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EVALUATION OF GAS-REBURNING AND LOW NO_x
BURNERS ON A WALL FIRED BOILER

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Clean Coal Technology (CCT) implies the use of coal in an environmentally acceptable manner. Coal combustion results in the emission of oxides of nitrogen (NO_x), which are precursors of both acid rain and ozone formation. The primary objective of this CCT project is to evaluate the use of Gas Reburning and Low NO_x Burners (GR-LNB) for NO_x emission control from a wall fired boiler. It is anticipated that, if the demonstration is successful, the GR-LNB technology could become commercialized during the 1990's and will be capable of (1) achieving significant reduction in the emissions of nitrogen oxides and sulfur dioxide (another acid rain precursor) from existing facilities to minimize environmental impacts such as transboundary and interstate pollution and/or (2) providing for future energy needs in an environmentally acceptable manner.

Low NO_x burners are designed to delay the mixing of the coal fuel with combustion air to minimize the NO_x formation. Typically, one may obtain up to 50% reduction in NO_x emissions through the use of LNB. For LNB applications, the technology is developed and a number of LNB designs are commercially available.

With GR, about 80-85 percent of the coal fuel is fired in the main combustion zone. The balance of the fuel is added downstream as natural gas to create a slightly fuel rich environment in which NO_x is converted to N_2 . The combustion process is completed by over-fire air addition. SO_x emissions are reduced to the extent that natural gas replaces sulfur-containing coal. The level of NO_x reduction achievable with 15-20% natural gas is on the order of 50-60%. Thus the emission reduction target of the combination of these two developed technologies is about 70%.

Specifically, the technical objectives of this project are to:

1. Demonstrate the full effectiveness of GR-LNB for NO_x emission control. This includes the performance of the separate technologies and of the integrated GR-LNB technology.

2. Demonstrate the compatibility of GR-LNB with existing wall fired boilers.
3. Demonstrate the additional reductions in SO₂, particulate and CO₂ achievable with GR-LNB.
4. Demonstrate the synergism of GR-LNB with sorbent injection for SO₂ control if a sorbent injection system is installed outside the scope of this project.
5. Develop a data base which can be used to establish the commercial viability of GR-LNB to meet existing and projected emission control regulations.
6. Transfer the project results to industry to ensure that GR-LNB is a recognized cost effective competitor for utility boiler emission control.

This project is being conducted in three phases at the host site, a 172 MW_e wall fired boiler of Public Service Company of Colorado (PSCo), Cherokee Unit 3 in Denver, Colorado: Phase I - Design and Permitting, Phase II - Construction and Start-up, and Phase III - Operation, Data Collection, Reporting and Disposition. Technology transfer to industry is accomplished through the formation of an industry panel.

Phase I of the project commenced on October 13, 1990 and was completed June 30, 1992.

Phase II of the project commenced on June 13, 1991, and was completed on September 2, 1992.

Phase III of the project was approved and commenced on April 15, 1992. Phase III activities during this reporting period involved completion of the second generation gas reburning parametric testing. This technology utilizes enhanced natural gas and overfire air injectors with elimination of the flue gas recirculation system. The objective is to demonstrate NO_x reductions similar to that of long term testing but with a reduced capital cost requirement through elimination of the FGR system.

Key Words

SO_x

SO₂

NO_x

NO

Burners

Start-up

CEMS

Reburning

BPMS

Ash

Coal

Gas

Low NO_x Burners

Construction

Instrumentation

Industry Panel

Injection

Emission

Control

Boiler

Precipitator

Flue Gas

Contracts

Baghouse

Ducts

2.0 INTRODUCTION

The specific goal of this project is to demonstrate NO_x emission reductions of 70 percent or more as a result of combining LNB and GR on a utility boiler having the design characteristics mentioned above. A Host Site Agreement has been signed by EER and a utility company in the State of Colorado: Public Service Company of Colorado (Cherokee Unit No. 3, 172 MW_e) front wall fired boiler near Denver.

To achieve the objectives of the project, it is being conducted in the following three phases at the host site.

- Phase I: Design and Permitting
- Phase II: Construction and Start-up
- Phase III: Operation, Data Collection, Reporting and Disposition

Phase I is complete.

Phase II is complete.

Phase III of the project (Operation, Data Collection, Reporting and Disposition) officially began on April 15, 1992 with Task 1, Project Management work. Due to delays such as the rebuilding of pulverizers, Task 2, Optimization commenced mid-September, 1992. Planned and unplanned boiler shutdowns delayed completion of Task 2 until late April 1993. Task 3, Long Term Testing began on April 27, 1993 with Gas Reburning controls configured in automatic to provide a load following test condition. Long term testing continued through January 20, 1994. The six week Cherokee Unit #3 outage followed, concluding on March 6, 1994. After completion of the outage, during which EER made a number of enhancements to the Gas Reburning (GR) system, the Low NO_x Burners were started up and optimized. Guarantee tests followed. During the last quarter, testing of the Second Generation Gas Reburning System was completed.

Major work performed during this past quarter was as follows:

1. Completion of the Second Generation Gas Reburning System testing.

Within the final phase of the project, the following tasks will be performed to demonstrate the cost effective control of NO_x and SO_x emissions from pre-NSPS coal fired utility boilers:

Phase III: OPERATION, DATA COLLECTION, REPORTING AND DISPOSITION

Task 1 - Project Management

- Continuation of Phases I and II project management activities.
- Conducting final project review at conclusion of project.

Task 2 - Optimization Testing

- Optimization of LNB installation.
- Optimization of GR-LNB technology
- Evaluation of effects of process variables on emission control performance.
- Determination of operating conditions for optimum overall performance.

Task 3 - Long Term Tests

- Operation of GR-LNB equipment under optimized conditions for approximately one-year duration.
- Measurement of emission control system performance.
- Determination of boiler impacts.

Task 4 - Evaluation of Field Test Results

- Analysis of test data.

- Preparation of guideline manuals for application of GR-LNB technology, including design recommendations, cost projection and comparisons with competing technologies.

Task 5 - Restoration

- Disposition of GR-LNB equipment installation:
To be retained by host site or removal and restoration work.

Task 6 - Technology Transfer

- Continuation of technology transfer activities from Phases I and II.
- Meeting with Industry Panel to review results obtained.

Task 7 - Gas Reburning Enhancements

- Modification of OFA and Natural Gas injectors.
- Elimination of FGR system.
- Parametric and Long Term Testing of GR Enhancements.

4.0 PROJECT STATUS

4.1 Phase I Design and Permitting Phase I is Complete.

4.2 Phase II Construction and Startup Phase II is Complete.

4.3 Phase III Operation, Data Collection, Reporting and Disposition Reports are in progress.

4.3.1 Task 1 - Project Management

Project management activities this reporting period consisted of coordinating and planning, data analysis and issuance of reports as required by the cooperative agreement.

A meeting was held at Public Service of Colorado (PSCo) on March 20, 1995 to present the results of testing and discuss restoration options. PSCo will retain the gas reburning and overfire air portions of the system, but require restore the flue gas recirculation. In essence, PSCo will retain the system configuration defined as Second Generation Gas Reburning.

4.3.2 Task 2 - Optimization Testing

Optimization testing is completed.

4.3.3 Task 3 - Long Term Testing

Long term testing is completed.

4.3.4 Task 4 - Evaluation of Results

Testing of the Second Generation Gas Reburning System was completed on January 26, 1995. The results show that the re-design of the natural gas injectors plus removal of the flue gas recirculation system resulted in virtually the same NO_x reduction as found before the modification. The re-design of the overfire air nozzles resulted in a reduced level of CO emissions.

The following is a summary of the test results. The percent of NO_x reduction is measured from the baseline level of .73 lb/MMBtu (without low NO_x burners). The CO has been corrected to 3% O₂. Data displayed is for 4-mill operation at approximately 150 MW.

<u>Parameter</u>	<u>Pre-Modification</u>	<u>Post-Modification</u>
LNB Only		
NO _x level (lb/MMBtu)	.451	.428
NO _x reduction	38%	41%
CO level (ppm)	225	117
LNB-OFA		
NO _x level (lb/MMBtu)	.395	.384
NO _x reduction	46%	47%
CO level (ppm)	252	196
6-8% Natural Gas		
NO _x level (lb/MMBtu)	.269	.268
NO _x reduction	63%	63%
CO level (ppm)	643	47
9-10% Natural Gas		
NO _x level (lb/MMBtu)	.247	.258
NO _x reduction	66%	65%
CO level (ppm)	150	107

The Second Generation Gas Reburning System has been considered to be a successful implementation to this project. The test of the system demonstrated that a significant capital cost reduction (approximately one-third) can be achieved by removing the flue gas recirculation system from the design while achieving acceptable NO_x reductions.

4.3.5 Restoration

PSCo will retain the gas reburning and overfire air portions of the system, but require restore the flue gas recirculation.

4.3.6 Technology Transfer

The next industrial panel meeting has been scheduled for Fall, 1995 in Philadelphia.

4.3.7 Gas Reburning Enhancements

Parametric/optimization testing of the second generation gas reburning was completed in January, 1995.

5.0 PLANNED ACTIVITIES

During the next quarter (October through December, 1994) the following work is planned:

1. Project Management continues into the next quarter concentrating on preparation of final reports.
2. Continue with final reports.
3. Refine subcontractor workscope for restoration.

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