Title: NOX REMOVAL IN JET-ENGINE TEST CELL EXHAUST: PROPOSED NON-THERMAL PLASMA SYSTEMS AND ECONOMIC CONSIDERATIONS

Author(s): Louis A. Rosocha, LANL/P-24
Jen-Shih Chang, Kuniko Urasima, and Seock J. Kim
McMaster University,
Andrzej W. Miziolek, Michael J. Nusca, and Robert G. Daniel
US Army Research Laboratory,
Robert F. Huie and John T. Herron
National Institute of Standards and Technology

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Incentives for implementing new pollution-control technologies are both regulatory and economic. Given considerable regulatory pressure, e.g., the promulgation of a NESHAPS (National Emissions Standard for Hazardous Air Pollutants) for NOx emissions in CY 2000, new de-NOx technologies are being explored. One major reason for this is that conventional de-NOx methods (like wet scrubbers plus Selective Catalytic Reduction –SCR) will not work effectively for the low NO concentrations (e.g., < 50 ppm), high exhaust-gas flow rates (~10⁶ Nm³/h), and low gas temperatures (near ambient) characteristic of Jet Engine Test Cells (JETCs). Our project is currently evaluating non-thermal plasma (NTP) technologies for treating jet-engine exhaust and other hazardous air pollutants. In this paper, we will present our initial design options for NTP reactor systems for a field-pilot demonstration on small jet engines (e.g., F107 or F112; flow rates ~ 10⁶ Nm³/h). The field-pilot demonstration is necessary to provide further data and operating experience to more fully evaluate economic and performance projections for NTP de-NOx technology and to design larger systems with confidence.
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the US Strategic Environmental Research & Development Program (SERDP)
for support for this work.

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Outline of talk

- Motivation for and applications of research
- Background of atmospheric-pressure, non-thermal plasma processing for environmental applications (air-pollution control)
  - Basics of radical formation & decomposition chemistry
  - Figures-of-merit & costs for decomposition of example pollutants
- Removal of NO\textsubscript{x} and VOCs from jet-engine test facilities
  - Plans for field demonstration of pilot unit
  - Candidate NTP systems
  - Economic considerations (candidate systems compared to conventional)
- Future trends
- Summary

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Technology-development motivators are regulatory, economic, and social

**Regulatory**
- New and/or more stringent regulations
  - Clean Air Act Amendment of 1990, Clean Water Act
  - Attendant MACT standards
- Enforcement of regulations

**Economic**
- Impact of regulations
- Costs associated with conventional methods

**Social**
- Environmental consciousness
- Health risks
The CAAA 1990 contains three titles closely related to NTPs:

<table>
<thead>
<tr>
<th>Title III (Air Toxics)</th>
<th>Title IV (Acid Rain)</th>
<th>Title VI (Stratospheric Ozone)</th>
<th>MACT (Max Achievable Control Technology) Standards</th>
</tr>
</thead>
<tbody>
<tr>
<td>Directly concerned with emission of hazardous air pollutants (HAPs)</td>
<td>Established standards for 189 listed chemicals</td>
<td>Reduction of SOx/NOx emissions</td>
<td>Calls for state-of-art pollution control equipment</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Phase out of VOCs</td>
<td>Require changes in equipment, processes, treatment</td>
</tr>
</tbody>
</table>
Regulations for engine test facilities are changing under CAAA 1990 10-yr provisions

- Previously, engine test facilities were considered mobile sources because engines were moved in and out of the facilities for testing operations. However, the test facility itself was usually a permanent structure.

- The upcoming new standards will consider the test facilities as stationary sources, which are regulated differently (more stringently) than mobile sources.

- The test-facility emissions (primarily NO\textsubscript{x} and volatile organic compounds - VOCs) have dilute concentrations (e.g., < 50 ppm) and very high (~ 10\textsuperscript{6} - 10\textsuperscript{7} Nm\textsuperscript{3}/h) exhaust-gas flows.

- Consequently, new emissions-control technologies are being explored.

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Non-thermal plasmas (NTPs) are a type of advanced oxidation & reduction process which use free radicals to decompose pollutants in the gas phase.

<table>
<thead>
<tr>
<th>Non-thermal plasmas are a type of AOP making use of “cold combustion” via free-radical reactions. Electrons are energetic (<em>hot</em>), while neutral &amp; ions are at near-ambient temperatures (<em>cold</em>).</th>
<th>Applications</th>
</tr>
</thead>
</table>
| The key idea is to direct electrical energy into favorable chemistry for oxidizing and/or reducing pollutants to more manageable forms (simpler or mineralized terminal products). | • Flue gases & engine emissions: e.g., NO\textsubscript{x} & SO\textsubscript{x}  
• VOCs: e.g., hydrocarbons & halocarbons  
• Odors: H\textsubscript{2}S, others | |

| Potential Advantages |
|---|---|
| • In-situ generation of chemical reactants  
• No added fuel (greenhouse gases)  
• Simultaneous removal of multiple pollutant species  
• Electronic feedback for optimal process control. | |

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Non-thermal Plasmas Decompose Pollutants Via Active Species Generated in the Process Gas

Influent Stream (w/pollutants) → Electrical Energy → Plasma & active species (e.g., free radicals) → Effluent Stream (w/decomposed pollutants, simpler compounds)
The radical production efficiency (G-value) depends on the gaseous electronics/plasma chemistry.

\[ G = f \left( \frac{k_{rad}}{\frac{E}{V_d \frac{N}{N}}} \right) \]

- Radical generation is mainly initiated by energetic-electron collisions,
- E/N is the reduced field,
- V_d is the electron drift velocity, which depends on E/N,
- k_{rad} is the rate constant for radical formation (e.g., a dissociation rate constant, which depends on E/N), and/or other rate constants.
The overall process efficiency can be effectively separated into two terms: the radical production efficiency and the radical utilization efficiency.

\[ \eta_{\text{net}} = G_R \eta_u \]

- \(G_R\) is the radical-production efficiency (mainly depends on gaseous electronics/plasma chemistry)
- \(\eta_u\) is the radical utilization efficiency (mainly depends on chemical kinetics)
Gas-phase plasma chemical decomposition is driven by electron impact and radical attack.

\[
\begin{align*}
(1) & \quad e + X \rightarrow \text{products} \\
(2) & \quad \text{O, OH, N, etc.} + X \rightarrow \text{products}
\end{align*}
\]

- The first reaction is dominant at large pollutant mole fractions.
- The second dominates at smaller mole fractions.

(More energy is directly absorbed by pollutant at high mole fraction, hence electron channel dominates.)

Plasma chemical decomposition of VOCs produces a variety of terminal products.

\[
e, \text{O, OH, N, etc.} + X \rightarrow \text{products}
\]

- **Manageable products:** $\text{CO}_2$, $\text{CO}$, $\text{Cl}_2$, HCl, COCl$_2$
- **Undesirable products:** Other halocarbons, hazardous byproducts (e.g., DCAC - CHCl$_2$COCl); polymers
- **Secondary treatment:**
  \[
  \begin{align*}
  \text{CO}_2 + \text{NaOH} & \rightarrow \text{NaHCO}_3 \\
  \text{CO} + \text{catalyst} & \rightarrow \text{CO}_2 \\
  \text{Cl}_2 + \text{NaHCO}_3 & \rightarrow \text{NaCl} + \text{HCl} + \ldots \\
  \text{HCl} + \text{NaOH} & \rightarrow \text{NaCl} + \text{H}_2\text{O} \\
  \text{COCl}_2 + \text{H}_2\text{O} & \rightarrow 2\text{HCl} + \text{CO}_2
  \end{align*}
  \]

---

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Major de-NO\textsubscript{x} Reactions in Moist Gas Mixtures w/o HCs

\[
\begin{align*}
O + NO + M & \rightarrow NO_2 + M \\
O + NO_2 & \rightarrow NO + O_2 \\
O + N_2 & \rightarrow NO + N \\
O + O_2 + M & \rightarrow O_3 + M \\
O_3 + NO & \rightarrow NO_2 + O_2 \\
O_3 + NO_2 & \rightarrow NO_3 + O_2 \\
NO_2 + NO_3 + M & \rightarrow N_2O_5 + M \\
N(^{2}\text{D}) + O_2 & \rightarrow NO + O \\
N + NO & \rightarrow N_2 + O \\
N(^{2}\text{D}) + NO & \rightarrow N_2 + O(^{1}\text{D}) \\
N + NO_2 & \rightarrow N_2O + O \\
N + NO_2 & \rightarrow 2NO \\
N(^{2}\text{D}) + H_2O & \rightarrow NH + OH \\
NH + NO & \rightarrow N_2 + OH \\
NH + O_2 & \rightarrow NO + OH \\
NO + NO_3 & \rightarrow 2NO_2 \\
NO + OH + M & \rightarrow HNO_2 + M \\
OH + HNO_2 & \rightarrow NO_2 + H_2O \\
OH + NO_2 + M & \rightarrow HNO_3 + M \\
N + NO_2 & \rightarrow N_2 + O_2 \\
N + N_2O & \rightarrow NO + N_2 \\
O(^{1}\text{D}) + NO_2 & \rightarrow NO + O_2 \\
O(^{1}\text{D}) + N_2O & \rightarrow 2NO \text{ or } N_2 + O_2 \\
N_2(A) + O_2 & \rightarrow N_2 + 2O \\
N_2(A) + N_2O & \rightarrow N_2 + N + NO
\end{align*}
\]

Primary Acid-Formation Pathways:

\[
\begin{align*}
NO + OH + M & \rightarrow HNO_2 + M \\
OH + NO_2 + M & \rightarrow HNO_3 + M
\end{align*}
\]
The presence of $\text{SO}_2$ recycles OH radicals & reduces effective de-$\text{NO}_x$ energy cost

$$\text{OH} + \text{SO}_2 + \text{M} \rightarrow \text{HSO}_3 + \text{M}$$

$$\text{HSO}_3 + \text{O}_2 \rightarrow \text{HO}_2 + \text{SO}_3$$

$$\text{HO}_2 + \text{NO} \rightarrow \text{NO}_2 + \text{OH}$$

The OH radical then goes on to be used again in de-$\text{NO}_x$

$$\text{OH} + \text{NO} + \text{M} \rightarrow \text{HNO}_2 + \text{M}$$

$$\text{OH} + \text{HNO}_2 \rightarrow \text{NO}_2 + \text{H}_2\text{O}$$

$$\text{OH} + \text{NO}_2 + \text{M} \rightarrow \text{HNO}_3 + \text{M}$$

Acid is also formed by the reaction

$$\text{HSO}_3 + \text{H}_2\text{O} \rightarrow \text{H}_2\text{SO}_4$$

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With ammonia ($\text{NH}_3$) addition, useful particulates (fertilizer) can be formed from $\text{NO}_x$

\[
e + \text{NH}_3 \rightarrow \text{NH}_2 + \text{H} + \text{e}
e + \text{NH}_2 \rightarrow \text{NH} + \text{H} + \text{e}
\text{NH + H} \rightarrow \text{N} + \text{H}_2
\text{NH}_2 + \text{NO} \rightarrow \text{N}_2 + \text{H}_2\text{O}
\text{NH + NO} \rightarrow \text{N}_2 + \text{OH}
\text{N + NO} \rightarrow \text{N}_2 + \text{O}
\[
\text{OH + NH}_3 \rightarrow \text{NH}_2 + \text{H}_2\text{O}
\text{OH + NO + M} \rightarrow \text{HNO}_2 + \text{M}
\text{OH + HNO}_2 \rightarrow \text{NO}_2 + \text{H}_2\text{O}
\text{OH + NO}_2 + \text{M} \rightarrow \text{HNO}_3 + \text{M}
\text{NH}_3 + \text{HNO}_3 \rightarrow \text{NH}_4\text{NO}_3 \quad (\text{Ammonium Nitrate fertilizer})
A generalized removal equation depends on plasma chemistry (radical yields), reaction chemistry, and applied plasma specific energy.

Generalized differential equation:

\[ \frac{k[X] + \sum_i k_{S_i} [S_i]}{k[X]} d[X] = -G d\bar{E} \]

Integration with limits \([X]_0 \to [X]\) and \(0 \to \bar{E}\) gives:

\[ \frac{[X]}{[X]_0} + \frac{\sum_i k_{S_i} [S_i]}{k [X]_0} \ln \frac{[X]}{[X]_0} - 1 = -\frac{G \bar{E}}{[X]_0} \]

For low degree of removal (i.e., \([X]/[X]_0 \approx 1 + \ln \{ [X]/[X]_0 \} \)), an analytical solution is obtained:

\[ \frac{[X]}{[X]_0} = \exp \left( -\frac{\bar{E}}{\beta} \right) \]

where

\[ \beta = \frac{1}{G} \left( \frac{\sum_i k_{S_i} [S_i]}{k} + [X]_0 + \frac{\sum_i k_{S_i} [S_i]}{k} \right) \]

When \(k[X] \ll \sum_i k_{S_i} [S_i]\), the \(\beta\)-value and, hence the degree of removal \([X]/[X]_0\) shows no dependence on the initial concentration \([X]_0\).
Example scaling laws for pollutant removal
(non-sensitive [X]₀ dependence)

(1) \( [X] = [X]₀ \exp \left( - \frac{\bar{E}}{\beta} \right) \),

where \([X]₀\) is the initial pollutant concentration, \([X]\) is the resulting concentration, \(\bar{E}\) is the applied specific energy (or plasma power divided by gas flow rate, \(P/Q\)), and \(\beta\) is the e-fold energy density. Supplying one \(\beta\) to the reactor reduces the concentration by \(1/e\), \(2\beta\) by \(1/e^2\), and so on.

A useful figure of merit for the decomposition of pollutants is defined by the energy delivered to the plasma per hazardous molecule removed from the gas stream. At any instant, this can be expressed as the following quantity obtained by solving Equation 1 for \(\bar{E}\) and taking the derivative:

\[
\gamma_i = -\frac{d\bar{E}}{d[X]} = -\frac{d[-\beta \ln \left( \frac{[X]}{[X]₀} \right) ]}{d[X]} = \frac{\beta}{[X]}. 
\]

This is the instantaneous energy cost per molecule removed.
Scaling laws for pollutant removal (cont’d)

A more practically-useful parameter is the integral, or average, energy cost $\gamma$

\[
\gamma = \frac{\bar{E}}{[X]_0 - [X]} = \frac{-\beta \ln\left(\frac{[X]}{[X]_0}\right)}{[X]_0 \left(1 - \frac{[X]}{[X]_0}\right)} \quad (= \beta/[X]_0 \text{ at optimum; i.e., } [X]/[X]_0 \sim 1).
\]

Here, the energy cost per molecule is expressed in terms of the $\beta$-value, the degree of removal, and the initial concentration.

When radical-pollutant attack dominates $\beta \approx [X]_0/G$ and the removal cost is then independent of the initial concentration

\[
\gamma = \frac{\bar{E}}{[X]_0 - [X]} = \frac{-\ln\left(\frac{[X]}{[X]_0}\right)}{G \left(1 - \frac{[X]}{[X]_0}\right)} \quad (= 1/G \text{ at optimum; i.e., } [X]/[X]_0 \sim 1).
\]

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Scaling laws for pollutant removal (graphical forms)

Energy costs and degree of removal for NO removal in an NO-air mixture with one e-fold plasma specific energies of 50 J/liter and 20 J/liter. NO is a compound whose β-value is not very sensitive to the initial concentration; therefore, the removal energy costs decrease as the concentration increases (note 200 ppm case vs 100 ppm case).

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NTP pilot-unit setup for de-NOx field tests
## Expected exhaust-gas data and conditions

<table>
<thead>
<tr>
<th>Source Data</th>
<th>Variable</th>
<th>Units</th>
<th>JETC Values</th>
<th>CMTC Values</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gas Flow</td>
<td>$Q_{gas}$</td>
<td>Nm$^3$/h</td>
<td>1.0E+05</td>
<td>6.6E+03</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>1.7E+06</td>
<td>1.3E+04</td>
</tr>
<tr>
<td>Fuel</td>
<td></td>
<td></td>
<td>JP-8</td>
<td>JP-10</td>
</tr>
<tr>
<td>Final Exhaust-Gas Composition</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>$N_2$</td>
<td>$C_{N_2}$</td>
<td>%</td>
<td>80.98</td>
<td>78.00</td>
</tr>
<tr>
<td>$O_2$</td>
<td>$C_{O_2}$</td>
<td>%</td>
<td>18.00</td>
<td>21.00</td>
</tr>
<tr>
<td>$CO_2$</td>
<td>$C_{CO_2}$</td>
<td>%</td>
<td>0.50</td>
<td>0.50</td>
</tr>
<tr>
<td>$H_2O$</td>
<td>$C_{H_2O}$</td>
<td>%</td>
<td>0.50</td>
<td>0.50</td>
</tr>
<tr>
<td>Density (Normal)</td>
<td>$D_{gas}$</td>
<td>kg/Nm$^3$</td>
<td>1.283</td>
<td>1.283</td>
</tr>
<tr>
<td>Exhaust Gas Temperature</td>
<td>$T_{gas}$</td>
<td>C</td>
<td>25</td>
<td>25-75</td>
</tr>
<tr>
<td>NTP Inlet Temperature</td>
<td>$TNTP_{in}$</td>
<td>C</td>
<td>25</td>
<td>25-30</td>
</tr>
<tr>
<td>Pressure</td>
<td>$P_{gas}$</td>
<td>mm Hg</td>
<td>720</td>
<td>720</td>
</tr>
<tr>
<td>Emission Data</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>$NO_x$</td>
<td>$C_{NO_x}$</td>
<td>ppm</td>
<td>36.00</td>
<td>&lt; 10</td>
</tr>
<tr>
<td>$SO_2$</td>
<td>$C_{SO_2}$</td>
<td>ppm</td>
<td>4.59</td>
<td>~ 1</td>
</tr>
<tr>
<td>HC (VOC)</td>
<td>$C_{HC}$</td>
<td>ppm</td>
<td>60.00</td>
<td>20-25</td>
</tr>
<tr>
<td>$CO$</td>
<td>$C_{CO}$</td>
<td>ppm</td>
<td>53.36</td>
<td>~ 5</td>
</tr>
<tr>
<td>Particles</td>
<td>$C_{part}$</td>
<td>mg/Nm$^3$</td>
<td>-</td>
<td>~/ 1.0</td>
</tr>
<tr>
<td>NH$_3$ Stochiometric Ratio to NO and SO$_2$: 1.5 for both JETCs and CMTCs</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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NTP de-NOx System Examples

**Stand-Alone System**

\[ \text{NO} + \text{VOCs} + \text{Air} \rightarrow \text{NTP Reactor} \rightarrow \text{NO}_2, \text{HNO}_3, \text{N}_2 \]

**NO → NO\(_2\) Conversion + Scrubber System**

\[ \text{NO} + \text{VOCs} + \text{Air} \rightarrow \text{NTP Reactor} \rightarrow \text{NO}_2, \text{HNO}_3 \rightarrow \text{Wet Scrubber} \rightarrow \text{Dilute HNO}_3 \text{ (w \ / \ Na}_2\text{S}_2\text{O}_3) \]
\[ \rightarrow \text{NaNO}_3 + \text{H}_2\text{O} \text{ (w \ / \ NaOH)} \]
\[ \rightarrow \text{Ca(NO}_3)_2 + \text{H}_2\text{O} \text{ (w \ / \ Ca(OH)}_2) \]

**Injection Systems**

\[ \text{NO} + \text{VOCs} + \text{Air} \rightarrow \text{NTP Reactor} \rightarrow \text{NH}_4\text{NO}_3 \rightarrow \text{ESP} \rightarrow \text{Particulate NH}_4\text{NO}_3 \text{ (Fertilizer)} \]

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Pulsed Corona System

Pulsed or DC corona

Hydro-carbons

Pulse Generator

Influent Gas

\( \text{NH}_3 (\text{C}_2\text{H}_4) \)

Pulse Generator

Wire Electrodes

Electrostatic Precipitator

Reactor

Channels

Stack

Fertilizer

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Dielectric-Barrier (Silent Discharge) System

Illustration of mobile dielectric-barrier NTP reactor system employed for VOC decomposition tests at McClellan AFB. Each plasma reactor tank operated at up to 10 kW of plasma power.

CRADAs with the Electric Power Research Institute (EPRI) & High Mesa Technologies (HMT) were an essential part of the development & fielding of this equipment.
Schematic diagram of commercial Tecolytic™ modified
dielectric-barrier NTP reactor system for de-NO\textsubscript{x}/SO\textsubscript{x}
(flue-gas treatment)
Electron-Beam System

[Diagram showing the electron-beam system with labeled components such as Radiation Shield, Electron Guns, Power Supply, Influent Gas, Electrostatic Precipitator, Channels, Stack, and Fertilizer.]
Corona Radical Shower System

Schematic diagram of CRS reactor. Ammonia (NH₃) or methane (CH₄) are added to generate radicals that drive reactions leading to the formation of particulates; these particulates are then captured by the electrostatic precipitator. Some of the captured products are useful for agricultural fertilizer (e.g., ammonium nitrate, NH₄NO₃).
Corona Radical Shower (CRS) Lab-Scale Prototype at McMaster University

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We have provided economic analyses for three hybrid NTP systems compared to conventional de-NO$_x$ systems

<table>
<thead>
<tr>
<th>Conventional</th>
<th>NTP</th>
</tr>
</thead>
<tbody>
<tr>
<td>Selective Catalytic Reduction (SCR) + Wet Scrubbers</td>
<td>Pulsed Corona</td>
</tr>
<tr>
<td>Selective Catalytic Reduction (SCR) + Electrostatic Precipitator (ESP)</td>
<td>Electron-Beam</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>![Diagram]</th>
</tr>
</thead>
<tbody>
<tr>
<td>Influent Gas</td>
</tr>
<tr>
<td>Limestone Slurry</td>
</tr>
</tbody>
</table>

Corona Radical Shower (CRS)

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Example: NO$_x$-removal power requirement depends on exhaust gas flow rate, characteristic specific energy, and desired degree of removal.

(Assume stand-alone NTP system.)

- Typical removal scaling: \([X]/[X]_0 = \exp (- E_s/\beta)\),

where \(E_s = P/Q\), plasma power divided by gas flow rate and \(\beta = \text{specific energy for one e-fold removal}\).

For NO, \(\beta \sim 10\ \text{J/lit (e-beam)}; \sim 50\ \text{J/lit (electrical discharge)}\).

- Power requirement for one e-fold removal: \(P = Q \cdot \beta\).

<table>
<thead>
<tr>
<th>Small Source:</th>
<th>Large Source:</th>
</tr>
</thead>
<tbody>
<tr>
<td>Q \sim 100\ \text{SCFM (2832 lit/min)}</td>
<td>Q \sim 1 \times 10^6\ \text{SCFM (2.83 \times 10^7 lit/min)}</td>
</tr>
<tr>
<td>P \sim 472.\ \text{W (e-b), 2.4 kW (e-d)}</td>
<td>P \sim 4.7\ \text{MW (e-b), 24 MW (e-d)}</td>
</tr>
</tbody>
</table>

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## Benchmarking Basis/Examples for Economic Analyses

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Units</th>
<th>Reactor Type:</th>
<th>Pulsed Corona</th>
<th>Corona Shower</th>
<th>Electron Beam</th>
<th>Conventional</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Facility:</td>
<td>JETC Exhaust</td>
<td>'JETC' Exhaust</td>
<td>Auto Tunnel</td>
<td>Power Plant</td>
</tr>
<tr>
<td>[NO\textsubscript{2}]</td>
<td>ppm</td>
<td></td>
<td>36</td>
<td>40</td>
<td>10</td>
<td>300</td>
</tr>
<tr>
<td>\textit{NO \textsubscript{x} Removal}</td>
<td>%</td>
<td></td>
<td>56</td>
<td>90</td>
<td>70</td>
<td>80</td>
</tr>
<tr>
<td>[SO\textsubscript{2}]</td>
<td>ppm</td>
<td></td>
<td>4</td>
<td>4</td>
<td>1</td>
<td>3,050</td>
</tr>
<tr>
<td>\textit{SO \textsubscript{x} Removal}</td>
<td>%</td>
<td></td>
<td>90</td>
<td>95</td>
<td>95</td>
<td>90</td>
</tr>
<tr>
<td>Energy Yield</td>
<td>g-NO/kW-h</td>
<td></td>
<td>20</td>
<td>17</td>
<td>19</td>
<td>-</td>
</tr>
<tr>
<td>Exp. Scale</td>
<td>Nm\textsuperscript{3}/h</td>
<td></td>
<td>600</td>
<td>12</td>
<td>40,000</td>
<td>1.9 x 10\textsuperscript{6}</td>
</tr>
</tbody>
</table>

Cost comparisons for various de-NO\textsubscript{x} systems
(70\% de-NO\textsubscript{x}, 108 h/wk operation)

![Graph showing cost comparisons for various de-NO\textsubscript{x} systems.]

<table>
<thead>
<tr>
<th>(k$)</th>
<th>Pulsed Corona</th>
<th>Corona Shower</th>
<th>Electron Beam</th>
<th>Wet Scrubber + SCR</th>
<th>ESP + SCR</th>
</tr>
</thead>
<tbody>
<tr>
<td>Capital Recovery</td>
<td>345</td>
<td>410</td>
<td>718</td>
<td>36</td>
<td>104</td>
</tr>
<tr>
<td>Labor &amp; Maintenance</td>
<td>218</td>
<td>246</td>
<td>377</td>
<td>273</td>
<td>273</td>
</tr>
<tr>
<td>Electric Power</td>
<td>99</td>
<td>116</td>
<td>77</td>
<td>123</td>
<td>83</td>
</tr>
<tr>
<td>Chemicals &amp; Utilities</td>
<td>6</td>
<td>6</td>
<td>6</td>
<td>1,291</td>
<td>1,192</td>
</tr>
<tr>
<td>Total Annual Cost</td>
<td>664</td>
<td>774</td>
<td>1,176</td>
<td>1,723</td>
<td>1,651</td>
</tr>
<tr>
<td>Fertilizer Recovery</td>
<td>4</td>
<td>4</td>
<td>4</td>
<td>0</td>
<td>0</td>
</tr>
</tbody>
</table>
Cost comparisons for various de-NO$_x$ systems (cont'd.)
(70% de-NOx, 108 h/wk operation)

![Graph showing annual cost comparison for different systems.]

Gas Flow Rate: 1.70 x 10$^8$ Nm$^3$/h (1.0 x 10$^4$ SCFM)

<table>
<thead>
<tr>
<th></th>
<th>Pulsed Corona</th>
<th>Corona Shower</th>
<th>Electron Beam</th>
<th>Wet Scrubber + SCR</th>
<th>ESP + SCR</th>
</tr>
</thead>
<tbody>
<tr>
<td>Capital Recovery</td>
<td>3,594</td>
<td>4,151</td>
<td>6,504</td>
<td>3,802</td>
<td>3,123</td>
</tr>
<tr>
<td>Labor &amp; Maintenance</td>
<td>1,823</td>
<td>2,060</td>
<td>3,061</td>
<td>4,641</td>
<td>4,641</td>
</tr>
<tr>
<td>Electric Power</td>
<td>1,674</td>
<td>1,970</td>
<td>1,318</td>
<td>2,082</td>
<td>1,403</td>
</tr>
<tr>
<td>Chemicals &amp; Utilities</td>
<td>110</td>
<td>110</td>
<td>110</td>
<td>21,935</td>
<td>20,247</td>
</tr>
<tr>
<td>Total Annual Cost</td>
<td>7,139</td>
<td>8,230</td>
<td>10,931</td>
<td>32,459</td>
<td>29,414</td>
</tr>
<tr>
<td>Fertilizer Recovery</td>
<td>62</td>
<td>62</td>
<td>62</td>
<td>0</td>
<td>0</td>
</tr>
</tbody>
</table>

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Other workers have evaluated two additional NTP de-NO$_x$ & de-SO$_x$/NO$_x$ systems

Haythornthwaite et al
(Air Force contract)
(Pulsed corona oxidizer + scrubber)

Tecogen/Thermo Power
(Modified dielectric barrier)

\[ \text{NO} \rightarrow \text{NO}_2 \text{ Conversion + Scrubber System} \]

- NO + VOCs + Air \rightarrow \text{NTP Reactor} \rightarrow \text{NO}_2, \text{HNO}_3 \rightarrow \text{Wet Scrubber} \rightarrow \text{Dilute HNO}_3 (w / \text{Na}_2\text{S}_2\text{O}_3)
- \text{NaNO}_3 + \text{H}_2\text{O} (w / \text{NaOH})
- \text{Ca(NO}_3)_2 + \text{H}_2\text{O} (w / \text{Ca(OH)}_2)

__________________________
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Cost data for
Haythornthwaite et al 1997

4 x 10^6 SCFM JETC using PCR
NO → NO₂ converter + wet scrubber
(~50% NOₓ removal)

<table>
<thead>
<tr>
<th>Capital Cost</th>
<th>$109,200,000</th>
</tr>
</thead>
<tbody>
<tr>
<td>Capital Recovery</td>
<td>$14,196,000</td>
</tr>
<tr>
<td>Run Time</td>
<td></td>
</tr>
<tr>
<td>10 hr/week</td>
<td>50 hr/week</td>
</tr>
<tr>
<td>O &amp; M Costs/Yr</td>
<td>$523,600</td>
</tr>
<tr>
<td>Annual Cost</td>
<td>$14,719,600</td>
</tr>
</tbody>
</table>

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Cost comparisons for commercial TecoLytic™ modified dielectrc-barrier NTP reactor system for de-NO$_x$/SO$_x$ (flue-gas treatment) show favorable trends.
Future trends

Realizing the performance and economic shortcomings of stand-alone NTP reactors, the use of staged or hybrid systems to better match particular air-emissions control applications is being more widely explored

- NTP + injectants
- NTP + catalysts
- NTP + adsorbents

NTP technology may become more common in areas where it has significant advantages over conventional technologies in terms of:

- Increased efficiency and/or economics
- Increased selectivity or throughput
- Better control of final products and/or process
- Unique process streams

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Summary

- A greater awareness of the effects of air pollutants ($\text{NO}_x/\text{SO}_x$, VOCs, particulates) on our environment and human health has led to more stringent regulations on air emissions.

- Non-thermal plasma technology is being explored as an emissions-control option in several areas (this talk has emphasized $\text{NO}_x$ control in jet engine test facilities).

- Hybrid systems (e.g., using injectants) show increased removal yields and favorable economic trends for large-scale de-$\text{NO}_x$ systems.

- Rigorous pilot-plant tests are required to provide further data and operating experience to more fully evaluate economic and performance projections.

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