

INDUSTRIAL GAS CLEANING

(2nd Edition – S I Units)

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W. STRAUSS

INDUSTRIAL GAS CLEANING

SECOND EDITION

*The principles and practice of the control of gaseous
and particulate emissions*

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PREFACE TO THE SECOND EDITION

AS READERS of the first edition are aware, this book attempted to review critically the science, technology and "state of the art" of cleaning industrial process and waste gases, with particular emphasis on the control of atmospheric pollution. During the six-year period since the completion of the manuscript of the first edition, there have been some major developments in the technology of gas cleaning, with lesser, but still significant, theoretical developments.

These technological developments include processes for removing sulphur dioxide from flue gases, improvement in the design of direct-flame incinerators, filter materials suitable for temperatures to 400°C and a reverse-flow cyclone, to name only a few. These developments have made the revision of the book an urgent one. The new edition also gives the writer an opportunity to correct a number of errors found in the first edition. He wishes to express his thanks to all those who have written to him pointing these out.

The first edition has been found suitable by many as a textbook for graduate courses and special courses in air-pollution-control technology. In view of this, a brief section has been appended giving some examination questions which were used by the writer. If teachers and practitioners in the field develop new questions, particularly numerical ones, the author would be pleased to receive these to incorporate in future editions.

A criticism levelled at the first edition was that no cost information was included. At that stage this was deliberate as, with the exception of the work of Stairmand,⁸⁰⁴ very little had been done in this area. More recently, however, some attempt has been made to assess costs in the United States, England and Australia, and this will be published elsewhere by Mr. J. R. Alonso.¹⁵ A new chapter, Chapter 12, has been added which will help in assessing cost of plants, although it is not intended as a guide to detailed costing.

The author wishes to acknowledge the help by discussions and friendly criticism he has received in the preparation of this new edition from his colleagues and research students at the University of Melbourne and at the Westinghouse Research Laboratories, in particular Prof. S. R. Siemon and Dr. E. V. Somers. He also wishes to acknowledge gratefully the help he has received in the careful revision of the manuscript from Miss V. Carter and Mrs. D. Muir.

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PREFACE TO THE FIRST EDITION

THE control of air pollution at its major and most varied source, the industrial process, is a task confronting an increasing number of engineers and applied scientists. When starting his postgraduate studies some years ago the author was set the problem of finding a new method of reducing the fumes from steel-making processes, with particular emphasis on the fine orange-brown fumes from the then recently introduced oxygen lancing in the open-hearth and the pneumatic steel-making processes. The new process was to be cheaper than the conventional methods used—electrostatic precipitation or venturi scrubbing—although the efficiency requirements were not quite as rigorous. Subsequently a pebble-bed type filter was developed and found to be over 90 per cent efficient in some circumstances.³³²

At the beginning of the programme of research no details of fume emission at the various stages of open-hearth steel making could be found in the published literature, and even if the fume characteristics had been defined, the possible mechanisms of collection were not set down in a textbook or monograph, together with the relevant equations which could be used to test the applicability of a particular mechanism. The author found further that gas cleaning was treated by its practitioners largely as an art based on practical experience and rule of thumb. Although the basic theory of gas-cleaning mechanisms was published in scattered papers, no integrated account of these was available to engineers who wished to use them in “scale-up” calculations or in predicting the effect of a change in one of the process variables, such as gas velocity through a cleaning system. Even now only two aspects of gas cleaning, absorption and electrostatic precipitation, have received extensive treatment, while the gas-cleaning methods involving particle mechanics generally have not been comprehensively reviewed. The author hopes that this book will go some way towards filling this gap, and that it will prove useful to the engineer designing or specifying gas-cleaning plant as well as to the applied scientist developing new methods of gas cleaning.

The author wishes to acknowledge the assistance and encouragement he received from Prof. M. W. Thring, who first directed his interests towards this field, and from his colleagues, in particular, Mr. R. S. Yost, who is responsible for Appendix I, Mr. C. H. Johnson, who read and made many helpful suggestions with respect to Chapters 4 and 7, and Mr. J. B. Agnew, who similarly assisted with parts of Chapter 3. The author is particularly indebted to the Engineering Librarian, Mr. J. Greig, and his staff, for their help with references and diagrams, and Mrs. F. M. Beissel, for her careful typing of the manuscript.

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LIST OF SYMBOLS

Latin Letters

<i>a</i>	constant interfacial or surface area per unit volume height of cyclone entrance line distance from node coefficient of diffuse reflection
<i>A</i>	surface area aggregate surface area of particles in unit volume
<i>A_p</i>	external surface area of a porous solid
<i>A</i>	area of plates in electrostatic precipitator amplitude of sound vibrations
<i>b</i>	constant time fraction wind is in a 45° sector entrance width of cyclone (<i>ab</i> = cross-sectional area of cyclone entry)
<i>B</i>	breadth of settling chamber diameter of opening at cone apex in cyclone
<i>c</i>	constant concentration (mass or volume) of particles in gas
<i>c₀</i>	number of particles at zero time centre-line particle concentration
<i>C</i>	Cunningham correction factor
<i>C_D</i>	drag coefficient
<i>C_{DA}</i>	drag coefficient for accelerating particles
<i>C₀</i>	function of applied voltage \mathcal{O} and electrode geometry ($\mathcal{O}/\ln R_2/R_1$)
<i>C_p</i>	specific heat, constant pressure
<i>C_v</i>	specific heat, constant volume
<i>C_y</i>	generalized eddy diffusion coefficient—cross wind (Sutton ⁸⁴³)
<i>C_z</i>	generalized eddy diffusion coefficient—vertical (Sutton ⁸⁴³)
<i>e</i>	constant
<i>d</i>	diameter of spherical particle
<i>d''</i>	diameter of sphere of influence
<i>d_A</i>	area diameter (diameter of circle with same projected area as that of particle)

d_c	diameter of cloud
d_e	drag diameter
d_s	surface diameter (diameter of sphere with same surface area as particle)
d_v	volume diameter (diameter of sphere with same volume as particle)
d_{crit}	diameter of smallest particle 100 per cent collected
d_{50}	diameter of particle 50 per cent collected
D	diameter of cyclone
	diameter of collecting body (fibre, droplet, rod or sphere)
	diameter of sampling probe
D_C	diameter of core
D_e	diameter of exit pipe in cyclone
\mathcal{D}	diffusivity (Brownian)
e	electronic charge
	charge on an ion
e	turbine efficiency
E	strength of heat source relative to surrounding atmosphere (J s^{-1} ; W)
	field strength of electric field (V m^{-1})
E'	strength of charging field
E	energy intensity (sonic) (J m^{-2})
E_c	critical field strength for electrical breakdown of gases
f	free falling speed of particles
	Fanning friction factor
F	fluid resistance force on particle
F_h	hydrodynamic attractive force in sonic field
F_r	radiation pressure in a sonic field (N)
F_t	thermal force
F_c	fluid resistance to clouds
F_E	electrostatic force
F_{EI}	electrostatic image force (image of collector induced on particle)
F_{EM}	electrostatic image force (image of particle induced on collector)
F_{EC}	coulombic force
F_{ES}	space charge force
F_W	fluid resistance corrected for wall effects
g	gravity acceleration
g_c	gravity-acceleration constant
G	potential temperature gradient in the atmosphere ($^{\circ}\text{C m}^{-1}$)
	force on a particle
	friction constant (Stairmand) for cyclones
\mathcal{Q}	gravitational settling parameter
h	height of cylindrical section of cyclone
H	total height of smoke plume (effective stack height)
	height of settling chamber
	height of cyclone (or length, if cyclone body curved)

H	field strength of magnetic field ($A\text{-turn m}^{-1}$)
H_S	chimney stack height
H_t	height of a transfer unit (gas absorption)
H_T	buoyancy rise of plume
H_V	momentum rise of plume (velocity rise)
\mathcal{H}	Henry's law constant
i	ionic current per unit length of conductor
I	light intensity
	index of agglomeration (sonic)
\mathcal{I}	sound intensity
J	variable in Bosanquet buoyancy rise equation
k	orifice coefficient
	extinction coefficient
k	Boltzmann's constant
k_f	mass-transfer coefficient—gas to solid surface
k_G	gas-film mass transfer coefficient
k_L	liquid-film mass transfer coefficient
K	correction factor
K_G	overall mass-transfer coefficient (pressure units)
K_L	overall mass-transfer coefficient (concentration units)
l	distance between two particles
	distance for absorption
l	distance between enclosing walls
L	rate of liquid flow
	depth of filter bed
	length of settling chamber
	distance between wire and plate in electrostatic precipitator
	distance moved by particle in sonic field
L_1	ratio of liquid flow to gas flow in scrubber (lm^{-3})
m	mass flow
	mass of particle
	irregularity factor—a function of wire condition
M	molecular weight
M'	weight of a molecule
M	rate of deposition ($\text{mg m}^{-2}/\text{day}$)
\mathcal{M}	function of weights of particles and ions
n	turbulence index (Sutton)
n	number of times greater than the force of gravity
N	molecules per unit volume
	number of points
N_1	ions per unit volume
N	number of revolutions
\mathcal{N}	number of revolutions of gas stream in cyclone

N_A	rate of molecular transfer of species A
p_A	partial pressure of component
p_{AM}	logarithmic mean partial pressure of component A
p_i	partial pressure at interface
P	total gas pressure
P_c	cyclone gas pressure (average)
P_i	cyclone inlet gas pressure
Pe	Peclet number
\mathcal{P}	power
P	probability of collection
Δp	pressure drop
Δp_{CF}	pressure drop with constant gas flow
q	charge on a particle (subscript I refers to particle I)
Q	gas-flow rate ($\text{m}^3 \text{s}^{-1}$, $\text{m}^3 \text{h}^{-1}$)
	charge on a collecting body
Q'	rate of emission of pollutant gas
r	radius of particle
	distance between centre of particle and centre of collector
r	resistivity of dust layer
\bar{r}	average pore radius
R	universal gas constant
	radius of a circle
	radius of precipitator wire and tube
	interception parameter (d/D)
R_A	drag on accelerating particles
Re	Reynolds number ($u_0 D/\mu$ —pipes, $u d_0/\mu$ —particles)
Re_c	Reynolds number—collecting body ($v_0 D_0/\mu$)
R_h	half distance between sphere centres for hexagonal particle arrangement
S	cross-sectional area of absorption tower
	retentivity of charcoal (Turk's equation 3.60)
	stopping distance
	width of corona layer on discharge electrode
	influence factor (ratio of diameter of sphere of influence of particle and actual particle diameter)
	depth of cyclone exit pipe within cyclone
S_*	dimensionless stopping distance
Sc	Schmidt number ($\mu/\rho \mathcal{D}$)
\mathcal{S}	collection surface in electrostatic precipitator per unit volume gas flow
t	time
T	absolute temperature
T_s	stack exit gas temperature
T_1	absolute temperature at which density of stack gases equals density of atmosphere (K)

u	gas velocity wind velocity molecular velocity
\bar{u}	average velocity average velocity of gas molecules
u_g	velocity amplitude of gas
u_H	axial velocity
u_i	inlet velocity ionic mobility in a field of unit strength
u_p	velocity amplitude of particle
u_R	radial velocity
u_s	superficial velocity
u_t	terminal velocity
u_T	tangential velocity
u_τ	shear velocity
U	average gas velocity
U_S	velocity of sound
v	velocity stack exit velocity
v_0	undisturbed upstream fluid velocity
Δv	relative velocity of two particles
V	rate of gas flow (absorption) volume of settling chamber
V_a	swept volume
V_A	volume of species A at normal boiling point
\mathcal{O}	voltage, potential difference
V_1	voltage of collecting body
\mathcal{O}_c	corona starting voltage
V_d	potential across deposited dust layer
w	thickness of refractory
W	rate of solids emission weight of adsorbing solid distance between successive wires in electrostatic precipitator
x	downwind distance from stack (plume dispersion) mole fraction downstream distance in precipitator thickness of boundary layer thickness of dust layer dust content of filter cloth exponent in voltage/corona current equation
x_e	equilibrium dust content of filter cloth
X	function in Bosanquet buoyancy equation
X_g	amplitude of gas vibration

X_p	amplitude of particle vibration
y	cross wind distance (plume dispersion) mole fraction
Z	function in Bosanquet equation height of absorption tower diffusion collection parameter
z	particles per m^2 of fibre

Greek Letters

α	constant blade angle entrance loss coefficient for cyclone packing density
β	constant loss constant volume concentration correction factor
γ	specific heat ratio (C_p/C_v)
ϵ	porosity or voidage of a packed bed or porous solid
ϵ	dielectric constant of an aerosol particle
ϵ_0	specific inductive capacity of space ($8.85 \times 10^9 \text{ A}^2 \text{ N}^{-1}$)
ϵ	loss number
ζ	dimensionless pressure-loss factor
η	efficiency
η_C	interception-collection efficiency
η_D	diffusion-collection efficiency
η_I	inertial-impaction collection efficiency
η_0	overall efficiency
η_{ICD}	combined efficiency
η_z	particle collection efficiency on fibre
θ	angle of particle movement parameter for cylindrical coordinate
κ	permeability coefficient thermal conductivity coagulation constant
κ_g	thermal conductivity of gas
κ_p	thermal conductivity of particle
κ_{str}	translational part of thermal conductivity of gas
λ	mean free path of gas molecules wavelength of sound waves
μ	viscosity of gas
μ_d	viscosity of droplet
ν	frequency

ξ	constant for free vortex formula
ρ	gas density
ρ_F	fibre bed density
ρ_L	density of liquid
ρ_V	density of vapour
ρ_p	density of particle
σ	molecular diameter
	surface tension
	space charge per unit volume
σ_{AB}	sum of radii of two interacting molecules or ions (distance between centres)
τ	dimensionless time parameter
	time constant
	dimensionless precipitator length ($x/Lf(\mathcal{D})$)
	period of vibration
τ_0	fluid shear stress at wall
T	parameter ($= mu_T^2/3\pi\mu dR_0$)
φ	friction factor for cyclones (Stairmand formula)
Φ	current density ($A m^{-2}$)
	dimensionless drift velocity parameter
χ	internal porosity of solid granules
	circularity of particles
ψ	inertial impaction parameter
Ψ	sphericity
ω	drift velocity
ω'	effective migration velocity

CONTENTS

PREFACE TO THE SECOND EDITION	xiii
PREFACE TO THE FIRST EDITION	xv
LIST OF SYMBOLS	xvii
Introduction	1
I.1 <i>Why clean gases?</i>	1
I.2 <i>Nature of air pollutants</i>	1
I.3 <i>How can gases be cleaned?</i>	5
I.4 <i>Tackling a gas-cleaning problem</i>	6
1. To what Extent must Gases be Cleaned?	9
1.1 <i>Introduction</i>	9
1.2 <i>Ambient air-quality standards</i>	10
1.3 <i>Harmful concentrations of pollutants</i>	14
1.4 <i>Ground-level concentrations from elevated-point source emissions</i>	18
1.5 <i>Geographical factors in air-pollution control</i>	26
1.6 <i>Air-pollution control legislation</i>	26
1.6.1 <i>United Kingdom</i>	27
1.6.2 <i>United States</i>	31
1.6.3 <i>U.S.S.R.</i>	32
1.6.4 <i>German Federal Republic</i>	32
1.6.5 <i>France</i>	34
1.6.6 <i>Holland</i>	34

1.6.7	<i>Belgium</i>	35
1.6.8	<i>Sweden and Denmark</i>	35
1.6.9	<i>Italy</i>	35
1.6.10	<i>Australia</i>	35
1.6.11	<i>Canada</i>	36
1.6.12	<i>New Zealand</i>	37
1.6.13	<i>Ireland</i>	37
1.6.14	<i>Japan</i>	38
2.	Basic Data Requirements	39
2.1	<i>Introduction</i>	39
2.2	<i>Determination of gas flows</i>	39
2.2.1	<i>Measurement of gas flows</i>	40
2.2.2	<i>Calculation of flow rates</i>	43
2.3	<i>Measurement of gas temperature</i>	43
2.4	<i>Estimation of dew point</i>	52
2.5	<i>Classification of sampling</i>	54
2.6	<i>Collection and analysis of major gaseous constituents</i>	54
2.7	<i>Collection and analysis of minor gaseous constituents</i>	58
2.8	<i>Isokinetic sampling and probes for solid and liquid particles</i>	61
2.9	<i>Sample collectors for solid and liquid particles</i>	66
2.10	<i>Sample volumes</i>	68
2.11	<i>Classification of size-analysis methods</i>	69
2.12	<i>Size analyses based on particle geometry</i>	69
2.13	<i>Particle analyses based on aero- and hydrodynamics</i>	71
2.14	<i>Average particle size based on surface area</i>	74
2.15	<i>Other methods of particle sizing</i>	74
2.16	<i>Monitoring atmospheric pollution</i>	77
3.	The Removal of a Gaseous Constituent: Absorption, Adsorption and Combustion	80
3.1	<i>Introduction</i>	80
3.2	<i>Calculation of molecular diffusivity</i>	81

3.3	<i>Steady state diffusion of two gases</i>	83
3.4	<i>Theories of absorption</i>	85
3.5	<i>Design of absorption systems</i>	89
3.6	<i>Construction of absorption plant</i>	93
3.7	<i>Gas-absorption processes</i>	98
3.7.1	<i>Sulphur dioxide (SO₂)</i>	98
3.7.2	<i>Fluorine and fluoride compounds (HF, SiF₄)</i>	113
3.7.3	<i>Chlorine and chlorides</i>	118
3.7.4	<i>Hydrogen sulphide</i>	120
3.7.5	<i>Nitrogen compounds</i>	127
3.8	<i>Adsorption of gases on solids</i>	133
3.8.1	<i>Non-polar adsorbents—Carbon</i>	135
3.8.2	<i>Polar adsorbents</i>	141
3.8.3	<i>Adsorption with chemical reaction</i>	142
3.9	<i>Combustion processes—Flame combustion</i>	156
3.10	<i>Catalytic combustion of organic materials</i>	163
3.11	<i>Catalytic oxidation and decomposition</i>	166
3.11.1	<i>Sulphur dioxide</i>	166
3.11.2	<i>Oxides of nitrogen</i>	171
3.11.3	<i>Carbon monoxide</i>	171
4.	Fluid Resistance to Particle Motion	173
4.1	<i>Introduction</i>	173
4.2	<i>Fluid resistance to spheres in steady state motion</i>	174
4.3	<i>Fluid resistance to accelerating particles</i>	179
4.4	<i>Fluid resistance in a non-continuous medium</i>	181
4.5	<i>Fluid resistance to particle motion in a bounded fluid</i>	184
4.6	<i>Fluid resistance when a number of particles are present</i>	186
4.7	<i>Deposition from turbulent fluids</i>	189
4.8	<i>Fluid resistance to non-spherical particles</i>	192
4.9	<i>Particle roughness</i>	197
4.10	<i>Particle density</i>	198

5. Gravity and Momentum Separation Equipment	199
5.1 <i>Introduction</i>	199
5.2 <i>Theory of settling-chamber design</i>	199
5.3 <i>Application of simple settling chambers</i>	204
5.4 <i>Momentum separators</i>	205
6. Centrifugal Separators	216
6.1 <i>Introduction</i>	216
6.2 <i>Particle separation in a spinning gas</i>	217
6.3 <i>Straight-through cyclones with fixed impellers</i>	227
6.4 <i>Straight-through cyclones with moving impellers</i>	232
6.5 <i>Centrifugal-fan cyclone separators</i>	233
6.6 <i>Conventional (reverse-flow) cyclones</i>	233
6.7 <i>Prediction of cyclone performance</i>	238
6.8 <i>Prediction of cyclone pressure drop</i>	249
6.9 <i>Effect of high dust loadings</i>	254
6.10 <i>Commercial cyclones</i>	258
6.10.1 <i>Straight-through cyclones with fixed impellers</i>	259
6.10.2 <i>Straight-through cyclones with moving impellers</i>	263
6.10.3 <i>Straight-through cyclones with fixed impeller and reverse flow</i>	263
6.10.4 <i>Scroll collectors</i>	265
6.10.5 <i>Collectors combined with induced-draught fans</i>	267
6.10.6 <i>Conventional (reverse-flow) cyclones</i>	267
6.10.7 <i>Multiple cyclones</i>	271
6.10.8 <i>Cyclones for liquid droplets</i>	273
6.11 <i>Cyclones in series</i>	275
7. The Aerodynamic Capture of Particles	277
7.1 <i>Introduction</i>	277
7.2 <i>Velocity distribution around a cylinder</i>	278
7.3 <i>Inertial impaction</i>	280
7.4 <i>Interception</i>	285

7.5	<i>Diffusion</i>	287
7.6	<i>Combination of inertial impaction, interception and diffusion</i>	293
7.7	<i>Effect of temperature and pressure on the basic mechanisms</i>	297
7.8	<i>Deposition by gravitational settling</i>	299
7.9	<i>Electrostatic forces</i>	300
7.10	<i>Multiple collectors</i>	306
7.11	<i>Retention of particles on collectors</i>	308
	7.11.1 <i>van der Waals forces</i>	309
	7.11.2 <i>Electrostatic forces</i>	311
	7.11.3 <i>Capillary attraction</i>	311
	7.11.4 <i>Experimental investigation of particle adhesion</i>	312
8.	Filtration by Fibrous Filters	314
8.1	<i>Introduction</i>	314
8.2	<i>Construction of industrial filter plant</i>	315
	8.2.1 <i>Dust-cake removal methods</i>	318
	8.2.2 <i>Suspension and support of filter sleeves</i>	324
	8.2.3 <i>Housing</i>	325
8.3	<i>Filter materials</i>	326
	8.3.1 <i>Properties and application of fibres</i>	329
8.4	<i>Filter-plant operation</i>	335
	8.4.1 <i>Gas-flow rates: gas to cloth ratios</i>	335
	8.4.2 <i>Timing intermittent dust-cake removal</i>	336
	8.4.3 <i>Pressure losses in filter media</i>	338
	8.4.4 <i>Electrostatic charges in fibre filtration</i>	342
8.5	<i>Fibre filters for special applications</i>	346
	8.5.1 <i>Filters for very high temperatures (above 400°C)</i>	346
	8.5.2 <i>Mist filters</i>	348
	8.5.3 <i>Filters for decontamination of radioactive gases</i>	353
	8.5.4 <i>Filters in air conditioning</i>	357
9.	Particle Collection by Liquid Scrubbing	367
9.1	<i>Introduction</i>	367
9.2	<i>Spray towers</i>	369