CALCIUM LOOPING CAPTURE IN THE CEMENT INDUSTRY – CEMCAP CONCLUSIONS

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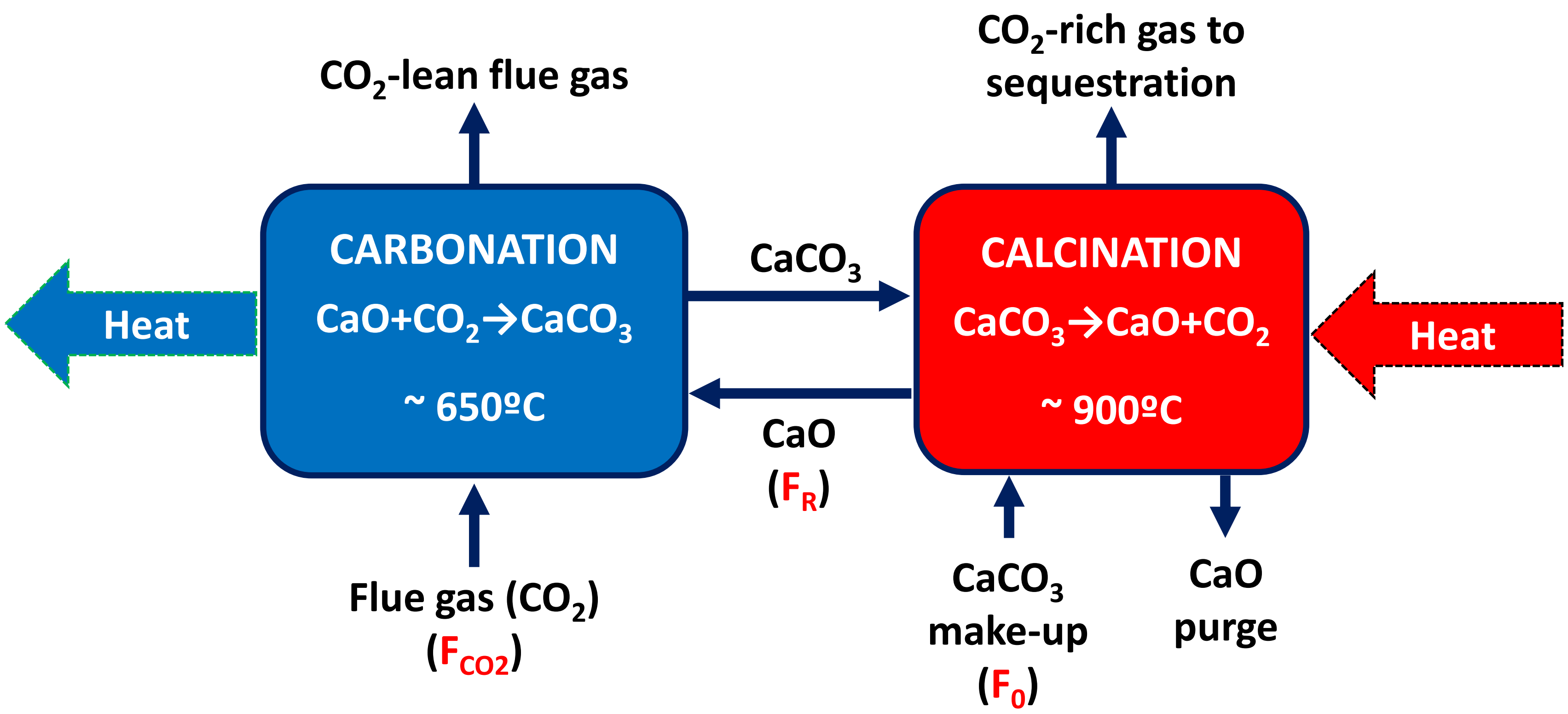
2nd ECRA/CEMCAP/CLEANKER workshop: Carbon Capture Technologies in the Cement Industry
Brussels, 17 October 2018

Calcium Looping process fundamentals



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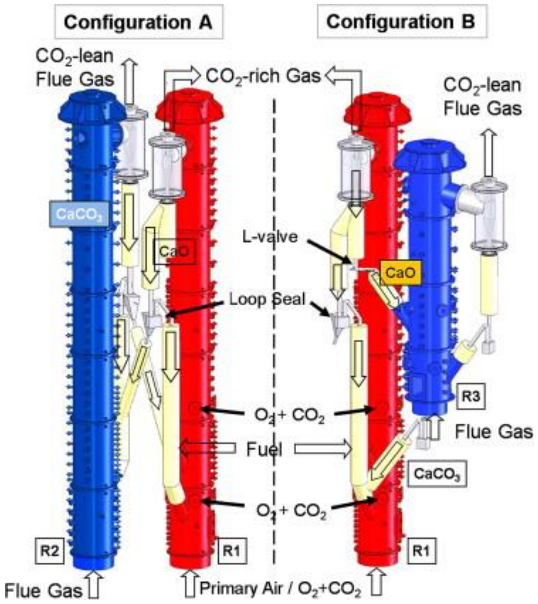
Calcium Looping for CO_2 capture: history

- Originally proposed by Shimizu et al., 1999. A twin fluid-bed reactor for removal of CO_2. Chem. Eng. Res. Des., 77.
- Continuously developed since 1998, mainly for application in power plants
- Several fluidized bed pilot facilities - demonstrated up to 1.7 MW

200 kW pilot at IFK, U. Stuttgart



1 MW pilot at TU Darmstadt

1.7 MW pilot at La Pereda (ES)

Calcium Looping for cement plants

1. Cement plant-power plant coupling: CaO-rich spent sorbent from a CaL power plant as feed for the cement plant, as substitute of $CaCO_3$

CEMCAP focus

2. Post-combustion "tail end" configuration: CaL process is integrated in the cement plant with a conventional post-combustion capture configuration

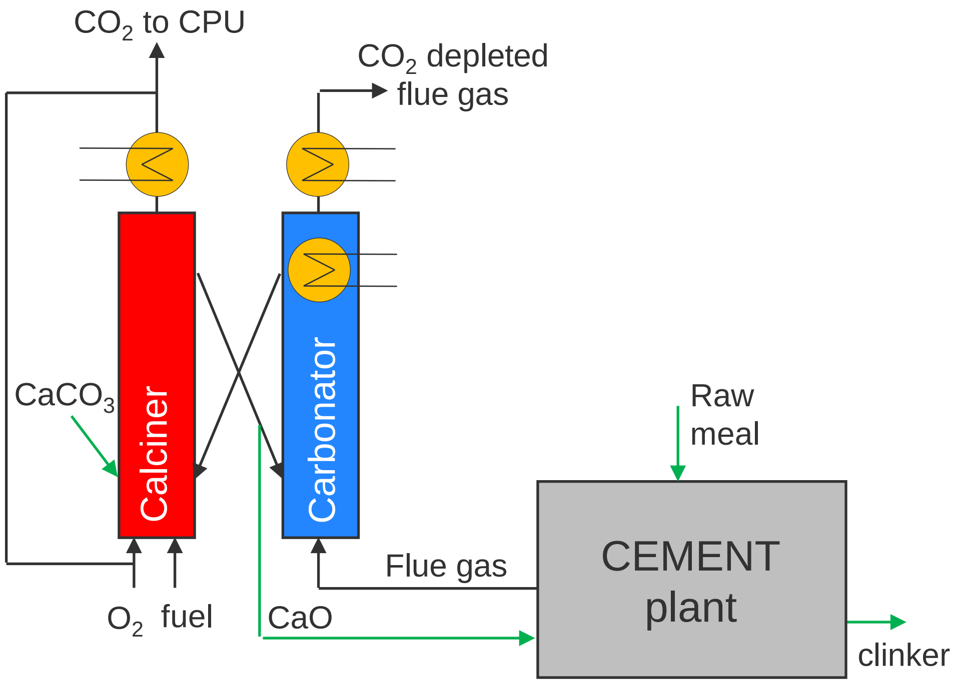
CLEANKER focus

3. Integrated CaL configuration: the CaL process is integrated within the cement production process by sharing the same oxyfuel calciner

Calcium Looping CO_2 capture: Tail-end CaL configuration

<u>General features of the process:</u>

- Carbonator removes CO_2 from cement plant flue gas
  → Easy integration in existing cement
- Limestone partly calcined in Calcium Looping calciner
  → CaO-rich purge from CaL calciner used as feed for the cement kiln
- High fuel consumption (double calcination for the mineral CO_2 captured)



- Heat from fuel consumption recovered in efficient (~35% efficiency) steam cycle for power generation
- CFB CaL reactors: d_{50}=100-250 µm, vs. particle size for clinker production d_{50}=10-20 µm
  → CaL purge milled in the raw mill at low temperature

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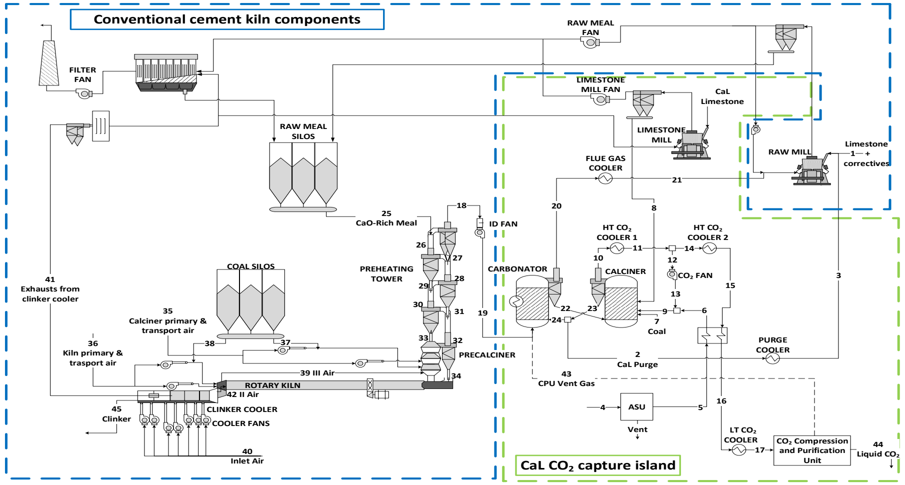
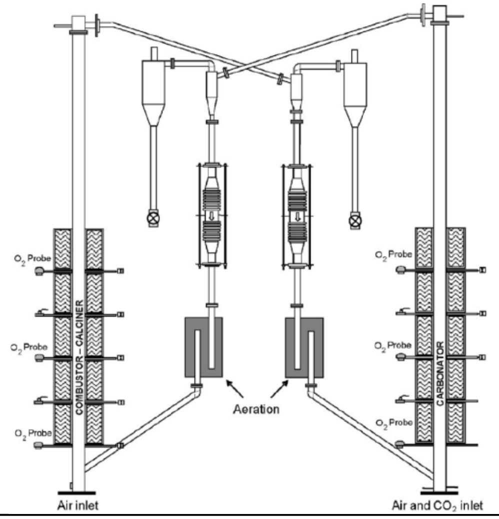
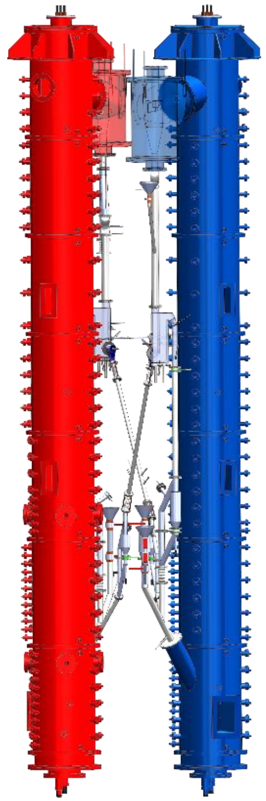
Calcium Looping CO_2 capture: Tail-end CaL configuration

<u>Conducted Work:</u>

- Parameter screening at 30 kW scale at CSIC (TRL5)
- Demonstration at semi-industrial scale (200 kW_{th}) at IFK (TRL6)
- Process integration study and techno-economic analysis







Arias et al., 2017. CO_2 Capture by CaL at Relevant Conditions for Cement Plants: Experimental Testing in a 30 kW Pilot Plant. *Ind. Eng. Chem. Res.*, 56, 2634–2640.

Hornberger et al., 2017. CaL for CO_2 Capture in Cement Plants – Pilot Scale Test. *Energy Procedia*, 114, 6171–6174.

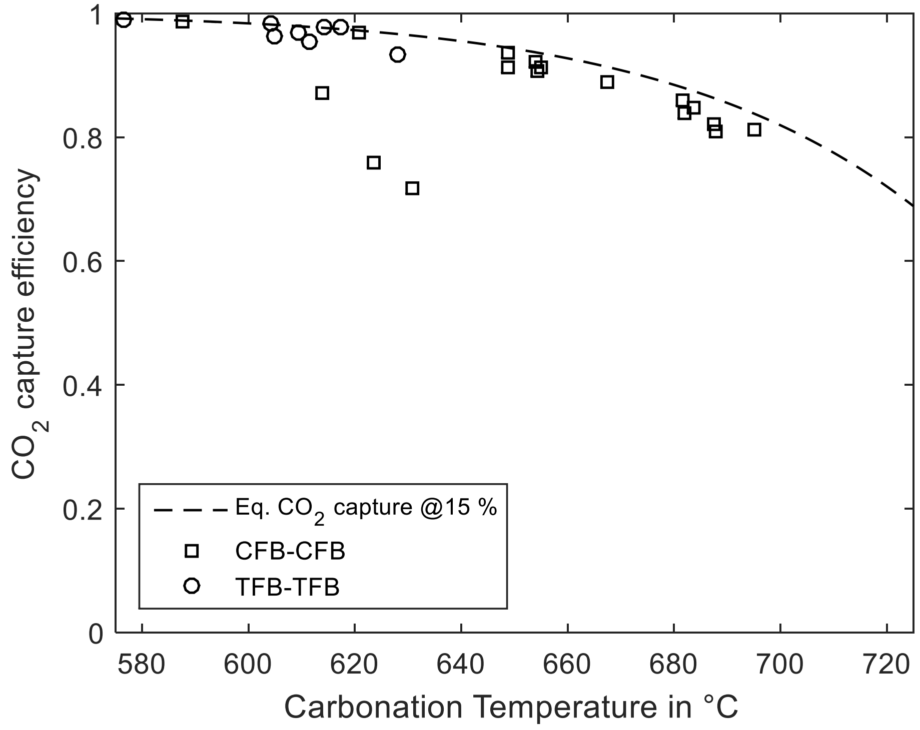
Spinelli et al., 2017. Integration of CaL systems for CO_2 capture in cement plants. *Energy Procedia, 114, 6206-6214.*

De Lena et al., 2017. Process integration of tail-end CaL in cement plants. *Int J Greenh Gas Control. 67, 71-92.*

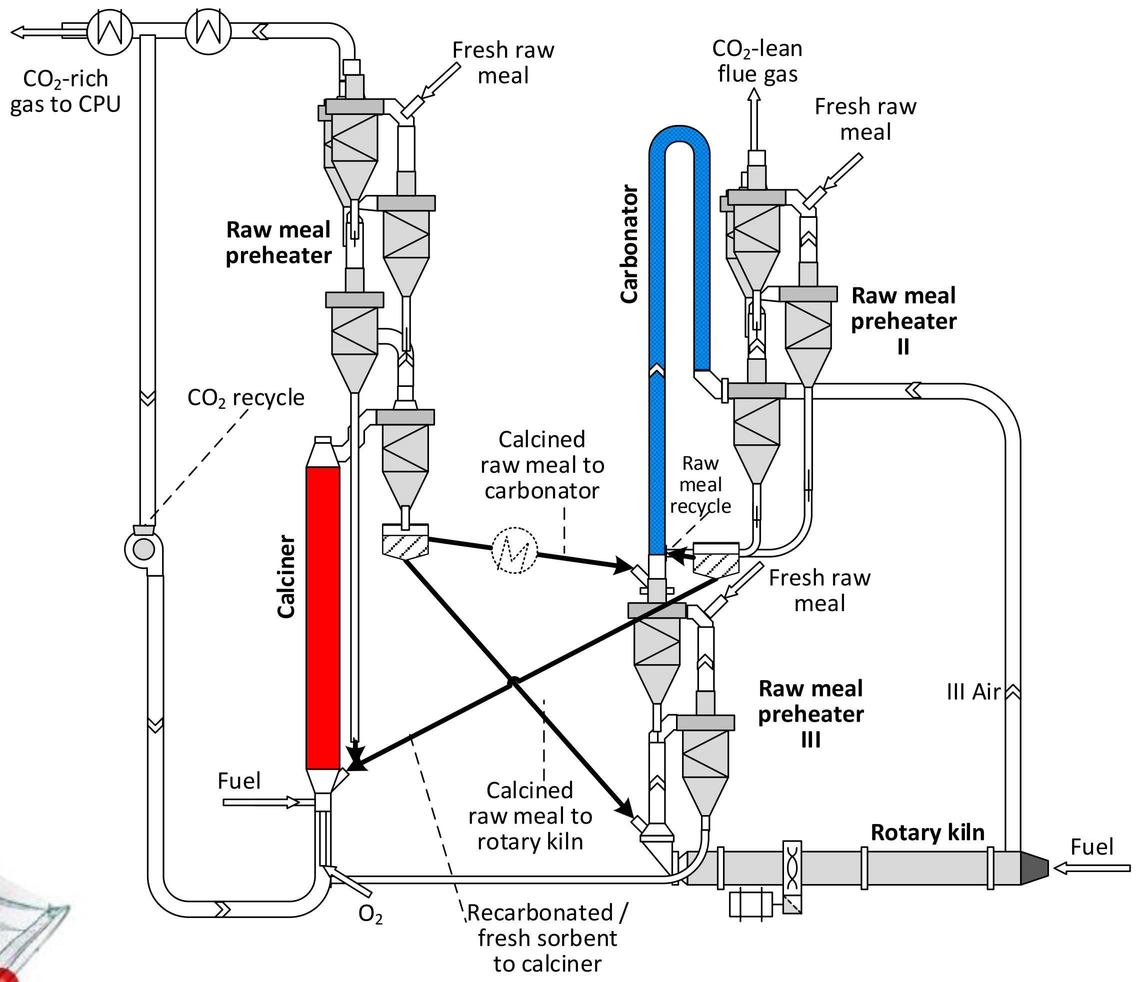
Calcium Looping CO_2 capture: Tail-end CaL configuration

Demonstration at semi-industrial scale:

- High CO_2 capture up to 98 % demonstrated in TRL6 facility
- The CaL design parameters for cement plant applications are in good agreement with the design parameters for power plant operation.
- Tail-end CaL ready for demonstration at TRL7-8.



Calcium Looping CO_2 capture: integrated configuration



General information:

- CaL calciner coincides with the cement kiln pre-calciner
- Calcined raw meal as CO_2 sorbent in the carbonator
- Sorbent has small particle size (d_{50}=10-20 μm) → entrained flow reactors

Marchi M.I., et al., 2012. Procedimento migliorato per la produzione di clinker di cemento e relativo apparato. *Patents MI2012 A00382 and MI2012 A00382.*

Romano et al., 2014. The calcium looping process for low CO_2 emission cement plants. *Energy Procedia, 61, 500-503*.

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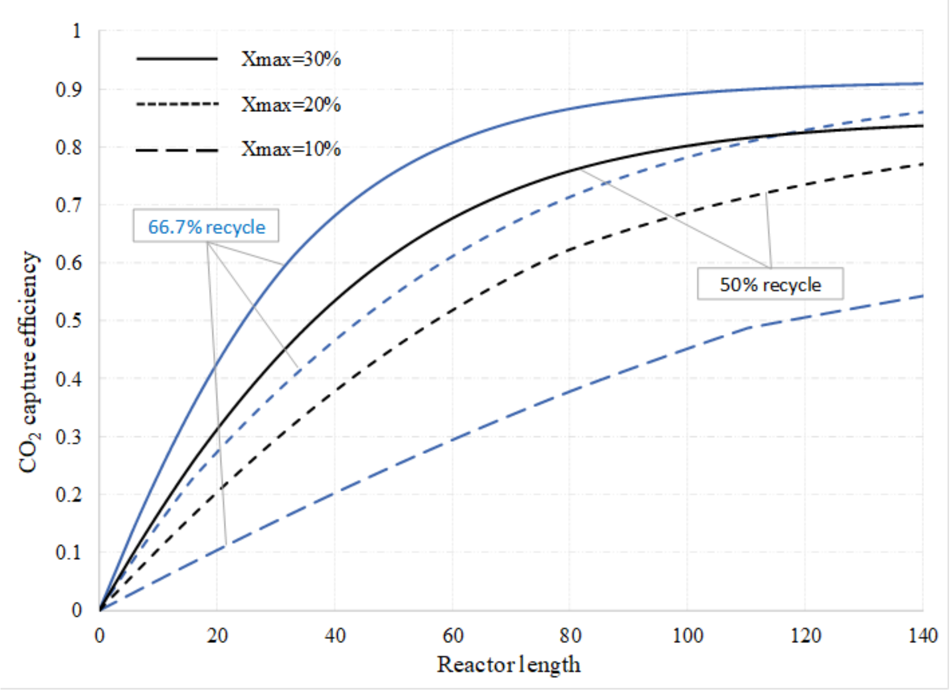
Calcium Looping CO_2 capture: integrated configuration

Development of integrated CaL concept using entrained flow calciner/carbonator:

- 1D carbonator modelling showed possibility of achieving high capture efficiency with solids/gas ratio of ~10 kg/Nm^3.
- Belite formation in calciner may cause a decrease of the sorbent CO_2 carrying capacity.
- Demonstration of chemistry and fluid-dynamics of the reactors in industrially relevant conditions needed.



Alonso et al., 2018. Capacities of Cement Raw Meals in Calcium Looping Systems. *Energy & Fuels*, 31, 13955–13962.

Spinelli et al., 2018. One-dimensional model of entrained-flow carbonator for CO_2 capture in cement kilns by calcium looping process. *Chemical Engineering Science, 191, 100-114.*

Mass and energy balance

	Cement plant w/o capture	Tail-end CaL (20% integration)	Tail-end CaL (50% integration)	Integrated CaL
Carbonator CO_2 capture efficiency [%]	--	88.8	90.0	82.0
Total fuel consumption [MJ_{LHV}/t_{clk}]	3240	8720	7100	5440
Rotary kiln fuel consumption [MJ_{LHV}/t_{clk}]	1230	1220	1220	1150
Pre-calciner fuel consumpt. [MJ_{LHV}/t_{clk}]	2010	1550	850	4290
CaL calciner fuel consumpt. [MJ_{LHV}/t_{clk}]	--	5950	5040	
Net electricity consumpt. [kWh_{el}/ t_{cem}]	**97**	**-81**	**42**	**117**
Direct CO_2 emissions [kg_{CO2}/t_{clk}]	865	119	79	55
Indirect CO_2 emissions [kg_{CO2}/t_{clk}] *	35	-29	15	46
Equivalent CO_2 emissions [kg_{CO2}/t_{clk}]	900	90	94	101
Equivalent CO_2 avoided [%]	--	90.0	89.5	88.8
SPECCA [MJ_{LHV}/kg_{CO2}] **	--	4.42	4.07	3.16

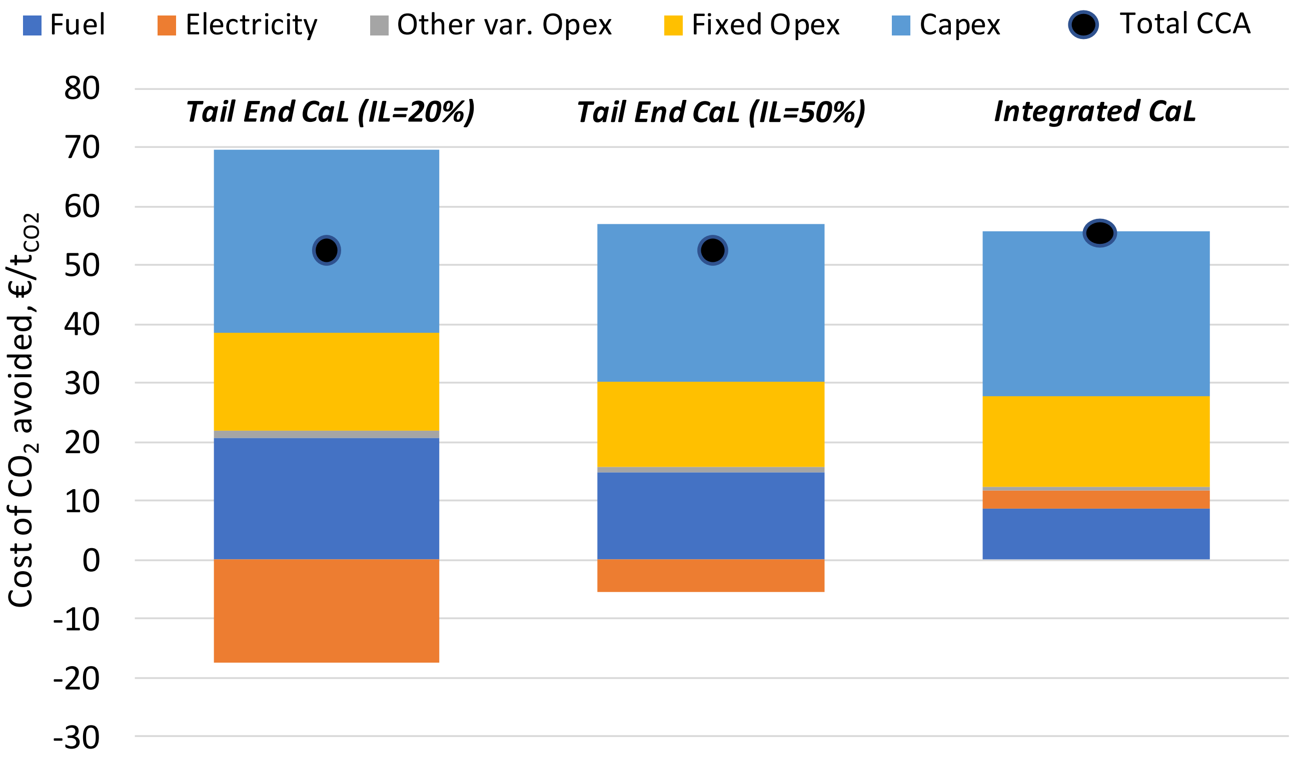
** Evaluated with the average EU-28 electricity mix: η_e = 45.9%, $E_{CO2,e}$ = 262 kg/MWh*

*** Specific primary energy consumption for CO_2 avoided*

De Lena et al., 2017. Process integration of tail-end CaL in cement plants. *Int J Greenh Gas Control. 67, 71-92.*

Economic analysis

Cost of CO_2 avoided = 50-55 €/t_{CO2}, mainly due to Capex.



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Conclusions and outlook

Ca-LOOPING PROCESS INTEGRATION OPTIONS:

1. Post-combustion capture configuration:
   - Low uncertainty in the technical feasibility ✓
   - Very high CO_2 capture expected ✓
   - Two calciners are present in the system, leading to high fuel consumptions ✗
2. Integrated CaL configuration:
   - High CO_2 capture efficiency without modifying rotary kiln operation (no need of kiln oxyfiring). ✓
   - Higher thermal efficiency and lower fuel consumptions ✓
   - New carbonator design and fluid-dynamic regime: fluid-dynamics, heat management and sorbent performance need validation ✗

– Competitive cost of CO_2 avoided. ✓

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Acknowledgements

This project has received funding from the European Union's Horizon 2020 research and innovation programme under grant agreement no 641185

This work was supported by the Swiss State Secretariat for Education, Research and Innovation (SERI) under contract number 15.0160

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