, France, P. Fouquet, France

Sludge incineration in Dordrecht (Netherlands)
Ir. L. van der Burg, Netherlands

Seite

Technische Möglichkeiten der kombinierten Schlamm- und Hausmüllverbrennung,
dargelegt an in der Bundesrepublik Deutschland ausgeführten Beispielen
Dipl.-Ing. W. Knorr, Bundesrepublik Deutschland

Seite 1

Expérience de développement d'un procédé de traitement des boues de stations d'épuration
conjointement avec l'incinération des ordures ménagères — Exemple de Lixieux
Y. Bouchala, Ingénieur, France

Seite 3

Teilnutzung der Rauchgaswärme einer Kehrichtverbrennungsanlage für die Schlammbehandlung auf einer regionalen Kläranlage mit hohem Industrielwasseranteil K. Scholl, Schweiz	Seite 45
Procédé de déshydratation et d'incinération des boues des stations d'épuration utilisant la chaleur non récupérée sur les installations moyennes d'incinération des ordures ménagères P.L. Gobron, Ingénieur, France	Seite 61
Erfahrungen mit der gemeinsamen Verbrennung von Klärschlamm und Hausmüll in der Müll- und Klärschlammverbrennungsanlage der Stadt Krefeld Ing. W. Körbel, Bundesrepublik Deutschland	Seite 71
EAS-Hauptthema:	
Neue Techniken der Abwasserbehandlung (Neuerungen bei konventionellen Reinigungsverfahren und weitergehende Abwasserreinigung)	
New techniques of waste water treatment (Innovation in conventional treatment and advanced treatment)	
Nouvelles techniques en traitement de l'effluent (Innovation dans les procédés traditionnels de l'épuration et du traitement tertiaire de l'effluent)	
1. Tagungsthema:	
Neuerungen bei konventionellen Reinigungsverfahren Innovations in conventional treatment processes Innovations des procédés traditionnels	
Diskussionsleiter Prof. E. de Fraja Frangipane, Italy	
Anmerkungen zum EAS-Seminar Basel 1980: Landwirtschaftliche Verwertung von Klärschlämmen Dipl.-Ing. W. Schenkel, Dr. A. Thormann, Bundesrepublik Deutschland	Seite 91
Décantation lamellaire J.P. Leglise, France	Seite 557
Operational and economic aspects of the treatment of municipal waste water by lime-aided settlement and recarbonation C.F.G. Clough, A.R. Butwell, Great Britain	Seite 101
Traitement physico-chimique en deux stades des eaux résiduelles de la Raffinerie Shell Pernis (Pays-Bas) F. Berne, J.M. Rovel, H. Labaquers, France	Seite 113
Colour removal from industrial waste water by granular activated carbon P. Albanese, P. d'Olimpio, P. Lavatelli, M. Agamennone, Italia	Seite 125
2. Tagungsthema:	
Neuerungen bei konventionellen Reinigungsverfahren Innovations in conventional treatment processes Innovations des procédés traditionnels	
Diskussionsleiter Prof. A. van Haute, Belgium	
The use of oxygen in sewage treatment R. Toms, Great Britain	Seite 143

Relationship between phosphate stress, effluent quality and observed cell yield in a pure oxygen activated sludge plant W. Verstraete, W. Vissers, Belgium	Seite 161
--	-----------

Die Verwendung von reinem Sauerstoff als Teilbegasung zur Verminderung von Geruchsproblemen und zur Steigerung des Sauerstoffeintrages am Großklärwerk Emschermündung Dr.-Ing. S. Schlegel, Bundesrepublik Deutschland	Seite 179
--	-----------

Couplage de l'épuration physico-chimique et de l'épuration biologique par bacteries aerobies fixées. La Station d'épuration de Briançon A. Bébin, C.-M. Faup, France	Seite 195
--	-----------

Experience in operating the Deep Shaft activated sludge process O.C. Collins, M.D. Elder, Great Britain	Seite 211
--	-----------

Nouveaux développements en traitement biologique utilisant une biomasse fixée P. Gilles, J.P. Leglise, H. Moreaud, France	Seite 229
--	-----------

3. Tagungsthema:

Weitergehende Abwasserreinigung: Sandfiltration — Mikrosliebung — Abwasserteiche

Advanced treatment: sand filtration — microstraining — lagooning
Traitement avancé: filtration sur sable — microtamisage — lagunage

Diskussionsleiter

Prof. Dr.-Ing. W. Bischofsberger, Bundesrepublik Deutschland

Upgrading of biologically treated sewage by slow sand filtration J.A. Somers, Netherlands	Seite 249
--	-----------

Mikrosliebung zur weitergehenden Abwasserreinigung Dipl.-Ing. M. Roth, Bundesrepublik Deutschland	Seite 277
--	-----------

Weitergehende Abwasserreinigung mittels Mikrosliebung Dr. R. Stürzer, Österreich	Seite 291
---	-----------

New concepts in tertiary filtration F. Jakma, Application Engineer, Netherlands J. Irwin, Senior Application Engineer, USA	Seite 317
--	-----------

Leistung grobkörniger Filter in der weitergehenden Abwasserreinigung Dipl.-Ing. P. Schleyen, Bundesrepublik Deutschland	Seite 333
--	-----------

Development of moving bed filters for continuous filtration A.R. Lister and E.P. Austin, England	Seite 355
---	-----------

Further treatment of sewage effluents by lagooning W.F. Lester, England	Seite 373
--	-----------

4. Tagungsthema:

Stickstoffelimination

Nitrogen removal
Elimination de l'azote

Diskussionsleiter

G.A. Truesdale, Great Britain

Nitrification and denitrification in sewage treatment Dr. M.C. Dart, England	Seite 387
---	-----------

Biological nitrogen removal — Danish development and experience
E. Bundgaard, J. La Cour Jansen, Denmark Seite 405

Design of fixed film nitrification and denitrification units based on laboratory and pilot scale results
Prof. P. Harremoës, Denmark; Prof. Dr.-Ing. I. Sekoulov, Germany; Prof. Dr. L. Bonomo, Italy Seite 423

Biological denitrification and simultaneous phosphorus precipitation of sewage in case of significant fluctuations of polluting loads
R. Cossu, E. de Fraja Frangipane, G. Urbini, Italy Seite 453

Kinetics of phosphorus removal by activated sludge
E. van Vaerenbergh, F.M. Bosch, Belgium Seite 467

5. Tagungsthema:

Phosphorelimination

Phosphorus removal

Elimination de phosphore

Diskussionsleiter

Dr. L. Lijklema, Netherlands

Biological P-removal in domestic wastewater by the activated sludge process
J.H. Rensink, H.J.G.W. Donker, H.P. de Vries, Netherlands Seite 487

Phosphorentfernung im Einzugsgebiet des Neusiedler Sees
Dr. W. Stalzer, Österreich Seite 503

Optimisation de la floculation — filtration pour le polissage des eaux usées
Dr. H. Gros, Schweiz Seite 521

Swedish experiences in the field of phosphorus removal
J. Hultgren, B. Hultman, Sweden Seite 535

Experience on use of ferrous sulphate in view of precipitating phosphorus in plants with extended aeration
R. Määttä, Finland Seite 547

Symposium der International Solid Wastes and Public Cleansing Association — ISWA

(Gemeinsame Vorträge EAS/ISWA siehe Seiten 1—90)

Themenblock I:

Sickerwasser und Gase aus geordneten Deponien

Leachates and gas generation in sanitary landfills

Lixiviation et gaz provenant des décharges contrôlées

Diskussionsleiter

J. Teipel, USA

The assessment and treatment of effluent water from refuse dumps

R. Zayc, Federal Republic of Germany

Seite 571

Vorschläge zur natürlichen Entgasung von Abfalldeponien

Prof. Dr.-Ing. O. Tabasaran, Bundesrepublik Deutschland

Seite 579

Les lessivats de décharge d'ordures ménagères broyées déposées en couches minces:

évolution chimique et bactériologique — traitement

M. Piel, France

Seite 591

Biological treatment of leachate in a full scale plant

R. Cossu, Italy

Seite 605

Anaerobic treatment of leachate from controlled tips of municipal solid waste

P.H.A.M.J. de Bekker, H.M.C. Kaspers, Holland

Seite 621

Ammonia stripping from leachate by countercurrent aeration in shallow tanks

T. Damhaug, P.E. Jahren, Norway

Seite 641

Diskussionsleiter

Prof. Ing. E. de Fraja Frangipane, Italy

Co-Disposal of incineration waste and household waste at a controlled landfill site. Generation and treatment of sulfide-containing leachate

O. Hjelmar, Denmark

Seite 655

Beständigkeit von Deponiedichtungen aus Ton gegen Sickerwässer

Prof. Dr.-Ing. H. Simons, Dipl.-Ing. W. Hänsel, Dipl.-Ing. H. Meseck, Bundesrepublik Deutschland

Seite 673

Möglichkeiten der Sickerwasser-Minimierung in abgeschlossenen Deponien

B. Jäger, K. Wiemer, Bundesrepublik Deutschland

Seite 689

Themenblock II:

Hydrogeologische und geologische Aspekte bei geordneten Deponien

Hydrogeological and geological phenomena in sanitary landfills

Les phénomènes hydrogéologiques et géologiques dans les décharges contrôlées

Analysis for the investigation of refuse decomposition and the determination of landfill stability

Prof. R.K. Ham, T. Booker, USA

Seite 701

Co-disposal of hazardous wastes: Attenuation mechanisms within a landfill site

J. Bromley, C. Stevens, A. Parker, J.F. Rees, Great Britain

Seite 715

Microbiological decomposition in sanitary landfills with different conditions of operation
Dr. H.-J. Ehrig, Bundesrepublik Deutschland

Seite 727

Diskussionsleiter

M.S. Seitzberg, Denmark

Criteria for the co-disposal of municipal and industrial wastes
Dr.-Ing. R. Stegmann, Bundesrepublik Deutschland

Seite 751

Measures to control groundwater pollution near waste disposal sites
Dr. J. Hoeks, Netherlands

Seite 773

The impact of landfilling on a porous geological site with residue resulting from the incineration of municipal waste
J.M. Blanchard, Ph. Revin, France

Seite 789

Etude sur site experimental de la migration en terrain semi-permeable d'effluents issus de boues industrielles
M. Barrès, M. Sauter, France

Seite 809

Themenblock III:

Umweltverträglichkeit und geordnete Deponien

The impact of sanitary landfills on the environment
L'impact des décharges sur l'environnement

Diskussionsleiter

A.M. Pingen, Netherlands

Guide methodologique pour la réalisation des études d'impact sur l'environnement des décharges contrôlées
A. Arnaud, M. Barrès, France

Seite 823

Upgrading land disposal sites
R.A. Colonna, USA

Seite 831

Methods to characterize the conditions of plant growth of the covered sanitary landfill with wild plants and their importance for recultivation
W. Konold, G.-H. Zeltner, Bundesrepublik Deutschland

Seite 859

Planungsarbeit zur Vorbereitung, Inbetriebhaltung und Schließung der geordneten Deponie am Beispiel Budapest
I. Kutas, Ungarn

Seite 871

An example of integrating controlled dump into the landscape
G. Bozzini, V. Ingegnoli, Italy

Seite 881

SLUDGE INCINERATION IN DORDRECHT (NETHERLANDS)

Ir.L. van der Burg, Gevudo, Dordrecht

1. GENERAL

The sludge of the sewage plant in Dordrecht is dewatered, dried and incinerated. Dewatering is achieved by means of centrifuges. A multiple hearth incinerator is used for drying and incineration. Before going into the method of sludge treatment, I would like to discuss the way the choice was made on this treatment and to give a description of the combined plant for refuse, sewage and sludge treatment. When the domestic refuse incineration plant of Dordrecht, built in 1938, after 25 years of service, started to show signs of wear, plans had to be made in the early sixties for the building of a new installation. Due to the absence of a sewage treatment plant in Dordrecht, all sewage water was directly discharged into the river. (Beneden Merwede). However this situation could not be maintained.

Therefore the idea was brought forward that a combined refuse and sludge treatment plant could be useful. Keeping in mind this idea the following criteria had to be met:

1. The refuse treatment had to be achieved by means of incineration and had to serve a community of 280.000 inhabitants.
2. The sewage treatment plant would only serve the municipality of Dordrecht (100.000 inhabitants); Industrial sewage was estimated to be equal to 40.000 inhabitants.
3. The combination refuse-sludge treatment had to be technically and economically viable.
4. It was virtually impossible to find or create a market for the digested dewatered sludge in the surrounding region of Dordrecht. One has to keep in mind that the disposal of this sludge had to be assured throughout the life of the installation.
5. The resulting flue gasses had to be treated and cleaned according to government regulation and therefore cooled.

The released heat should be used as efficiently as possible.

6. The necessary equipment for each stage of the process must have been sufficiently tested and be supplied by reliable companies.

An investigation into the combined composting of refuse and undigested sludge showed that this was technically possible, however this method presented problems in relation to the diminution and iron removal in the refuse. Also the removal of organic and inorganic components that cannot be composted. The largest drawback however, was that for the endproduct no stable market could be found. A closer investigation of the above mentioned consideration showed that thermal sludge conditioning was not preferred, because of the increased load on the water treatment plant. Of all the oxidation processes neither the pyrolysis method nor the fluidised bed method were commercially available at that time.

Due to this, only the multiple hearth incinerator, as used in the roasting of ores, could be considered.

Except, for the during incineration released flue gasses, only the inorganic substances of the sludge remain.

The furnace was already in use for the incineration of sludge, whereby it was necessary to dewater the sludge to a 15 to 20% dry solids and heat had to be added. The common incineration of domestic refuse and sludge practised in Ebingen and Bülach, demands in any case removal of iron and diminution of the refuse resulting in a high rate of mechanical wear, as well as in the mixers as in the furnaces. With an improperly controlled process or by using a low calorific value of the refuse, the temperature in the upper part of the incinerator will drop down too far.

In-complete incineration and pyrolysis will occur and thus cause odour problems. This has already occurred at the Bülach installation, which had to be closed down due to the inconvenience the odours caused.

The combined incineration without prior diminution and mixing of refuse and sludge in grate type incinerators, as is common for refuse incineration, leads to the formation of balls of sludge which are carbonised on the outside but unburned on the inside. They give odour problem at disposal.

Spraying of sludge on refuse gives rise to objections on hygienic grounds. When on top of that it was shown that the incineration capacity had to be enlarged with the sludge contribution it was concluded that the building of a special sludge incinerator next to the three planned refuse incinerators was the best solution.

2. RELATIONSHIP BETWEEN REFUSE INCINERATION SEWAGE TREATMENT AND SLUDGE INCINERATION PLANT

Attachment 1 shows the relationship between the different parts of the installation. In the refuse bunker is dumped:

- domestic and industrial refuse
- coarse refuse after diminution
- sediments from the degritter of the sewage treatment plant
- floating matter from the sewage treatment plant

After mixing this refuse is incinerated in the grating incinerators at a temperature of $800-1000^{\circ}\text{C}$. The experts may like to know that these furnaces are supplied by Martin Munich. After incineration the residue consists of slag, iron and flue gasses of $800-1000^{\circ}\text{C}$.

The sewage treatment plant consists of a degritter, primary sedimentation, aeration- and secondary sedimentation basin.

In these basins are treated:

- the waste water of the Isle of Dordrecht
- the pre sedimentated, used washwater from the scrubbers and also the backwashwater from the drinking water treatment plant in Dordrecht.

From the sewage treatment is subsequently discharged:

- primary sludge from the primary sedimentation basin and surplus sludge from the secondary sedimentation basin, which are together taken to a thickener.
- the effluent is discharged into the river Beneden Merwede. A part of the effluent is however used as washwater in the flue gas-scrubber and as cooling water.

The thickened sludge from the thickener is further dewatered and centrifuged and subsequently discharged into the sludge incinerator. A part of the flue gasses from the refuse incinerators is led into the sludge incinerator countercurrent to the sludge, as a result of which drying and incineration of the sludge takes place. The ash from the sludge incinerator is discharged into containers together with the residue of the refuse incinerators by means of a conveyer belt. A magnetic belt ensures that slag and iron are deposited in separate containers. The iron is disposed off to the scrap iron trade and the slag is dumped.

Research has been done to find possibilities and application of the slag in pavement stones as substitution of gravel.

The result is that some experimental pavement stones of good quality have been made, therefore the possibility exists that future slag can be used in road construction.

In every pavement stone with a weight of 3 kg upto 1 kg of slag can be incorporated.

The flue gasses from the refuse incinerator, as well as the flue gasses used in the sludge incinerators are washed in the scrubbers. This scrubbing is done with sewage water.

Residues from the scrubber are:

- washed flue gasses, saturated with water vapor
- polluted washwater

3. FLUE GASWASHING

The raw flue gasses are containing flyash and also corrosive and harmful gasses like SO_2 , NO_x , HCl and HF .

With application of electrofilters only the solid particles would be removed and not the harmful gasses. Before flue gasses can be passed through electrostatic precipitators it is necessary to cool them down to $250\text{--}300^\circ\text{C}$.

This cooling process can be achieved by means of the production of steam, cooling with air or evaporation of water in the gasstream. Steamproduction was rejected for economical reasons. The argument being that there was some fear that a growing proportion of halogenated plastics would cause excessive corrosion to the steam pipes, which evidently would be a large source of unscheduled stoppages. It is important to realise that these ideas date back to the sixties, while then the energy conservation problems did not yet exist.

Lowering of the flue gas temperature by means of adding air makes it necessary that the induced draught fan and electrostatic precipitators have to be 3 times as big as normal. This in turn means larger investments and a higher energy consumption. By evaporation of water injected into the gasstream the temperature of the flue gasses can be lowered. By cooling the flue gasses to such a temperature that the water only partly evaporates, polar gas molecules can dissolve in the water phase, whereby not only the solid particles, but also the harmful components are removed. The temperature of the washwater as well as the flue gasses must not exceed 70°C after the washing process.

Due to the application of radial flow scrubbers electrostatic precipitators were not required. The required water is obtained from the effluent of the sewage treatment plant. For a refuse furnace with a capacity of 7 Mg/h , for each scrubber about $90\text{ m}^3\text{ water/h}$ is supplied of which $20\text{ m}^3\text{ h}$ is evaporated. The scrubbed and cooled flue gasses are saturated with water which causes a stack plume. By a tangential introduction of the scrubbed gasses, into the stack, not

evaporated water droplets will be caught and ejected. This due to centrifugal force. Not only flyash but also HF, HCl, and a lesser extent SO₂ will go into solution in the remaining washwater. Results of gas scrubbing are in average:

	raw flue gas	scrubbed	reduction	emission
HF	15 mg/m ³	6,0 mg/m ³	96 %	0,1 kg/h
HCl	600	70	88	8,4
SO ₂	280	135	52	16,2
Flyash	1200	110	92	13,2

The effect of scrubbing on NO_x has not yet been determined. The pH of the washwater decreases from 7 to a pH less than 5. pH correction is achieved by adding CaCO₃ - containing rinsing water of the nearby water treatment plant. This correction is not normally necessary, but serves as protection for the concrete parts, which are attacked if the "acid" water has a too low pH-value before it is fully mixed with sewage water. A good protective coating on the concrete parts could also be a solution. The temperature of the sewage water will increase about 8 to 12° C. after mixing with the washwater (70° C.) depending on the quantities of supplied water. This temperature increase causes a larger bacterial activity which in turn creates an improved cleaning capability, especially in view of nitrogen reduction. Also volatile substances will be present in the flue gasses and subsequently be absorbed by the water. After the scrubbing process zinc, lead, copper, cadmium and chrome have been found in the washwater. They will partly settle in the washwater sedimentation basin and partly in the primary sedimentation basins. So it is possible these heavy metals come in a vicious circle, or are ejected together with the ash of the sludge incinerator or into the air. A quantitation analysis has to be made.

There are indications that the biological cleaning process is negatively influenced by heavy metals. An investigation has to be made. A large variety of heavy metal compounds have been found in the slags and flyash of refuse incinerators.

When the discharge of heat from the combustion gasses should lead to an unacceptable level of temperature increase of the sewage water to be cleaned, then partial aircooling of the washwater should be needed.

4. SLUDGE TREATMENT PLANT

After the thickener the sludge treatment consists of the following stages:

1. Centrifuges filling pump; This pump takes the sludge from the thickener to the centrifuges.
2. Centrifuges; to thicken the sludge mechanically.
3. Polyelectrolyte supply installation; This injects an amount of flocculant to the sludge just before entering the centrifuges.
4. Screw conveyor; used to take the sludge from the centrifuges to a collection basin.
5. Sludge incinerator supply pump, which takes the sludge from the collection basin to the sludge incinerator.
6. Sludge incinerator consisting of 12 floors with a diameter of 6 meters.
7. Ash chain-conveyor with humidification equipment.
8. Cooling air fan, for cooling the hollow shaft and scraper arms.

Additional equipment like, combustion air fan, induced draught fan, scrubber and stack, were not required as the existing equipment of the refuse incinerator could be used for this purpose.

4.1. Sludge treatment

A part of the excess sludge is returned to the primary sedimentation basins. This surplus sludge settles together with the primary sludge, after which the mixture of primary and secondary (surplus) sludge is pumped to the thickener, by means of a mono-pump. From the thickener the sludge is pumped through a filter and dividers to the centrifuges. Just before entering the centrifuges polyelectrolyte is added. The flocculant assures that the small sludge particles congeal to larger particles, with the result that also these sludge particles are separated from the water. The volume of the sludge after centrifuging, is about 1/10 of the sludge leaving the treatment plant. The water released in this process is evidently fed back into the sewage treatment plant. After the centrifuge stage the sludge is ready for incineration. The centrifugate from the centrifuges is a neglectable load for the sewage plant.

4.2. Sludge incineration furnace

After the centrifuge stage, the sludge is introduced at the top of the sludge incinerator. This incinerator consists of a circular steel housing with a diameter of 6 meters and a height of 13 meters. With the aid of heat resistant brickwork 12 floors are build up. In the centre of the furnace rotates a double walled hollow shaft. Attached to this hollow shaft just above each storey level hollow arms are fixed. The hollow shaft and these arms are cooled with the aid of a cooling air fan. On the arms, scrapers are mounted which slowly transport the sludge and ash. The sludge is pumped into the furnace on the outside of the top floor. By means of the scrapers the sludge is than slowly moved in the direction of the hollow shaft.

At the top floor there is an opening around the hollow shaft, through which the sludge drops to the second floor.

The second floor is mounted around the hollow shaft without space.