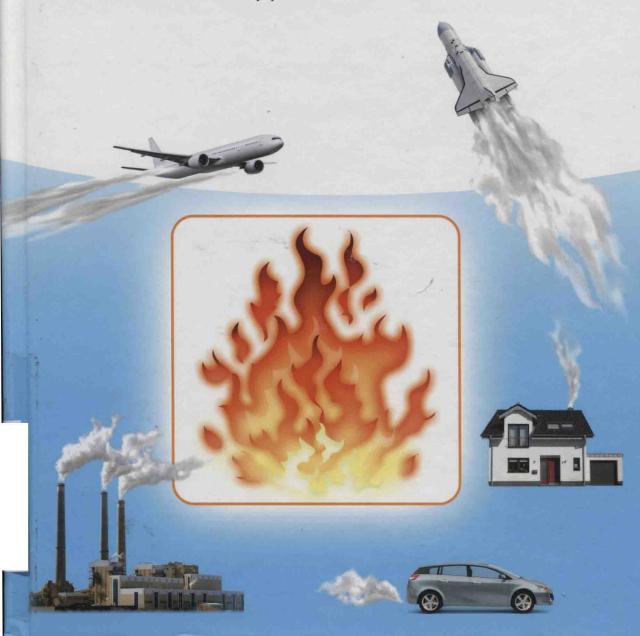
Maximilian Lackner, Árpád B. Palotás and Franz Winter

Combustion

From Basics to Applications



Maximilian Lackner, Árpád B. Palotás, and Franz Winter

Combustion

From Basics to Applications



WILEY-VCH Verlag GmbH & Co. KGaA

The Authors

Maximilian Lackner

Vienna University of Technology Institute of Chemical Engineering Getreidemarkt 9 /166 1060 Vienna Austria

Árpád B. Palotás

University of Miskolc Institute of Chemical Engineering 3515 Miskolc-Egyetemvaros Hungary

Franz Winter

Vienna University of Technology Institute of Chemical Engineering Getreidemarkt 9 /166 1060 Vienna Austria All books published by **Wiley-VCH** are carefully produced. Nevertheless, authors, editors, and publisher do not warrant the information contained in these books, including this book, to be free of errors. Readers are advised to keep in mind that statements, data, illustrations, procedural details or other items may inadvertently be inaccurate.

Library of Congress Card No.: applied for

British Library Cataloguing-in-Publication DataA catalogue record for this book is available from the British Library.

Bibliographic information published by the Deutsche Nationalbibliothek

The Deutsche Nationalbibliothek lists this publication in the Deutsche Nationalbibliografie; detailed bibliographic data are available on the Internet at http://dnb.d-nb.de>.

© 2013 Wiley-VCH Verlag GmbH & Co. KGaA, Boschstr. 12, 69469 Weinheim, Germany

All rights reserved (including those of translation into other languages). No part of this book may be reproduced in any form — by photoprinting, microfilm, or any other means — nor transmitted or translated into a machine language without written permission from the publishers. Registered names, trademarks, etc. used in this book, even when not specifically marked as such, are not to be considered unprotected by law.

Cover Design Formgeber, Eppelheim

Typesetting Thomson Digital, Noida, India

Printing and Binding Markono Print Media Pte Ltd, Singapore

Printed in Singapore Printed on acid-free paper

Print ISBN (Hardcover): 978-3-527-33376-9 Print ISBN (Softcover): 978-3-527-33351-6

ePDF ISBN: 978-3-527-66721-5
ePub ISBN: 978-3-527-66720-8
mobi ISBN: 978-3-527-66719-2
oBook ISBN: 978-3-527-66718-5

Maximilian Lackner, Árpád B. Palotás, and Franz Winter

Combustion

Related Titles

Lackner, M., Winter, F., Agarwal, A. K. (eds.)

Handbook of Combustion

5 Volumes 2010

ISBN: 978-3-527-32449-1

Koch, E.-C.

Metal-Fluorocarbon Based Energetic Materials

2012

ISBN: 978-3-527-32920-5

Stolten, D., Scherer, V. (eds.)

Transition to Renewable Energy Systems

2013

ISBN: 978-3-527-33239-7

Fricke, J., Borst, W. L.

Essentials of Energy Technology Sources, Transport, Storage, Conservation

2013

ISBN: 978-3-527-33416-2



Foreword

Combustion is a fascinating process which has been quite instrumental in civilization and industrialization. From the hearth fire and cooking stove, via techniques for ore smelting, glass blowing and porcelain making, to steam engines, cars and power plants, combustion has accompanied the history of humankind. Now, in a situation where global warming and air quality deterioration are associated with combustiongenerated carbon dioxide and pollutants, it is at the same time important to provide access to affordable but clean and sustainable energy. Combustion as mature technology still dominates today's power generation and transportation, and it is used in a number of important industrial processes and applications. Many professions, trades and businesses are linked to combustion, and many people world-wide depend on their work for car and aircraft manufacturers, for the petroleum, cement or steel industry or even as safety engineers and firefighters. This global situation is not likely to be changed rapidly, in spite of considerable effort to replace fossil by renewable energy, regarding the increase in world population and the desire to raise living standards and productivity accordingly. Combustion thus shows its Janus face today with promises of high-density fuels for an energy-hungry and mobile society on the one hand and threatening pictures of smog-polluted megacities without blue skies on the other.

It is thus time for the present volume as a summary and introduction to combustion fundamentals and applications for the more generally interested reader, including students and practitioners. With a fundament in physics and chemistry, modern concepts of combustion are presented in the necessary detail for a broad overview, without an excess of detail, in coherent and comprehensible fashion. The book provides a clear structure with seven Chapters, starting with some historical facts and interesting details in Chapter 1. The second Chapter introduces fuels with respect to their important properties and physic-chemical characteristics, accompanied by useful tables and literature. With Chapter 3, the fundamental principles of combustion are provided in an instructive form with some illustrative and facile calculation examples. The reader is introduced to the concepts of stoichiometry, the conservation equations and transport processes as well as to the basics of chemical reaction mechanisms and ignition processes. Pollutants are characterized in Chapter 4, which mainly gives some classifications and describes the main sources for specific emissions. For a more in-depth understanding of the different categories

of pollutants and their chemical formation and destruction pathways, readers are referred to relevant original literature. The very important aspect of carbon dioxide formation from combustion processes and concepts for carbon dioxide management are presented in Chapter 5. The next Chapter is very instructive regarding the typical technical environments in which combustion is encountered, and it explains many interesting features of combustion devices including those found in heating, power generation, transportation, and in certain industries. As a modern concept, combustion and gasification are seen as somewhat related subjects, with a short access also to gasification strategies. The book concludes with important safety aspects, especially also regarding industrial-scale applications.

In a timely manner, the book offers an overview on an introductory level, and in this respect, it will be useful to a broad community. Certainly, huge tomes could be written for each subject treated in these Chapters, and substantial reviews and literature exists on individual facets of combustion – as for example, conventional and bio-derived fuels, combustion kinetics or specific combustion systems and applications. For a field that is as complex as that of combustion, a guided tour – as in the present case – is helpful to not lose orientation! I wish that you, the reader, may find combustion, not only at a candle-light dinner or for a barbecue, a fascinating object for study, in spite or because of the many challenges presented by its use. I also hope that by understanding the fundamental principles and limitations of combustion better, the community might find suitable replacement strategies for the systems in use today to contribute to a more efficient and cleaner energy use in the near future.

Bielefeld, April 2013

Prof. Dr. Katharina Kohse-Höinghaus

Preface

Combustion, the source of comfort and fear, warmth as well as devastation, has always fascinated mankind. It has been and still is one of the most important and most widely used technologies. In 2010, the authors published the "Handbook of Combustion" [1], a five-volume reference work that was very well received by the scientific community. Soon the idea was born to distill the knowledge from the approximately 3200 pages into a digestible textbook for students.

This book is designed to be a compilation of up-to-date knowledge in the field of combustion in a way that even a reader from a different field of expertise can understand the basic principles and applications. The purpose of this textbook is to provide an introduction to combustion science and technology, spanning from fundamentals to practical applications. It deliberately does not dwell too much on the details, although the book aims at providing the necessary knowledge for those wishing to move further into the various sub-disciplines, such as energy efficiency, oxyfuel combustion, gasification, pollutant reduction, or combustion diagnostics.

This book is written not only for undergraduate and graduate students of chemistry, chemical engineering, materials science, engineering and related disciplines, but also for practitioners in the field.

Topics covered are:

- · History of combustion
- Fuels
- Combustion principles
- · Environmental impacts
- Measurement methods
- Applications
- Safety issues

Each chapter can be studied independently. For further reading, web resources are suggested at the end of each chapter.

XVI | Preface

The authors are proud to present this textbook and hope that it will serve many technicians, scientists and engineers throughout their studies and careers.

Vienna, June 2013

M. Lackner, A. B. Palotás, F. Winter

Reference

1 Lackner, M., Winter, F., and Agarwal, A.K. (eds) (2010) Handbook of Combustion, Wiley-VCH Verlag GmbH, Weinheim, 978-3527324491.

Contents

Foreword	XIII
Preface	XV

1 1.1 1.2 1.3 1.4	History of Combustion 1 Introduction 1 Timetable 3 Outlook 10 Web Resources 15 References 15
2	Fuels 19
2.1	Introduction 19
2.2	Gaseous Fuels 19
2.2.1	Density 21
2.2.2	Specific Heat Capacity 21
2.2.3	Molar Weight 22
2.2.4	Gas Constant 23
2.2.5	Thermal Conductivity 23
2.2.6	Viscosity 23
2.2.7	Heating Values 24
2.2.8	Ignition Temperature 25
2.2.9	Ignition Limits 26
2.2.10	Laminar Flame Velocity 26
2.2.11	Wobbe Index 27
2.2.12	Methane Number 28
2.3	Liquid Fuels 29
2.3.1	Chemical and Physical Characteristics 30
2.3.2	Sulfur Content 30
2.3.3	Ash Content 31
2.3.4	Water Content 31
2.3.5	Carbon Residue 31
2.3.6	Density and Specific Gravity 31
2.3.7	Viscosity 32

1	Contents	
•	2.3.8	Pour Point 32
	2.3.9	Cloud Point 32
	2.3.10	Flash Point 33
	2.4	Solid Fuels 33
	2.4.1	Origin of Solid Fuels 34
	2.4.2	Biomass 35
	2.4.3	Waste or Opportunity Fuels 36
	2.4.4	Coal 36
	2.4.5	Peat 37
	2.4.6	Solid Fuels Characterization 37
	2.4.7	Proximate Analysis 38
	2.4.8	Ultimate Analysis 39
	2.4.9	Physical Properties 41
		References 41
	3	Combustion Principles 43
	3.1	Basic Combustion Calculations 43
	3.1.1	Determination of the Quantity of Normal and Oxygenated Air
		Necessary for Complete Combustion 43
	3.1.1.1	Air Requirement of Gaseous Fuels 43
	3.1.1.2	Air Requirement for the Combustion of Liquid and Solid Fuels 45
	3.1.1.3	Calculations for the Case of Oxygenated Air 47
	3.1.2	Calculation of the Volume and the Composition of the Flue Gas 47
	3.1.2.1	Flue Gas of Gaseous Fuels 47
	3.1.2.2	Combustion Products of Liquid and Solid Fuels 48
	3.1.2.3	The Effect of Oxygen Enrichment 49
	3.1.2.4	Effect of Temperature and Pressure (Ideal Gas Law) 49
	3.1.2.5	Determination of the Actual Excess Air Factor 50
	3.1.3	Determination of the Combustion Temperature 51
	3.1.4	Heating Values 55
	3.1.5	Laminar Flame Velocity 56
	3.2	Heat-, Mass- and Momentum Transport and Balance 57
	3.2.1	Transport 57
	3.2.2	Mass Transport 58
	3.2.2.1	Diffusive Mass Transport 58
	3.2.2.2	Convective Mass Transport 58
	3.2.3	Mass Transfer 59
	3.2.4	Heat Transport 60
	3.2.4.1	Heat Conduction 60
	3.2.4.2	Thermal Radiation 61
	3.2.5	Heat Transfer 64
	3.2.6	Momentum Transport 65
	3.2.7	Balance 67
	3.2.7.1	Mass Balance 67
	3.2.7.2	Heat Balance 68

Momentum Balance 69
Elementary Reactions and Radicals 69
Elementary Reactions 69
Reaction Rates 70
Temperature Dependence 71
Collision Theory 72
Three-Body Reactions 73
Chemical Equilibrium 74
Gibbs Enthalpy 74
Radicals 75
Development and Analysis of a Set of Reactions 76
Simplification of a Set of Reactions 78
Ignition 79
Introduction 79
Autoignition 79
Induced Ignition 80
Theoretical Models for Ignition 82
Explosives 83
Flammability Limits 84
Minimum Ignition Energy 85
Quenching and Maximum Experimental
Safe Gap (MESG) 85
pT Explosion Diagram 87
Ignition Delay Time 89
Ignitability 90
Octane Number 91
Cetane Number 92
Ignition in Various Combustion Devices 93
Undesired Ignition 94
References 95
Environmental Impacts 97
Pollutants: Formation and Impact 97
Introduction 97
Description of Most Relevant Pollutants 98
Unburnt Hydrocarbons (UHC) 98
CO 99
NO _x 100
SO ₂ 102
Dioxins 102
Particulate Matter (PM) 103
Soot 106
Ash 110
Allcali Motola 110
Alkali Metals 110 Heavy Metals 111

VIII	Contents	
	4.1.3	Concepts for Pollutant Reduction 112
	4.1.4	Summary 117
	4.1.5	Web Resources 118
	4.2	Combustion and Climate Change 118
	4.2.1	Introduction 118
	4.2.2	Primary Energy Production 120
	4.2.3	Combustion and Global Warming by Sectors 120
	4.2.4	Mitigation of Global Warming in the Context
		of Combustion 121
	4.2.4.1	Energy Efficiency 121
	4.2.4.2	Reduction of CO ₂ Emissions 123
	4.2.4.3	Use of Renewable Fuels 123
	4.2.4.4	Other Measures Against Climate Change 126
	4.2.5	Carbon Sequestration 126
	4.2.6	Web Resources 128
		References 130
	5	Measurement Methods 137
	5.1	Introduction 137
	5.2	In Situ versus Ex Situ Measurements 139
	5.3	Fuel Characterization 140
	5.3.1	Proximate and Ultimate Analysis 140
	5.3.2	Thermal Analysis (TGA/DSC) 141
	5.3.3	Ash Melting 142
	5.3.4	Laminar Flame Speed 144
	5.4	Investigation of Combustion Processes 144
	5.4.1	Selection of Non-optical Methods 145
	5.4.1.1	Suction Probe Coupled with GC/MS 145
	5.4.1.2	Hot Wire Anemometry 146
	5.4.1.3	Thermocouple 147
	5.4.1.4	Gas Potentiometric Sensors 147
	5.4.1.5	Paramagnetic Analyzer for O ₂ 148
	5.4.2	Selection of Optical Techniques 149
	5.4.2.1	Chemiluminescence 149
	5.4.2.2	Schlieren Photography 150
	5.4.2.3	Non-Dispersive Infrared Spectrometer 150
	5.4.2.4	Fourier Transform Infrared Spectrometer 151
	5.4.2.5	Laser-Induced Absorption Techniques 153
	5.4.2.6	Laser-Induced Emission Techniques 157
	5.4.2.7	Laser-Induced Scattering Techniques 159 Particle Diagnostics 162
	5.4.3 5.4.4	8
	5.4.5	1 / 8
	5.4.6	Other Techniques 164 Test Beds 164
	5.4.6.1	Open Flames on Laboratory Model Burners 164
	J.T.U.1	open manies on Laboratory Model Bufflers 104

5.4.6.2	Combustion Bombs 168
5.4.6.3	Shock Tubes 168
5.4.6.4	Optical Engines 169
5.4.6.5	Pilot Plants 171
5.4.6.6	Combustors Placed on a Test Rig 172
5.4.6.7	Industrial Furnaces with Optical Access Ports 172
5.4.7	Advanced Combustion Control 174
	References 176
6	Applications 185
6.1	Burners 185
6.1.1	The Evolution of Combustion Processes 185
6.1.2	The Flame 185
6.1.3	Fuel Preparation, Pre-Processing 186
6.1.4	Requirements of a Burner 187
6.1.5	Burner Classification by the Fuel Used 188
6.1.6	Burner Categories 189
6.1.6.1	Classification Methods for Gas Burners 189
6.1.6.2	Generalized Classification of Gas Burners 191
6.1.7	Burner Control, Automation 193
6.1.8	Flares 193
6.1.9	Categorization of Oil Burners 195
6.1.10	Atomization of the Fuel 196
6.1.11	Mixed Fuel and Alternative Burners 197
6.2	Industrial Boilers 198
6.2.1	Firing Systems for Steam Generation 200
6.2.2	Fixed Bed Combustion 202
6.2.3	Fluidized Bed Combustion (FBC) 206
6.2.3.1	Bubbling Fluidized Bed Combustion (BFBC) 207
6.2.3.2	Circulating Fluidized Bed Combustion (CFBC) 208
6.2.3.3	Dust Firing 210
6.2.4	Summary of Combustion Technologies for Boilers 212
6.3	Industrial Technologies 213
6.3.1	Characteristics of Industrial Heating Installations
	and Furnaces 213
6.3.2	Metal Industry 214
6.3.2.1	Shaft Furnaces 214
6.3.2.2	Aluminum Melting Furnaces 214
6.3.2.3	Crucible Furnaces 216
6.3.2.4	Annealing and Heat Treatment Furnaces 216
6.3.3	Ceramic Industry 218
6.3.3.1	Glass Melting Furnaces 218
6.3.4	Furnaces Used in Various Industries 220
6.3.4.1	Cylindrical Rotary Kilns 220
6.3.4.2	Chamber Furnaces 221

v ı	Cautauta	
×	Contents	
	6.3.4.3	Indirectly Fired Chamber Furnaces 221
	6.3.5	Heat Treatment Systems, Heat Treatment Furnace Plants 222
	6.3.5.1	Complex Heat Treatment Systems 222
	6.3.5.2	Continuous Heat Treatment Furnace Plants 223
	6.3.6	Petroleum Industry Tube Furnaces 223
	6.3.7	Internal Combustion Engines 223
	6.3.7.1	Introduction 223
	6.3.7.2	Four-Stroke Engines 224
	6.3.7.3	Two-Stroke Engines 225
	6.3.7.4	Spark Ignition Engines 226
	6.3.7.5	Compression Ignition Engines 227
	6.3.7.6	Cycle Analysis and Key Parameters 228
	6.3.7.7	Ideal Air Standard Otto Cycle 229
	6.3.7.8	Ideal Air Standard Diesel Cycle 230
	6.3.7.9	Engine Emissions 231
	6.3.8	Gasification and Pyrolysis 231
	6.3.8.1	Introduction to Gasification and Industrial Applications 231
	6.3.8.2	Fuel Conversion During Gasification 232
	6.3.8.3	Gasification Chemistry and Reactions 234
	6.3.8.4	Gasification Technologies 235
		References 239
	7	Safety Issues 241
	7.1	Introduction 241
	7.2	Fundamentals 241
	7.3	Fire Classes 243
	7.4	Working Mechanism of Fire Extinguishing Media 244
	7.5	Fire Detectors 245
	7.6	Deflagrations and Detonations 245
	7.7	Dust Explosions 247
	7.8	Legal Framework: Example of ATEX in Europe 248
	7.9	Preventing and Mitigating the Effect of Explosions in Industry 252
	7.10	Aspects of Preventive Fire Protection 253
	7.10.1	Flame Retardants Containing Phosphorus 253
	7.10.2	Flame Retardants Based on Hydroxides of Al and Mg 254
	7.10.3	Organic, Halogen-Containing Compounds 254
	7.10.4	Intumescence-Based Systems 254
	7.11	Fire Suppression by Oxygen Reduction 255
	7.12	Safety by Process Design 255
	7.13	Other Important Terms Related to Fire Safety 256
	7.13.1	Flashover 256
	7.13.2	Loss-of-containment and Fires 256
	7.13.3	Flammable Substance Release 257
	7.13.3.1	Boiling Liquid Expanding Vapor Explosion (BLEVE) and Vapor Cloud Explosion (VCE) 257

7.13.4	Burning Index (Danger Class, Rating)	258
7.13.5	K Value (K_G , K_{ST}) 258	
7.13.6	Dust Explosion Class 258	
7.13.7	Explosion Pressure 259	
7.13.8	Limiting Oxygen Concentration (LOC) References 260	259

Index 261