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PETC INTERIM REPORT: December 1995 CRADA PC-95006

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INTRODUCTION

The Moving-Bed Copper Oxide Process is of particular interest since it is capable of simultaneously removing SO_2 and NO_x from flue gas; it can meet the goals of the Superclean Emissions Control subprogram of the Flue Gas Cleanup Program; and it can beneficially be integrated into the design of advanced power systems, such as HIPPS. This process has been the subject of a small scale experimental test program with Rockwell and is currently being evaluated in a life-cycle test system (LCTS) with a moving-bed flue gas contactor at DOE's Pittsburgh Energy Technology Center (PETC). An experimental data base will be established that will be used to verify reported technical and economic advantages, to optimize process conditions, to provide scale-up information, and to validate absorber and regenerator mathematical models.

The chemistry of the process is relatively straightforward. In the absorption step, SO_2 in the flue gas reacts with copper oxide, supported on small spheres of alumina, to form the sulfate. Ammonia is injected into the flue gas before the absorption reactor and an SCR-type reaction occurs that reduces the nitric oxides in the flue gas. In the regeneration step, the copper sulfate is reduced in a regenerator via a reducing agent, such as natural gas, and a concentrated stream of SO_2 is produced. Another advantage of the process is the lower pressure drop across the moving-bed configuration reduces power consumption and thus influences the overall economic costs. The moving-bed process also has a lower projected sorbent attrition rate compared with other reactor configurations. Lastly, high sorbent utilization (the degree to which the sorbent absorbs its theoretical maximum level of SO_2 based on the metal oxide loading on the alumina sphere) can be realized in a moving-bed design.

In this communication, the results from five tests (MBCUO-2 through MBCUO-6) with the LCTS are discussed. During MBCUO-2 and MBCUO-3, the effect of absorber parameters on sorbent performance (e.g., SO₂ removal) and operational performance was investigated. UOP sorbent was used in this work. During MBCUO-4, natural gas regeneration was evaluated with the UOP sorbent. In MBCUO-5, a Grace sorbent with a slightly higher copper loading (7.0% versus the UOP 6.4%) was used to further evaluate natural gas regeneration and initially investigate hydrogen regeneration. Finally, the Grace sorbent was used again and hydrogen regeneration was investigated in MBCUO-6. Initial shakedown results leading to these parametric studies were previously described in a topical report (Pennline et al., 1995) and in a letter of Pennline to Darguzas dated June 19, 1995. Flow visualization tests after the initial coal combustion

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characterization tests in April 1995 can also be found in the letter of Pennline to Darguzas dated June 19, 1995.

EXPERIMENTAL

The process has been investigated using the LCTS that has been designed, constructed, and operated at PETC. The LCTS has the capability of operating in a continuous integrated mode, specifically related to the absorption and regeneration steps. Flue gas can be generated by a combustor that burns approximately 40 lbs/hr of pulverized coal, resulting in a nominal flue gas flow rate of 110 scfm. Coal is pulverized in an adjacent building, stored in a 20-ton hopper, periodically transported to the LCTS feed silo, and then fed from the silo by a feed screw into a stream of transport air for combustion in the furnace. The combustor can also be fired using natural gas for purposes of total flue gas production, of support for coal combustion, and of preheating the absorber and associated vessels thus preventing condensation of corrosive flue gas components, such as sulfuric acid, during initial coal burning. The flue gas exiting the combustor passes through heat exchangers so that a prescribed inlet absorber temperature can be maintained. The flue gas can be spiked with SO₂ and NO supplied from cylinders to adjust these concentrations to those of the desired test levels. Typically, NO is spiked for a 1-3 hour period after steady-state is reached at a set of parameters. Consequently, ammonia is injected into the flue gas upstream of the absorber to facilitate the catalytic reduction of nitrogen oxides to nitrogen and water vapor in the absorber. A controlled flue gas bypass provides a slip stream around the absorber, enabling the desired flow of flue gas through the absorber to be maintained. After passing either through or around the absorber, the flue gas is cooled by humidification and then passed through a baghouse for removal of any residual fly ash.

The sorbent process stream in the LCTS involves a closed-loop cycle of sorbent transported through four major vessels. The sorbent absorbs flue gas contaminants in the moving-bed absorber, passes through a fluidized-bed sorbent heater where the sorbent is heated with air and the products of a natural gas combustor, enters a regenerator where sulfur-containing species are released after treatment of the sorbent with a reducing gas, and lastly passes through a fluidized-bed air cooler prior to returning to the absorber. The sorbent is gravity fed through all four vessels, with the exception being the line connecting the absorber exit with the fluidized-bed sorbent heater. In this line, a pneumatic transport system sends the sorbent to an elevated location (i.e., the sorbent heater) to repeat the gravity-fed sorbent cycle. The hot air from the sorbent heater is vented through a baghouse for dust removal, and the regenerator offgas is vented through an incinerator.

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The entire system operates at pressures close to ambient; the various vessel pressures are maintained by forced draft and induced draft blowers and control valves. The absorber and regenerator have externally mounted heaters for temperature maintenance, and typically operate at 750 and 850°F, respectively. Gas analyzers and various instrumentation have been used in the experimental characterization of the process.

Steady-state at a set of process parameters was typically defined by following key parameters and calculated quantities (e.g., SO, removal, certain thermocouple readings from the absorber and regenerator, regenerator off-gas composition, etc.). Once at the steady-state condition, operation of the LCTS continued for an additional period of time. Data was then averaged over this period of time or a smaller representative era within the period. The parameters and calculated quantities in the detailed and summary tables represent the average of this data or calculation over the designated steady-state period. Absorber removal efficiencies are corrected for air in-leakage. Also, inlet and outlet analyzer readings for the absorber are adjusted to reflect a constant inlet oxygen concentration of 3.6%. (Calculated quantities are defined in the Appendix of the topical report of Pennline et al. (1995).) These tables will be further refined by examining test logbooks to assure that there are no additional changes that may need to be recognized. It is felt that minor changes with little significant impact on the results will occur. Tables 1-5 are summaries of the results from the respective tests MBCUO-2 through MBCUO-6. The more detailed parameters are found in Tables 6-10, that correspond to tests MBCUO-2 through MBCUO-6.

Several items are noteworthy.

(1) The period designation in the summary tables reflects that found in the test plan for a particular test, but the detailed tables list the periods in numerical order. In either case, the periods are listed in chronological order and a one-to-one correspondence exists between tables of the same tests.

(2) Certain periods were not used in some of the data discussion because it was determined that steady-state was not attained or that operational problems during the period significantly impacted the experimental results. An example of this was the first two periods of MBCUO-3, where the Perma Pure filters malfunctioned and thus gave erroneous information.

(3) During testing, a summary sheet is updated daily. (See Table 11 for a first hand look at the results of MBCUO-7.) These sheets aid in directing and planning the course of the testing during operation. A steady-state is determined; data results "eyeballed"; and information hand recorded. The detailed and summary tables represent information that was computer-averaged over the steady state period.

(4) Within a particular study of a parameter, a systematic change of only that parameter was conducted and a comparison with subsequent test periods was performed.

DISCUSSION AND RESULTS

Absorber Parametric Testing: Tests MBCUO-2 and MBCUO-3

Sorbent performance and operational performance of the LCTS are presented in the attached tables for various parametric conditions. The UOP sorbent used was 1/16-inch diameter spheres of alumina containing a 6.4 weight percent copper loading.

During earlier shakedown studies, several issues were resolved so that a baseline test could be defined. One concern was that the regeneration step with natural gas was not entirely effective. A batch test in the regenerator identified the regeneration conditions that would be used throughout Tests MBCUO-2 and MBCUO-3. A temperature of 850°F and a 3-hr sorbent residence time with an excess of natural gas (typically twice the stoichiometric requirement) was sufficient to regenerate the sorbent.

The moving-bed absorber mathematical model of Young and Yeh (1993) was used as a means to define a baseline test so that changes in parameters could be quantified in the parametric study. The shakedown tests also indicated that sorbent flow in the original reactor design was not ideal, and cold flow studies dictated that the reactor width be 1 ft. (See letter of Pennline to Darguzas dated June 19, 1995.) Final absorption conditions for the baseline are a cross-sectional area of $8-ft^2$, bed thickness of 5 inches, temperature at 750°F, sorbent flow of 1-1b/min, and a flue gas flow of 110-scfm produced by burning natural gas and spiking to a level of 2250 ppm of SO₂. Regeneration conditions described above were employed. Periodically during the parametric testing, the baseline condition was repeated to assure that the activity of the sorbent, as well as the operational response of the LCTS, was maintained.

The effects of absorption temperature, inlet SO_2 concentration, sorbent flow, and flue gas flow on the pollutant removal efficiencies in the absorber were systematically investigated. Absorber model predictions were also compared to the actual SO_2 removals at a set of conditions. The SO_2 removal of the baseline test was typically 93 percent.

Temperature

In the temperature study, four temperatures of absorption were investigated: 591, 705, 749, and 801° F, corresponding to the test periods MBCUO-3-8, MBCUO-3-2A, MBCUO-3-1A, and MBCUO-3-3, respectively. From past investigations, the optimum temperature of absorption is 750°F. Results of the LCTS testing (see Figure 1) would indicate that temperature fluctuation between 700 to 800 °F due to upsets in a commercial process would not have an appreciable impact on SO₂ removal. However, the lower the temperature the less activity as depicted by the 76.6 percent removal at the 591°F temperature level.

Flue Gas Flow Rate

Increasing the flue gas flow rate through the bed results in a decrease in the SO_2 removal. An explanation for this is that, when the gas flow is increased, the effective Cu/S feed ratio into the bed is decreased, and also the gas residence time within the bed is decreased. This effect can be seen in the data when the flue gas flow rate was doubled from near 55 (MBCUO-2-2A) to near 110 scfm (MBCUO-3-1A) and the other absorber parameters were held constant. From these initial tests, the nominal 110 scfm condition was chosen as the baseline since an observable change from the SO_2 removal at the lower flue gas flow rate could be difficult during the other parametric scans.

Inlet SO₂ Concentration

The impact of the inlet flue gas SO_2 concentration was also investigated. Essentially, as the SO_2 concentration increases, the effective Cu/S feed ratio decreases, thus causing a decrease in removal efficiency. Results can be seen in Figure 2 when the concentration levels of SO_2 were 1500, 2242, 3059, and 3244 ppm, simulating the concentrations in flue gas when a mid- to highsulfur coal is combusted. The respective SO_2 percent removals for periods MBCUO-3-4, MBCUO-3-1A, MBCUO-2-3, and MBCUO-3-5 were 96.3, 93.2, 85.9, and 81.2, respectively.

Sorbent Flow

The effect of changing the sorbent flow on the SO₂ removal efficiency was also investigated. During this set of parametric tests, sorbent samples were withdrawn from the regenerator to verify that the regeneration step was complete. Thus the sorbent flowing into the absorber should have the same available copper for each sorbent flow variance. Effects of varying the sorbent flow can be seen at two gas flow conditions. The first is at a 55 scfm gas flow where sorbent flow was increased from 0.5 to 1.0 lb/min. A corresponding increase in SO_2 removal (94.0 to 95.2 percent) occurred as seen in MBCUO-2-1 and MBCUO-2-2A. At 110 scfm, the sorbent flow rates for three sets of conditions for periods MBCUO-3-6, MBCUO-3-1A, and MBCUO-3-7 were 0.75, 1.0, and 1.25 lb/min respectively, with corresponding SO₂ removals of 86.5, 93.2, and 91.1 percent. Except for the latter point as seen in Figure 3, the trend is the same indicating that a higher sorbent flow of regenerated sorbent will enhance the SO₂ removal efficiency of the absorber. However, in a commercial installation, an optimum sorbent flow should be attained to minimize the cost of sorbent transport and the effects of sorbent attrition.

NO_x Removals

As mentioned previously, NO was injected after certain test period conditions attained steady-state. Once the chemilumenescent analyzers established the NO spike concentration, ammonia was injected to a flow that established a 90 or 95% NO_x removal by again following the chemilumenescent analyzers. The molar flow of ammonia was determined by the flow settings, and a molar ratio of ammonia to nitric oxides was then calculated. From Table 2, the

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ratio in MBCUO-3 was between 0.85 and 1.05, with most conditions below 1.0. A similar NH_3/NO ratio had been found in earlier copper oxide work, indicating that a molar ratio less than one can reduce a vast majority of the NO_x . A wet chemical sampling technique that bubbled the flue gas through a hydrochloric acid solution was used to determine if ammonia slippage occurred. The solution is further analyzed by using an ion electrode technique. No ammonia slippage has been seen after using this sampling and analytical technique.

Sulfur Analysis of the Spent Sorbent

During the course of the testing, sorbent samples were withdrawn from the absorber and regenerator at various locations along the length of each respective reactor. While sampling sorbent from the absorber, the flue gas bypassed the reactor; for the regenerator, the reactor was purged with nitrogen before the samples were taken. A metal probe (thief) was inserted at the port and a vacuum drew the sample into a container. The probe was gradually moved back and forth within the vessel in an attempt to obtain а representative sample at a horizontal cross-section of the reactor. These samples were then analyzed for total sulfur content by using a LECO sulfur analyzer. After MBCUO-3, the absorber ports were enlarged to facilitate probe insertion and sample withdrawl during sampling. After MBCUO-5, samples could also be taken from the hoppers that were located before and after the regenerator and from the transport hopper. Caution must be used in interpreting these results since some locations prior to the change before MBCUO-6 may not have given a representative sample. An example of this is the original regenerator outlet location which was in reality a distance above where the regenerant (reducing agent) entered the reactor. Results of sulfur analyses can be found in Table 12.

For the MBCUO-2 and MBCUO-3 tests, the extent of regeneration was substantial with a high sorbent residence time and with an excess natural gas flow. The sulfur content on the regenerated sorbent was typically low. However, residual sulfur was always present on the sorbent and it can be speculated that the sulfur is bonded to the alumina substrate, as discussed by McCrea et al. (1970).

Sulfur Balances

Sulfur material recoveries in the summary tables are reported for the gas phase only. At steady-state, the sulfur dioxide in the flue gas that was removed by sorbent must equal the sulfur dioxide emitted in the regeneration step. Although MBCUO-2 did not monitor the flow of gas from the regenerator, sulfur material balances from subsequent testing were reasonable.

Regeneration Parametric Study -- Natural Gas: MBCUO-4

Most regeneration studied to date has been with natural gas. From past results and a more recent microbalance study, a temperature of 850°F is required with a sufficient residence time for an effective regeneration with methane (natural gas). For the purpose of this study, the initial baseline test was one chosen from MBCUO-3 with a sorbent flow of 0.75 lb/min (MBCUO-3-6). Criteria for this was that at these absorber process parameters, the utilization is high

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(near 60%) and would approach that which would occur in a commercial application.

Absorber process conditions were held constant throughout the tests with the realization that a regeneration parametric change would not only affect the regeneration results (e.g., gas and sorbent composition from the regenerator) but also the SO_2 removal efficiency of the absorber. Regeneration parameters that were investigated were the inlet CH_4/S molar ratio, sorbent residence time, and temperature.

It must be specified that this test was conducted with the UOP sorbent, but the supply of sorbent was exhausted at the end of the The residence time in the regenerator was decreased test. periodically during the test so that the sorbent extracted from the regenerator could be used as make-up sorbent that was required because of attrition. Therefore, it was impossible to repeat the initial baseline period (3-hr regenerator residence time) at the end of the test. Also, it was noted that the absorber pressure drop increased during parts of the test and a corresponding decrease in absorber SO2 removal would occur. This problem was avoided by periodically bypassing the flue gas around the reactor and then scrubbing the reactor retention screens by circulating sorbent through the bed for a 2-3 hour period. Visual inspection of the retention screens during the later post-test maintenance period revealed that small pieces of sorbent were caught in the exit retention screen. Also, note that before MBCUO-4, the overall particle size distribution of the sorbent had shifted. Sieve analysis of the unused fresh sorbent resulted in 99.9% retained on a 16-mesh screen; after MBCUO-3, 89.6% was retained on a 16-mesh screen.

Unlike Tests MBCUO-2 and MBCUO-3, the nitrogen purges in the inlet and outlet hoppers around the regenerator were terminated during this test. Thus the CH_4 , SO_2 , and CO_2 compositions should add up to 100%. These components were obtained from the continuous gas analyzers and are periodically checked by taking a volumetric gas sample and having it analyzed by gas chromatography. Comparisons are usually excellent.

Hydrogen regeneration was attempted during the last period of the test. However, instability of the temperature prohibited any meaningful test results.

Inlet CH₄/S Molar Ratio

This ratio is defined as the moles of natural gas flowing into the reactor divided by the sulfur on the sorbent. The flow of natural gas into the reactor was taken as 100% methane, whereas in actuality it is closer to 90%. Since the SO₂ removal efficiency was typically high, the moles of S was calculated from the total amount of SO₂ flowing into the absorber. This method of calculating the CH_4/S ratio has been used throughout the research effort. An excess of natural gas was present at all times and results from varying the ratio from 0.59 to 1.17 are shown in Figure 4. Results are from Periods MBCUO-4-3, MBCUO-4-2, and

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MBCUO-4-1. It can been seen that as the molar ratio increases, the methane concentration in the regenerator offgas increases and the corresponding SO_2 concentration decreases because of the dilution effect of the methane. However, as the ratio approaches the stoichiometric amount required from the process chemistry (0.5/1), the activity of the sorbent in the absorber decreases. This would probably be magnified if the residence time were not 3-hr. Also, the sulfur on the sorbent out of the regenerator appears to be higher at the lower molar ratio.

Sorbent Residence Time

The impact of the residence time within the regenerator was also investigated. Residence times of 60 min (MBCUO-4-7), 120 min (MBCUO-4-4), and 180 min (MBCUO-4-1) were studied, and the results are shown in Figure 5. Attempts were made to hold constant all other parameters within the regenerator. From the results, it appears that as the residence time increases a better regeneration occurs as noted by a decreasing methane gas exit concentration and an increasing SO₂ concentration. The SO₂ removal efficiency in the absorber increased with increasing residence time; the residual sulfur on the sorbent decreased slightly with increasing residence time.

Temperature

The impact of temperature on regeneration is shown in two separate comparisons: at a 120 min residence time and at $850^{\circ}F$ (MBCUO-4-4) and $937^{\circ}F$ (MBCUO-4-6A); at a 60 min residence time and at $815^{\circ}F$ (MBCUO-4-8) and $876^{\circ}F$ (MBCUO-4-7). In the first case, the absorber activity after regeneration at the extremely high temperature of $937^{\circ}F$ was lower (probably within the limits of uncertainty) than after the $850^{\circ}F$ regeneration. This could indicate that at $850^{\circ}F$ and 120 min residence time, the sorbent is being adequately regenerated or, that at the higher regeneration temperature, some irreversible deactivation of the sorbent occurred. It must be recognized that after the high temperature regeneration, the sulfur content on the sorbent was the lowest seen, but not too different than the $850^{\circ}F$ regeneration (0.87 versus 0.93 wt%).

For the higher temperature regeneration, the contents of the gas stream leaving the regenerator were low with respect to SO_2 , and the sulfur recovery was extremely low. Typically, when the regeneration temperature is 850° F, the temperature of the sorbent within the fluid bed heater -- immediately preceding the regenerator -- is near 1020° F. However, to obtain the higher temperature within the regenerator, the temperature in the fluid bed heater soared to near 1190° F. Some thermal decomposition of the copper sulfate occurred as indicated by the SO_2 analyzer on the exit stream to the fluid bed heater.

The other impact of temperature was determined at a residence time of 60 min and temperatures of $815^{\circ}F$ and $876^{\circ}F$. The lower temperature adversely affected the regeneration as denoted in the higher concentration of methane in the exit gas stream at the lower temperature and the corresponding lower concentration of carbon dioxide. The absorber SO₂ removal was significantly lower (76.6 versus 83.5) and the sulfur content of the sorbent at the lower temperature was high (1.47 versus 1.02 wt%).

<u>Regeneration Parametric Study -- Natural Gas and Hydrogen: MBCUO-5</u> A Grace sorbent that contained 7.0 wt% copper was used during this test. The initial test condition was identical to a previous test period with the UOP sorbent using natural gas as the regenerant. Parametric conditions for this base case were chosen to match a test from MBCUO-4. The effect of nitrogen dilution during natural gas regeneration was also studied. Additionally, hydrogen regeneration was investigated.

Prior to the test, a sliding thermocouple in a thermowell was installed in a radial position within the regenerator. This was to determine if significant radial thermal gradients occurred during hydrogen regeneration.

Toward the latter part of the test, the flue gas was produced by combusting the Illinois coal (Old Ben No. 24). Pluggage of the retention screens and/or the bed decreased the effectiveness of the moving-bed absorber. Certain information that pertained to the operation led to the conclusion that bed scrubbing (bypassing the flue gas around the absorber and then circulating sorbent through the bed for a 2-3 hr period) could reduce the pressure drop and return the overall system to the prior conditions. However, a rapid growth in the pressure drop across the absorber would continue to occur once flyash-laden flue gas was reintroduced, and the results are questionable, since steady-state conditions were difficult to attain.

Sorbent Comparison

The test period for comparison with the Grace sorbent was MBCUO-4-4 that used UOP sorbent at the following nominal conditions: absorber temperature of 750oF with 2250 ppm of SO_2 in 110 scfm of flue gas, sorbent flow of 0.75 lb/min, regenerator temperature of 850oF, natural gas-to-sulfur molar ratio of 1.17, and 120 min regenerator residence time. This test period was compared with MBCUO-5-1, MBCUO-5-4, and MBCUO-5-1B. These periods used the Grace sorbent; were at identical process conditions as the UOP sorbent; and were repeats during MBCUO-5.

Results indicated that the three tests in MBCUO-5-were nearly the same. Comparison of these with the UOP result indicates that the Grace sorbent was more reactive with respect to SO_2 removal than the UOP sorbent. This could be explained by the difference in copper content between the sorbents (6.4 versus 7.0%) and possible differences in the substrate material of the sorbents. Also, for the UOP sorbent, the composition of the exit gas from the regenerator was higher in CH_4 but lower in SO_2 as compared to the Grace results, although the differences in the sulfur content of the sorbent from the regenerator were not that significant.

Effect of Nitrogen Dilution

The impact of increasing the gas velocity in the regenerator was demonstrated in MBCUO-5-2. All conditions were nearly identical with MBCUO-5-1 (or MBCUO-5-4) except that an equal molar flow of nitrogen diluent was injected with the natural gas into the bottom of the regenerator. Results from both test periods indicate that SO_2 removal efficiency was about the same as well as the sulfur content on the sorbent. The dilution effects were seen in the regenerator exit gas concentrations, except for the unexplained methane composition. It could be speculated from the results that the diluent had negligible effect -- possibly the lower regenerant (reducing gas) partial pressure was offset by a decrease in bulk mass transfer limitations.

Hydrogen Regeneration

Four test periods during MBCUO-5 were devoted to hydrogen regeneration. The initial operation in going to hydrogen from methane was complicated because of the exothermicity of the hydrogen regeneration. Due to operational inexperience at this condition, the regenerator was run at an elevated temperature during the first test period. However, the next two periods were conducted at an 850°F regenerator temperature followed by a 750°F condition. Heater controls on the regenerator were observed frequently. All tests were at the same absorption conditions and used hydrogen at a 120 min sorbent residence time in the regenerator and at a 4.65 H_2/S molar ratio. The high concentration of water in the regenerator exit gas also caused some operational problems.

<u>Methane versus hydrogen regeneration</u>

Test period MBCUO-5-1B can be compared with MBCUO-5-5B. Conditions were approximately the same except that a nitrogen diluted hydrogen gas was used in the one period rather than natural gas. Results indicate that the sorbent reactivity was a little lower after the hydrogen regeneration, but this may fall within the range of uncertainty. The nitrogen dilution was used in the hydrogen test because of operational problems downstream of the regenerator. Without the added nitrogen dilution with the hydrogen flow, regenerator gas concentration results would be similar to that of MBCUO-5-5A, with about 85% of the exit gas as SO₂.

From MBCUO-5-5B, no excess hydrogen as well as any other type of gas (H_2S) was seen in the regenerator off-gas, as determined from gas chromatography. Also, the sulfur content on the sorbent from the regenerator was greater than in any previous testing. Duplicates were run confirming this.

Regenerator temperature

The impact of temperature of hydrogen regeneration can be seen in test periods MBCUO-5-5, MBCUO-5-5B, and MBCUO-5-7, where the temperatures were 962, 851, and 755°F respectively. Results from these tests indicate that the SO_2 removal efficiencies did not vary significantly and the concentration of SO_2 exiting the regenerator was near the same for all three cases. Again, no excess hydrogen

2.2

was seen in the exit gas stream. Also, the sulfur content on the sorbent exiting the system was high in all these cases.

Regeneration Parametric Study -- Hydrogen and Natural Gas: MBCUO-6

The concerns of the CRADA partners with respect to synthesis gas $(H_2 + CO)$ regeneration led to additional testing with hydrogen. Interest also exists in trying to maintain good regeneration at a low temperature. A systematic parametric study with hydrogen was proposed for MBCUO-6, with the first two test periods operating at a regeneration temperature about $700^{\circ}F$.

A major concern during the original hydrogen testing in MBCUO-5 and these two test periods in MBCUO-6 was that no excess hydrogen was seen in the regenerator off-gas. A batch test was proposed where volumetric gas samples were taken and hopefully hydrogen would be seen during the breakthrough. After MBCUO-6-2, this batch test was performed in the regenerator. A three hour regeneration with hydrogen at 700°F was conducted. (See Figure 6.) As detected by gas chromatography, hydrogen as well as H_2S was emitted from the reactor during the latter stages of regeneration. Some temperature excursions did occur during this batch test. The initial bed temperatures were around 600-700°F and zoomed as high as 1000°F because of the introduction of pure hydrogen. Also, an increase in pressure due to plugging in the regenerator offgas line led to a brief shutdown that was followed by a resumption of hydrogen flow.

Following the batch test, the sorbent was regenerated with natural gas (MBCUO-6-9) and was compared with baseline periods in test MBCUO-5 (5-1, 5-4, and 5-1B) to see if it had changed significantly. From a SO_2 removal efficiency perspective, it did not appear that sorbent reactivity decreased.

In MBCUO-6-11, MBCUO-6-13, and MBCUO-6-14, attempts were made to observe excess hydrogen exiting the regenerator by increasing hydrogen input to the regenerator. All attempts were unsuccessful in accomplishing this.

General

Pressure Drop Across the Absorber

Pressure drop measurements across the absorber are taken at various locations as shown in Figure 7. The circles in Figure 7 represent the pressure tap points. The tap points are about 1/4-in away from the absorber screen. There are 6 pressure taps within the sorbent bed: 2 taps at each top, middle, and bottom location in the bed. The taps across points 1-4 measure the overall absorber bed pressure drop. The taps across points 1-2 and 3-4 measure the pressure drops across the front and back retention screens, respectively.

Table 13 lists selected pressure drop measurements for MBCUO-4 to MBCUO-6. Pressure drop across the sorbent can be deduced by subtracting (dp 1-2) and (dp 3-4) from (dp 1-4). Note that the dp 1-4 is located only at the bottom of the bed and that in the table, the three measurement for this are for three times during which the measurements were taken. MBCUO-4 used natural gas-firing to produce the flue gas and was the last test with UOP sorbent. As stated earlier, the sorbent particle size distribution had shifted to smaller particles as compared to the initial material. Upon inspection of the reactor at the end of the test, sorbent particles were stuck in the retention screen, and this may explain the higher pressure drop across the bed throughout the test.

MBCUO-5 used natural gas-firing to produce the flue gas for the first part of the test and was the first test with a fresh Grace sorbent. Pressure drops were low during this part of the test. At the end of the testing, the flue gas was produced by burning coal. The high pressure drops indicate particulate accumulation within the absorber. MBCUO-6 used natural gas-firing to produce the flue gas and tested the same Grace sorbent that was used in MBCUO-5.

In all the tests, it appears that the pressure drop across the front screen is negligible; most of the pressure drop can be attributed to buildup within the bed and across the back retention screen. Flyash particles are trapped within the bed and cannot be removed. A new design for the retention screens will hopefully remedy this problem.

Attrition

Sorbent attrition rate is calculated for each test series from sorbent make-up added during a test. Attrition rates are shown in Table 14 together with hours of operation, number of hopper cycles, and accumulative sorbent inventory cycles. From the topical report of Pennline et al. (1995), it must be remembered that the prime contributor to sorbent attrition is the transport of the sorbent within the transport line from the hopper to the fluidized-bed heater.

The sorbent attrition rate is comparable to sorbent attrition during NOXSO life-cycle testing at PETC in 1989.

Uncertainty in Calculated Quantities

Analysis for uncertainty in the SO_2 and NO_x removal efficiency calculations is determined to insure that proper conclusions are made with respect to removal efficiencies.

 SO_3 concentration data may be affected by the following factors. A numerical example is discussed in detail.

(1) Effect of SO₂ analyzer accuracy for the absorber

Inlet conc. +/-2% full scale
full scale: 5000 ppm
max. error = +/- 100 ppm

Outlet conc. +/-2% full scale full scale: 1000 ppm max. error = +/- 20 ppm

Assuming the inlet SO_2 concentration is measured at 2250 ppm, it could range from 2150 ppm to 2350 ppm.

If SO_2 removal is 99% or outlet SO_2 is measured at 22 ppm, it could range from (22-20) = 2 ppm to (22+20) = 42 ppm

The error bar for SO_2 removal efficiency based on analyzers readings would be

maximum = (2350 - 2)/2350 = 99.91% minimum = (2150 - 42)/2150 = 98.05%

The error bar would be from 98.05% to 99.91% with the apparent removal at 99%.

(2) Effect of oxygen analyzer accuracy

Error +/- 2% full scale Full scale is 25% O₂ reading is 5%

Assuming the O_2 measured concentrations are 5% for both absorber inlet and outlet, it could mean 4.5% to 5.5%.

Then, the possible air in-leakage contribution is

fraction = (0.055-0.045)/(0.21 - 0.045) = 0.01/0.165 = 0.0606possible error in ppm reading = 0.0606*2250 ppm = 136 ppm

Then the lowest calculated efficiency value is [2150-42-(136)]/(2150-136) = 1972/2014 = 97.91%.

It is recognized that the analyzer is a major source of error in the removal efficiency calculations. However, this source of error is being minimized by frequent analyzer calibrations. Calibration gas is an independent source of standard; it is blended by high accuracy volumetric mixing.

The remaining source of error is the possible slight non-linearity between cal-gas concentration level and the actual flue gas concentration level. For example, if the cal-gas is 2500 ppm and the actual flue gas concentration is 2300 ppm a very slight nonlinearity may be present.

It is recommended that there is no need to assign an error bar for the data points for the calculated SO_2 removal efficiencies. The same analysis is applicable to uncertainty in NO_x removal efficiency calculation.

It should also be noted that since the data are averaged over a time window, the standard deviation of the calculated value is available from the PETC computerized data file.

SUMMARY

A parametric study of the Moving-Bed Copper Oxide Process was conducted using the LCTS. The effects of various parameters on the absorption step of this flue gas cleanup technique were systematically investigated. High removals of SO_2 were obtained at most conditions. Removal efficiencies within the temperature range of 700-800°F did not vary significantly. A decrease in the flue gas flow rate, a decrease in the inlet SO_2 concentration, and an increase in the sorbent flow rate would all tend to enhance the SO_2 removal capabilities of the absorber.

Regeneration studies investigated the optimization of the natural gas regeneration step with respect to temperature, reducing gas stoichiometric ratio, and sorbent residence time. Optimal regeneration temperature with natural gas is near the reported $850^{\circ}F$ temperature. As the CH₄/S molar ratio increases or the sorbent residence time increases, the regeneration improves.

RECOMMENDATIONS

Hydrogen regeneration requires additional investigations to elucidate the process chemistry. Findings by McCrea et al. (1970) and Bjornbom et al. (1995) indicate that more hydrogen than predicted by the simple copper sulfate/hydrogen reduction equation is needed due to the occurrence of side reactions. Also, regenerator artifacts, if any, must be identified. The possibility of elemental sulfur generated as a product of regeneration may exist at certain conditions. Although elemental sulfur formation could be detrimental pertaining to sorbent life, it could also be an advantage to the overall process. Future investigations with hydrogen will clarify the results to date.

With respect to the LCTS being able to handle flyash particulate loading, information from MBCUO-7 must be analyzed to determine the course of action with the larger-sized Alcoa sorbent to be tested in the future.

December 20, 1995

Summary for Test MBCUO-2 Table 1. Table 2. Summary for Test MBCUO-3 Summary for Test MBCUO-4 Table 3. Table 4. Summary for Test MBCUO-5 Table 5. Summary for Test MBCUO-6 Detailed Information for Test MBCUO-2 Table 6. Detailed Information for Test MBCUO-3 Table 7. Table 8. Detailed Information for Test MBCUO-4 Detailed Information for Test MBCUO-5 Table 9. Table 10. Detailed Information for Test MBCUO-6 Table 11. Daily Hand Data Sheet for Test MBCUO-7 Table 12. Sulfur Analytical Results Table 13. Absorber Pressure Drop Measurements Table 14. Sorbent Attrition Information Figure 1. Effect of Temperature on SO₂ Removal: Experimental and Calculated Effect of SO₂ Concentration on SO₂ Removal: Experimental Figure 2. and Calculated Figure 3. Effect of Sorbent Flow on SO₂ Removal: Experimental and Calculated Effect of Regenerator Inlet Gas CH₄/S Molar Ratio on Figure 4. Regenerator Offgas Composition and Exit Sorbent Sulfur Content Figure 5. Effect of Regenerator Sorbent Residence Time on Regenerator Offgas Composition and Exit Sorbent Sulfur Content Figure 6. Batch Regeneration Results with Hydrogen Figure 7. Location of Pressure Taps in the Absorber

Summary of Test Conditions (Natural Gas Fire)

Test Condition MBCUO-2	1	2	2A	3		l					
Test Date 1995	5/23	5/24	5/26	5/26							
Hours on stream	38.9	16.4	15	15.8		[·······	
Accumulat. sorbent cycle	29.1	30.6	32.0	33.7			• ••• ••••• •••••				
ABSORBER (1 ft x 8 ft)					× .					· · · · · · · · · · · · · · · · · · ·	
Absorber temp.nominal, °F	750	750	750	750		[······································	
Absorber temp.actual, °F	740	748	748	735							
Flue gas, scfm	54.4	54.2	54.3	107.8				[
Sorbent resident time, min	344	172	172	172							
Sorbent flow, lb/min	0.5	1.0	1.0	1.0	······································			[
Inlet SO ₂ , ppm	2247	2252	2239	3059		1					
Outlet SO ₂ , ppm	135	110	102	425			1				
SO ₂ removal, %	94	95	95.2	85.9							
Inlet NOx, ppm	492	NA	NĀ	530			1				
Outlet NOx, ppm	22	NA	NA	316							
NOx removal, %	95.6	NA	NĂ	39.6		1					
NH ₃ flow, lb/h	0.048	0	0	0.044		1					
NH ₃ /NOx mol ratio	0.8	NÁ	NA	0.75	· · · · · · · · · · · · · · · · · · ·	1			,		
REGENERATOR											
regn temp. nominal, "F	850	850	850	850		1					
regn temp. actual, °F	871	878	877	863		1	1				
Resi.time, min	180	180	180	180			1	1			
NG flow, lb/h	0.3	0.3	0.6	1.6		1					
NG/S mol ratio	1.165	1.165	2.34	2.99							
Equivalence	2.33	2.33	4.68	5.98							
H_2 tlow, Ib/h	0	0	0	0							· ·
H ₂ /S mol ratio								ļ			
SO Ø	24.5	- 25	10.0			ļ					
$\frac{1}{1}$	24.5	25	19.0	22.1		ļ					
	0.2	30.1	35.5	51.7						· · · · · · · · · · · · · · · · · · ·	
$P_{aan} off aas fi3(m (dry))$	9.2 NIA	0.5	9.2	51.7	 	ļ					
(total Cu)/S mol ratio	1 07	1NA 2 72	NA 2.74		ļ	.					
Cu utilization Ø	1.87	3.12	3.74	1.38							
Sulfur halance (and phase) of	50.2	25.0	25.5	62							
Unregenerated S %	INA 0.99		NA	NA		L		· · · · · · · · · · · · · · · · · · ·			
Omegenerateu 5, 70	0.88	NA	0.98	NA							

Table 1. Summary for Test MBCUO-2

Summary of Test Conditions (Natural Gas Fire)

Test Condition MBCUO-3	1	2	2A	1A	3	18	4	5	6	7	8
Test Date 1995	6/13	6/14	6/15	6/15	6/16	6/16	6/17	6/18	6/18	6/19	6/20
Hours on stream	29.01	20.5	18.57	12.35	14.45	2.87	15.57	20.62	14.4	20.73	7.22
Accumulat. sorbent cycle	37.84	40.23	42.45	43.99	45.77	46.09	48.0	50.36	53.04	57.32	61.85
ABSORBER (1 ft x 8 ft)											
Absorber temp.nominal, °F	750	700	700	750	800	750	750	750	750	750	600
Absorber temp.actual, °F	755	700	705	749	800	749	750	755	738	756	591
Flue gas, scfm	107	107	107	107	107	107	107	107	107	107	106
Sorbent resident time, min	117	117	117	117	117	117	117	117	156	94	117
Sorbent flow, lb/min	1	1	1	1	1	1	1	1	0.75	1.25	1
Inlet SO ₂ , ppm	2237	2277	2255	2242	2223	2218	1500	3244	2261	2261	2249
Outlet SO ₂ , ppm	209	242	171	153	164	123	56	606	303	199	521
SO ₂ removal, %	90.5	89.2	92.4	93.2	92.5	94.4	96.3	81.2	86.5	91.1	76.6
Inlet NOx, ppm	519	474	NA	523	494	NA	522	513	493	491	NA
Outlet NOx, ppm	19	23	NA	31	31	NA	42	31	39	32	NA
NOx removal, %	96.3	95.1	NA	94.1	93.6	NA	92	93.9	92	93.3	NA
NH ₃ flow, lb/h	0.114	0.107	0	0.133	0.123	0	0.122	0.121	0.117	0.123	0
NH ₃ /NOx mol ratio	0.91	0.94	NA	1.06	1.04	NA	0.96	0.97	0.99	1.05	NĂ
REGENERATOR											
regn temp. nominal,°F	850	850	850	850	850	850	850	850	850	850	850
regn temp. actual, °F	850	855	863	861	861	878	870	846	888	874	841
Resi.time, min	180	180	180	180	180	180	180	180	180	180	180
NG flow, lb/h	0.6	0.6	0.6	0.6	0.6	0.6	0.5	0.82	0.6	0.6	0.6
NG/S mol ratio	1.183	1.246	1.238	1.183	1.19	1.198	1.47	1.115	1.172	1.17	1.19
Equivalence	2.36	2.49	2.48	2.366	2.38	2.4	2.94	2.23	2.344	2.34	2.38
H ₂ flow, lb/h	0	0	0	0	0	0	0	0	0	0	0
H ₂ /S mol ratio											
so %	215	20.0	20.0	20.0	22.0		- 24.2	- 26	22.7		
$\frac{30_2}{CO}$	277		40.5		27.0	42	40	27	26.0	20.9	20.0
	07	41.0	40.5	41.0	57.0	43	40	37	30.0	39.0	5.0
$\mathbf{D}_{\text{agn off ass } \mathbf{f}_{1}^{2}(\mathbf{m}_{1}^{2}(\mathbf{d}_{T}\mathbf{v}))$	0.1	0.55			0.54	4.0 NIA		0.67	14.0	0.55	J.9 NA
(total Cu)/S mal ratio	1 0.55	1.94			1.02		7.95	0.07	1.42	0.33	1.02
Cu utilization %	1.00	1.04	1.9	1.91	1.92	1.95	2.05	61.5	60.0	2.57	1.92
Sulfur balance (gas phase) %	40.2	40.4	40.0	40.0	40.2	40.9	33.0 NA		24.0	30.4	39.9
Unregenerated S %	0.84	0.01	NA		-0.9		1 12	+2.4	-24.9	-1.4	
Unregenerated 5, 70	0.04	0.71		INA	1.5	IN/A	1.13	1	1.02	1.04	1.04
		L			1	1		1			

Table 2. Summary for Test MBCUO-3

Summary of Test Conditions (Natural Gas Fire)

Test Condition MBCUO-4	1	2	3	4	6	6A	4A	7	8	9	
Test Date 1995	7/18	7/19	7/20	7/22	7/23	7/24	7/25	7/26	7/27	7/28	
Hours on stream	29.9	17.6	20.5	37.7	34.4	31.4	11.7	- 26.4	17.3	13.1	
Accumulat. sorbent cycle	63.6	65.3	67.4	70.6	74.4	77	78.4	80.6	82.3	83.9	
ABSORBER (1 ft x 8 ft)											
Absorber temp.nominal, °F	750	750	750	750	750	750	750	750	750	750	
Absorber temp.actual, °F	757	752	746	752	750	751	750	751	748	752	
Flue gas, scfm	110.7	111	110.9	110.5	110.3	112.5	112.5	112.4	112.4	112.2	
Sorbent resident time, min	200	200	200	200	200	200	200	200	200	200	
Sorbent flow, lb/min	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	
Inlet SO ₂ , ppm	2270	2270	2251	2243	2278	2256	2281	2235	2229	2220	
Outlet SO ₂ , ppm	255	295	335	343	481	395	530	366	496	385	
SO ₂ removal, %	88.6	86.8	84.6	84.0	78.3	82.0	76.4	83.5	76.6	81.8	
Inlet NOx, ppm	504	494	498	NA	NA	494	501	491	473	NA	
Outlet NOx, ppm	17	26	25	NA	ŇĂ	18	25	27	11	NA	
NOx removal, %	96.5	94.6	94.7	NA	NA	96.2	95	94.4	97.6	NA	
NH ₃ flow, lb/h	0.097	0.096	0.094	0	0	0.095	0.099	0.093	0.094	0	
NH ₃ /NOx mol ratio	0.83	0.84	0.81	NA	NA	0.83	0.85	0.8	0.87	NA	
REGENERATOR											
regn temp. nominal,°F	850	850	850	850	900	900	850	850	800	800	
regn temp. actual, °F	839	851	845	850	934	937	881	876	815	785	
Resi.time, min	180	180	180	120	120	120	120	60	60	60	
NG flow, lb/h	0.6	0.45	0.3	0.6	0.6	0.6	0.6	0.6	0.6	0	
NG/S mol ratio	1.17	0.873	0.59	1.18	1.16	1.154	1.14	1.17	1.17	0	
Equivalence	2.34	1.746	1.18	2.36	2.32	2.308	2.28	2.34	2.34	0	
H ₂ flow, lb/h	0	0	Ō	0	0	0	0	0	0	0.3	
H_2/S mol ratio					l					5	
Equivalence										2.5	
SO ₂ , %	39.7	46.2	52.5	34.7	25.6	25.9	30.9	31.2	31.9	56.7	
CO ₂ , %	41.9	46.1	42.6	39.6	37.7	38.3	37.8	34.1	24.0	0	
CH ₄ , %	18.9	6.4	0.7	28.6	31.7	31.3	32.8	36.2	42.9	0	
Regn off-gas,ft ³ /m (dry)	0.416	0.382	0.103	0.392	0.267	0.349	0.36	0.387	0.411	NA	
(total Cu)/S mol ratio	1.36	1.36	1.38	1.38	1.36	1.35	1.34	1.37	1.37	1.38	
Cu utilization, %	65	64	62	60.6	57	60.7	57	61	56	59.4	
Sulfur balance (gas phase), %	-8.4	-0.04	-68.1	-19.5	-59.1	-30	-29.6	-28.7	-35.2	NĂ	
Unregenerated S, %	0.74	1.05	2.43	0.95	0.6	NA	NA	1.3	1.47	1.14	
					ι.						

Table 3. Summary for Test MBCUO-4

Summary of Test Conditions (Natural Gas/Coal Firing)

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GRACE SORBENT

Test Condition MBCUO-5	1 1	2	3	4	5	5A	5B	7	IA	1B	9A	10	11	12A	12B	12C
Test Date 1995	8/15	8/16	8/16	8/17	8/18	8/19	8/20	8/21	8/21	8/22	8/23	8/24	8/24	8/25	8/25	8/25
Hours on stream	24.33	17.23	9.42	9.08	23.93	49.42	20.03	9.72	13.87	15.27	13.22	8.05	12.1	5.53	1.77	1.77
Accumulat. sorbent cycle	2.5	4.7	5.9	7.2	9.8	14.2	16.7	17.9	19.5	21	22.8	24.1	25.6	26.4	26.8	27
ABSORBER (1 ft x 8 ft)																
Absorber temp.nominal, °F	750	750	750	750	750	750	750	750	750	750	750	750	750	750	750	750
Absorber temp.actual, "F	760	761	755	760	755	751	768	747	744	758	754	739	752	746	765	775
Flue gas, scfm	111	107	108	108	108	107	108	108	108	108	56	56	56	58	58	58
Sorbent resident time, min	195	195	195	195	195	195	195	195	195	195	146	146	146	146	146	146
Sorbent flow, 1b/min	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	1	1	1	1	1	1
Inlet SO ₂ , ppm	2155	2207	2197	2336	2239	2261	2250	2254	2241	2237	2052	2117	2074	2201	2209	2229
Outlet SO ₂ , ppm	130	134	163	146	184	254	194	200	220	165	14	40	336	206	90	71
SO ₂ removal, %	93.8	93.8	92.4	93.6	91.6	88.4	91.1	90.8	89.8	92.4	99.3	97.9	82.7	90.3	95.8	96.7
Inlet NOx, ppm	510	492	NA	503	NA	NA	497	500	NA	500	703	NA	649	NA	NA	NA
Outlet NOx, ppm	26	23	NA	42	NA	NA	50	24	NA	22	19	NĂ	NA	NA	NĂ	NA
NOx removal, %	94.8	95.2	NA	91.3	NA	NA	89.6	95.1	NA	95.4	97.1	NA	NA	NA	NA	NA
NH, flow, lb/h	0.104	0.093	0	0.089	0	0	0.085	0.098	0	0.096	0.07	0	0	0	0	0
NH ₃ /NOx mol ratio	0.83	0.79	0	0.73	0	0	0.72	0.83	0	0.83	0.73	0	0	0	Ō	0
REGENERATOR																
regn temp. nominal,°F	850	850	850	850	850	850	850	750	800	850	850	750	750	750	750	750
regn temp. actual, °F	857	851	849	855	962	820	851	755	797	847	869	752	786	777	772	781
Resi.time, min	120	120	120	120	120	120	120	120	120	120	90	90	90	90	90	90
NG flow, lb/h	0.6	0.6	0.3	0.6	0	0	0	0	0.6	0.6	0.28	0.28	0	0	0	0
NG/S mol ratio	1	1	0.5	1					1	1	1	1				
Equivalence	2	2	1	2					2	2	2	2				
H ₂ flow, lb/h	0	0	0	0	0.3	0.3	0.3	0.3	0	$\overline{0}$	0	0	0.14	0.15	0.3	0.45
H ₂ /S mol ratio					5	5	5	5					4.7	5	10	15
Equivalence	- 12				2.5	2.5	2.5	2.5	13				2.4	2.5	5.	7.5
$\frac{3O_2}{CO}$	42	- 21	- 10		22.0	04.0	14	10	4/	43	- 22	0.7	20	1.5	29	33
<u>CH</u> %	11.5	12	43	12		0		0	33.1	39.4	- 22	10	0	0		0
Pean off and ft ¹ (m (dm))	0.455	0.715	0 269	0.454	0 (46		1 170	0	17.0	9.4	0.62	23	0		0	
(total Cu)/S mol ratio	1 57	1 50	1.50	1.40	1.40	1.40	1.179	1.1/	NA 156	0.55	0.53	0.53	NA 2.06	NA	NA	NA
Cu utilization %	60	50	58 4	62.8	61 5	50 2	1.50	59.2	1.30	1.55	3.98	3.80	3.90	3.91	3.91	3.82
Sulfur balance (gas phase) %	+27	+41	-25.6	110	20.7	J9.5	38.4	38.2	57.7	39.0	24.9	25.4	20.9	23.1	24.5	25.3
Linregenerated S %	1 13	1 01	2 00	+1.0 NA	-20.7	2.01	-11.3	1 60		-3.0	NA	-	NA	NA	NA	NA
Coal lb/br			2.70		1.09	2.01	1.85	1.08	2.3	0.73	NA 20 11	NA 20.80	NA 20.22	NA	NA	NA
	<u> </u>	<u> </u>	<u> </u>	0	0	U	0	0	0	0	30.71	30.80	30.73	0	0	0

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GRACE SURBENT		Summary	y of Test	Condition	is (Natural	Gas Fire	e)				
Test Condition MBCUO-6	1	2	9	10	11	13	14		T.	1	Ī
Test Date 1995	10/19	10/20	10/22	10/23	10/25	10/26	10/27		l		<u> </u>
Hours on stream	35.23	34.35	31.33	19.92	36.68	24.9	11.58				
Accumulat. sorbent cycle	32.6	37.6	40.3	43.2	48.1	50.9	52.9				
ABSORBER (1 ft x 8 ft)											
Absorber temp.nominal, °F	750	750	750	750	750	750	750				<u> </u>
Absorber temp.actual, °F	742	762	750	762	750	755	751			+	<u> </u>
Flue gas, scfm	106	109	109	110	110	110	108			-	+
Sorbent resident time, min	146	146	195	146	146	146	146				+
Sorbent flow, lb/min	1	1	0.75	1	1	1	1			1	1
Inlet SO ₂ , ppm	2276	2290	2250	2245	2244	2296	341				†
Outlet SO ₂ , ppm	334	122	130	102	128	172	3		<u> </u>		<u> </u>
SO ₂ removal, %	85.3	94.7	94.2	95.5	94.3	92.5	99.2				<u> </u>
Inlet NOx, ppm	NA	516	NA	NĀ	NA	NA	NA		<u> </u>	+	†
Outlet NOx, ppm	NA	18	NA	NĂ	NA	NA	NA		<u> </u>	+	<u>}</u>
NOx removal, %	NA	96.5	NA	NA	NA	NA	NA				
NH ₃ flow, lb/h	0	0.126	0	0	0	0	0		 		1
NH ₃ /NOx mol ratio	0	0.996	0	0	0	0	0				
REGENERATOR	1									1	
regn temp. nominal,°F	700	700	850	850	850	850	750		 		1
regn temp. actual, "F	704	719	849	860	850	834	744		<u> </u>	1	1
Resi.time, min	60	60	120	120	120	120	120		1	1	+
NG flow, lb/h	0	0	0.6	0.6	0	0	0				
NG/S mol ratio			1	1							
Equivalence			2	2						1	
H ₂ flow, lb/h	0.15	0.30	0	0	0.45	0.6	0.3			1	1
H ₂ /S mol ratio	2.5	5			7.5	10	5				
Equivalence	1.25	2.5	<u> 71 00</u>	1	3.75	5	2.5				
$\frac{50_2}{60}$	22.10	21.15	51.09	45.55	44.36	47.35	17.69				
$CU_2, 70$	0.01		43.35	44.66	0	0	0.02		ļ		
CH_4 , 70	0.61	0.1	5.86	3.66	0.77	0.64	0.04				
(total Cuv/S mal antio	0.533	0.529	0.428	0.412	0.588	NA	0.234				
Cu utilization Ø	2.07	2	1.53	2.03	2.03	1.98	13.6	·····			
Cu utilization, %	41.2	47.4	61.6	47	46.6	46.7	7.3				
Junur Dalance (gas.phase), %	-31.5	-40.8	+11.6	-5.2	+36.2	NA	+19.6				
Unregenerated S, %	4.41	5.14	1.5	1.2	2.6	1.9	2.6				

Table 5. Summary for Test MBCUO-6

	PARAMETER	TAG	E/U	1	2	3	4
COMBUSTOR FLE				COMBOIS	COM8018	COMBOIS	COM8020
	COMB AR	FY-1	#/HR	430.5	430.6	430.5	430.4
	MOTIVE AIR	FY-3	#/HR #/HR	22.65	22.81	22.60	22.80
·	COAL	WKT-26	\$/HR	0.00	0.00	0.00	0.00
	FEEDER WT	WT-26	L88 %YRA	0.00	0.00	0.00	0.00
	HEATINPUT	BTU	BTUNHR	604572	608411	608194	\$08248
	FLUE GAS MA	FY-18	#/HR	622.5	\$21.5	523.2	524.1
	FURNACE 02	PT-6	H2O	-1.02	-0.96	-1.03	-0.96
	COMB AIR P	PT-1	PBIG	4.48	4.50	4.67	4.56
	NATURAL GAS P	PT-20	PBKG	4.16	4.19	4.20	4.18
	FLUE GAS P	PT-16	- H20	6.27	6.17	6.29	8.07
	THEORAIR	8Y-X	THEOAR	381.22	343.69	363.76	343.76
	FURNACE CO2	AT-C02-0	PERCENT	9.73	9.96	9.89	10.01
	MOTIVE AIR V	8Y-3	FT/SEC	0.00	0.00	0.00	0.00
	FLUE GAS (M	FY-18	SCFM	112.1	111.0	112.2	112.4
ABSORBER FLE	<u> </u>	<u>}</u>	<u> </u>	A85026	A8826627	A8826427	A55026
	NLET SOR	AT-802-1	PPM	2247	2262	2239	3060
	INLET NOX	AT-NOX-1	PERCENT	492	4,33	4,38	4,36
	OUTLET 802	AT-802-2	PPM	136	110	102	426
	OUTLET NOX	AT-NO1-2	PPM	4 73	4.77	116	216
	NO SPIKE	FT-101	\$/HR	0.11	0.00	0.00	0.13
	302 SPKE	FT-102	#/HR	1.48	1.41	1.42	2.16
	BED DP	POT-19	H2O	0.78	0.96	1.18	2.81
	FLUE GAS DO	FY-17	#/HR	263.7	262.0	263.3	602.8
	SCREEN DP	PDT-21	H2O	0.20	0.31	0.44	1.38
	GAS NEET	TE-18	DEGF	747	747	748	747
	SOME IN	TE-390	DEGF	733	748	742	758
	SORE OUT	TE-301 8028FF	PERCENT	663 64 0	726	726	722
	NOX REMOVAL	NOXREF	PERCENT	94.6	4.4	0.6	39.6
	FLUE GAS (M	FY-17	SCPM	<u>84.6</u>	54.2	54.3	107.8
REGENERATOR FLE				RE GO25	RE 026427	RE 029427	RE GO20
	REGEN 602	AT-02-44	PERCENT	0.01	26.01	0.25	22.11
	REGEN CH4	AT-CH4-4	PERCENT	9.19	0.80	8.16	81.71
	REGEN CO2	AT-CO2-4	PERCENT	36.81	30.13	35.54	21.40
	REGEN 02	AT-02-48	PERCENT	0.44	8.73	0.03	0.11
	NATURAL GAS	FY-300	#/HR #/HB	0.30	0.30	0.60	0.001
	REGENP	PT-380	H2O	1.02	3.34	5.80	14.27
·····	TSORG LEVEL	TE-300	DEGF	21.23	48.83	48.71	46.74
	TSOR8 (17)	TE - 382	DEGF	840	823	836	832
·	TSORE (327)	TE-383	DEGF	844	900	874	879
	TGAS(EXIT)	TE - 386	DEGF	796	763	760	768
	T COND EX	TE-386 TE-387	DEGF	131	136	147	55
	TINC EX	TE-200	DEGF	483	418	358	361
·····	INCIN 02	AT-02-6	PERCENT	21.86	21.63	21.80	21.76
I PLUID BED HEATEMPER			DEGE	1100	- 5H26627	1071	P SHUZE
	T\$OR8(12)	TE-373			10/40		1078
	TSORE(12) NATURAL GAS	TE-373 FY-65	#/HA	6.03	6.32	6.27	1078
	TSORB(12) NATURAL GAS AHTR AIR (M) FBH VEL	TE-373 FY-56 FY-30 SY-30	#/HR #/HR FT/SEC	6.03 272.8 3.00	6.32 278.6 3.00	6.27 260.0 3.00	1078 6.42 279.1 3.00
	TSORB(12) NATURAL GAS AHTR ANR (M) FBH VEL FBH 02	TE-373 FY-55 FY-30 SY-30 AT-02-3	#/HR #/HR FT/SEC PERCENT	6.03 272.8 3.00 18.02	6.32 278.8 3.00 18.60	6.27 280.0 3.00 19.80	1078 6.42 279.1 3.00 20.67
	TSORB(12) NATURAL GAS AHTR AIR (M) FBH VEL FBH 02 TAHTR OUT T PLENUM	TE - 373 FY-55 FY-30 3Y-30 AT-02-3 TE-370 TE-372	#/HR #/HR FT/SEC PERCENT DEG F DEG F	8.03 272.8 3.00 18.02 1385 784	6.32 278.5 3.00 19.60 1415 812	6.27 280.0 3.00 19.80 1394 806	1078 6.42 279.1 3.00 20.67 1430 818
	TSORB(12) NATURAL GAS ANTR AIR (M) FBH VEL FBH 02 TAHTR OUT T PLENUM TSORB(24)	TE - 373 FY - 56 FY - 30 SY - 30 AT - 02 - 3 TE - 370 TE - 372 TE - 374	#/HR #/HR FT/SEC PERCENT DEGF DEGF DEGF	6.03 272.6 3.00 18.02 1386 784 1099	1074 6.32 278.8 3.00 19.60 1418 812 1071	6.27 260.0 3.00 19.80 1394 806 1069	1078 6.42 279.1 3.00 20.67 1430 818 1072
	TSORB(127) NATURAL GAS ANTR AIR (M) FBH VEL FBH OUT TAHTR OUT T PLENUM TSORB(247) TVENT THUM OUT	TE - 373 FY - 54 FY - 30 SY - 30 AT - 02 - 3 TE - 370 TE - 372 TE - 376 TE - 376	J/HR J/HR FT/SEC PERCENT DEGF DEGF DEGF	6.03 272.8 3.00 18.02 1386 784 1099 982 326	6.32 278.8 3.00 19.60 1416 812 1071 961 326	6.27 260.0 3.00 19.80 1394 806 1069 948 326	1078 6.42 279.1 3.00 20.67 1430 818 1072 358 326
	TSORB(127) NATURAL GAS ANTR AIR (M) FBH VEL FBH OUT TAHTR OUT T PLENUM TSORB(247) TVENT THUM OUT FBH PMES	TE-373 FY-86 FY-30 SY-30 AT-02-3 TE-370 TE-372 TE-374 TE-376 FT-376 PT-376	J/HR J/HR FT/SEC PERCENT DEG F DEG F DEG F DEG F DEG F	6.03 272.8 3.00 18.02 1386 784 1099 982 3.26 6.46	6.32 278.8 3.00 19.60 1418 812 1071 961 3.25 3.92	6.27 280.0 3.00 19.80 1394 806 1099 948 325 3.67	1078 6.62 276.1 3.00 20.87 1430 818 1072 958 326 1.14
	ТВОРВ(12) МАТURAL GAS АНТR АІЯ GA FBH VEL FBH 02 ТАНТВ ОUT T PLENUM TOOBG(4) TVENT THUM OUT FBH PAES BED DP PLENUM DP	TE - 373 FY - 85 FY - 30 SY - 30 AT - 02 - 3 TE - 370 TE - 376 TE - 376 PT - 376 PDT - 376	F/HR F/HR F/SEC PEACENT DEGF DEGF DEGF DEGF H20 H20 H20	6.03 272.8 3.00 18.02 1386 784 1099 982 3.26 6.46 6.46 10.81 19.27	074 6.32 278.6 3.00 19.60 1416 612 1071 961 3.25 3.92 13.30 9.57	6.27 280.0 3.00 19.80 1394 806 1068 948 326 3.47 1.62 9.67	1078 6.42 278.1 3.00 20.87 1430 818 1072 988 326 1.14 13.84 13.84
	ТВОРВ(12) MATURAL GAS AHTR AIR 60 FBH VEL FBH 02 TAHTR OUT T PLENAM TSORB(24) TVENT THUM OUT FBH PRES BED 09 PLENAM 09 FBH MOX	TE - 373 FY - 46 FY - 46 FY - 30 SY - 30 SY - 30 TE - 370 TE - 370 TE - 376 TE - 376 FT - 376 FT - 376 PT - 377 PD - 377 AT - NOX - 3	F/HR F/HR F/13EC PERCENT DEGF DEGF DEGF H20 H20 H20 H20 H20 H20	6.03 272.8 3.00 18.02 1385 784 1099 982 3.26 6.45 10.81 9.27 9.29	074 6.32 278.6 3.00 19.60 1416 812 1071 9451 3.262 3.92 13.30 9.67 3.41	6.27 6.27 280.0 3.00 19.80 1384 806 1069 948 326 3.47 1.62 9.57 3.19	1078 6.42 278.1 3.00 20.87 1430 818 1072 988 326 1.14 13.54 9.71 0.66
	150 PB(12) MATURAL GAS ANTR AIR 60 FBH VEL FBH 02 TAHTR OUT T PLENAM TSORB(24) TVENT THUM OUT FBH PRES BED DP PLENAM OP FBH NOX FBH SO2 ANTR AIR M	TE - 373 FY - 45 FY - 30 SY - 30 AT - 02 - 3 TE - 370 TE - 376 TE - 376 TE - 376 PT - 377 PT - 377 AT - NOX - 3 AT - NOX - 3 AT - NOX - 3 FY - 30	F/HR F/HR F/15EC PERCENT DEGF DEGF DEGF H20 H20 H20 H20 H20 PPM SCFM	6.03 272.8 3.00 13.95 784 1099 982 3.26 6.45 10.91 10.91 9.27 9.29 2.21 55.8	0.32 0.32 278.6 3.00 19.60 1416 612 1071 945 3.26 3.52 13.30 9.67 3.41 0.00 61.0	6.27 6.27 280.0 3.00 19.60 1394 806 806 1394 806 1394 806 806 1394 806 806 806 806 806 806 806 806	1078 6.42 278.1 3.00 20.67 1430 818 1072 958 326 1.14 13.84 13.84 9.71 0.68 6.43 61.2
	150 PB(12) MATURAL GAS ANTR AIR 60 FBH 02 FBH 02 TAHTR OUT T PLENUM TSORB(24) TVENT THUM OUT FBH PRES BED 0P PLENUM 0P FBH PAES FBH SO2 ANTR AIR (M) REG MGAS (M)	TE - 373 FY - 45 FY - 30 SY - 30 AT - 02 - 3 TE - 370 TE - 376 TE - 376 TE - 376 PT - 377 PT - 377 AT - NOX - 3 AT - NOX - 3 AT - NOX - 3 AT - NOX - 3 FY - 300 FY - 307 FY - 300 FY - 307 FY - 300 FY -	FINE FINE PEACENT DEGF DEGF DEGF H20 H20 H20 H20 PPM PPM SCFM SCFM	6.03 272.8 3.00 13.02 1385 784 1099 982 3.26 6.46 10.81 9.827 9.29 2.21 2.21 85.8 0.11	0.22 0.32 270.6 3.00 19.60 19.60 1416 612 1071 945 3.02 13.30 9.67 3.41 0.00 61.0 9.11	(01) 6.27 280.0 3.00 19.80 1334 806 1354 806 1354 806 948 325 3.47 11.62 9.67 3.19 0.00 01.4 0.22	1078 6.42 278.1 3.00 20.67 1430 818 1072 958 326 1.14 13.64 9.71 0.68 6.43 61.2 0.69
	TSORB(12) MATURAL GAS AHTR AIR GA FBH VEL FBH VEL FBH VEL TAHTR OUT TPUENUM TSORB(24) THURN OUT FBH PRES BED DP PLENGM DP FBH NOX FBH SO2 AHTT AIR (M FBH SO2	TE - 373 FY - 15 FY - 15 SY - 30 AT - 02 - 3 TE - 370 TE - 370 TE - 377 TE - 376 FT - 376 PDT - 377 PDT - 377 PDT - 377 PDT - 376 PDT - 377 AT - NOX - 3 AT - NOX - 3 FY - 300 FY - 3106	FINE FINE PEACENT DEGF DEGF DEGF DEGF H20 H20 H20 H20 PPM PPM SCFM SCFM	6.03 272.6 3.00 18.02 1386 784 1099 982 3.26 6.45 10.81 9.27 9.29 2.21 58.6 0.11 0.00	10/2 6.32 276.6 3.00 18.60 1415 612 1071 9451 3.26 3.62 3.62 3.62 3.62 9.67 3.41 0.00 61.0 0.11	6.27 280.0 3.00 19.80 1384 806 1068 948 326 3.47 11.62 9.67 3.19 0.00 91.4 0.22 0.00	1078 6.42 278.1 3.00 20.67 1430 818 1072 958 326 1.14 13.64 9.71 0.68 6.43 81.2 0.69
	TSORB(12) MATURAL GAS AHTR AIR 64) FBH VEL FBH VEL FBH 02 TAHTR OUT TPLENUM TSORB(24) TVENT THEN OUT FBH PRES BED DP FEH NOX FBH SO2 AHTR AIR (M) REG NGAS (M) REG NGAS (M)	TE - 373 FY - 45 FY - 45 SY - 30 AT - 02 - 3 TE - 370 TE - 372 TE - 376 FT - 376 FT - 376 PDT - 377 PDT - 377 PDT - 377 AT - NOZ - 3 AT - NOZ - 3 FY - 3008 FY - 3108	FINE FINE PERCENT DEGF DEGF DEGF DEGF H20 H20 H20 H20 H20 H20 H20 H20 H20 H20	6.03 272.6 3.00 18.02 1386 7844 1099 982 3366 6.45 10.91 9.29 2.21 5.9.0 9.29 2.21 5.9.0 0.11 0.00	078 6.322 278.5 3.00 1415 1071 941 3.255 3.362 13.30 9.325 3.362 13.30 9.325 3.41 0.00 0.11 0.00 9.11 0.00 9.51 1.5266 1.526 1.526 1.5266 1.526 1.5266 1.5266 1.5266 1.5	6.27 280.0 3.00 19.80 19.80 19.80 19.80 19.80 19.84 19.85 3.47 11.62 9.48 3.47 3.47 3.19 0.00 0.00 0.00 0.00 0.00 0.00 0.00 0	1078 6.42 278.1 3.00 20.87 1430 818 1072 945 935 1072 945 935 1.14 13.54 1.3.54 1.3.54 9.71 0.64 9.71 0.65 0.69 0.69
	TSORB(12) MATURAL GAS AHTR AIR GA FBH VEL FBH VEL TAHTR OUT T PLENUM TSORB(24) TORGAY TWENT THUM OUT FBH PRES BED DP FBH NOX FBH NOX FBH SO2 AHTR AIR GA PLENUM DP FBH SO2 AHTR AIR GA PE O CAR YEL AIR GA	TE - 373 FY - 45 FY - 45 FY - 45 FY - 50 SY - 30 TE - 370 TE - 370 TE - 376 TE - 376 TE - 376 FT - 376 PDT - 377 PDT - 377 PDT - 377 AT - 802 - 3 FY - 300 FY - 300 FY - 300 FY - 300	5/HA 5/HA 5/HA 5/T/SEC DEG F DEG F DEG F DEG F DEG F H20 H20 H20 H20 H20 H20 H20 H20 H20 H20	6.03 272.6 3.00 18.02 1386 882 326 882 326 8.06 10.81 19.27 9.29 2.21 8.00 0.11 0.00 9.22 9.22 8.00 0.11 0.00 10.0	078 0.22 278.6 3.00 18.80 18.80 18.80 18.80 18.80 18.80 9.87 3.41 3.26 9.87 3.41 0.00 0.11 0.00 0.11 0.00 0.11 0.00 18.00 19.00 10.0	6.27 290.0 3.000 19.80 19.80 19.80 19.80 19.80 948 325 3.47 11.62 9.57 3.19 0.00 61.4 0.00 61.4 0.00 65 62084.27 3.00	1078 6.42 279.1 3.00 20.67 1430 1430 1430 1430 1072 583 328 1072 585 1.14 1.14 1.3.64 5.45 6.43 6.43 6.43 6.43 6.43 6.45
	TSORB(12) MATURAL GAS AHTR AIR 60 FBH VEL FBH VEL FBH VEL TAHTR OUT T PLENAM TSORB(24) TVENT THUM OUT FBH PRES BED DP PLENAM OP FBH NOX FBH NOX REG NGAS (Y) REG NGAS (Y) FEC ART VEL ARTR AR (M) FBLENAM YLENAM YLENAM	TE - 373 FY - 16 FY - 16 SY - 30 AT - 02 - 3 TE - 376 TE - 376 TE - 377 TE - 376 TE - 377 TE - 376 PDT - 377 PDT - 377 AT - N02 - 3 AT - 302 - 3 FY - 300 FY - 300 FY - 360 FY - 376 FY - 376 FY - 377 FY - 370 FY	SIMA SIMA FIVEC FIVEC DEGF DEGF DEGF DEGF DEGF H20 H20 PPM SCFM SCFM SCFM SCFM SCFM SCFM	6.03 272.8 3.00 18.02 1386 882 326 6.46 10.91 9.27 9.29 2.21 88.8 0.11 9.27 9.29 2.21 88.8 0.11 9.27 9.29 2.21 88.8 0.11 0.00 9.22 10.00 8 2.21 8.00 10.00 1	078 078 078 078 078 078 078 077 071 071 071 071 071 071 071	6.27 290.0 3.000 19.80 1384 308 808 808 328 3.47 11.62 9.67 3.19 0.00 81.4 0.022 0.00 87.62264.27 3.00 97.62264.27 3.00	1078 6.42 275.1 3.00 20.67 1430 848 1072 948 1072 948 1072 948 1072 948 1072 948 1072 948 1072 948 1072 948 1072 948 1072 948 1072 948 1072 948 1072 10.64 10.66 10.
	TSORB(12) MATURAL GAS AHTR AIR 60 FBH VEL FBH VEL FBH VEL FBH VEL TAHTR AIR 60 FBH VEL FBH VEL TPLENAM TORB(24') TVENT THUM OUT FBH PRES BED OP PLENAM OP FBH SO2 AHTR AIR (M) REG N2 (M) FBC ARI VEL FBC ARI VEL AR MB TLENAM TLENAM	TE - 373 FY - 56 FY - 50 SY - 30 AT - 02 - 3 TE - 376 TE - 376 TE - 376 TE - 376 TE - 376 TE - 376 TE - 376 PDT - 376 PDT - 376 PDT - 376 PDT - 376 FY - 300 FY - 300	7 MB 7 MB	6.03 272.6 3.00 18.02 13.96 982 326 6.45 10.91 982 2.21 2.21 5.8.0 0.11 0.00 9.25 2.21 2.21 5.8.0 0.11 0.00 9.25 9.25 9.25 1.2.21 9.25 9.25 9.25 9.25 9.25 9.25 9.25 9.25	072 072 072 072 072 074 074 074 074 074 074 074 074	6.27 200.0 3.000 19.80 1988 806 1068 948 3.22 3.17 11.52 9.67 3.19 0.000 9.1.52 9.67 3.19 0.000 9.62 8.62 9.62 9.62 9.62 9.62 9.62 9.62 9.62 9	1078 1078 1078 1078 1078 1078 1078 1072 1430 1072 1430 1072 1585 1.14 13.54 14.54 13.54 15
	TBORB(12) MATURAL GAS AHTR AIR GAS FBH VEL FBH VEL FBH VEL TAHTR OUT TPUENUAL TBORB(24) THUR OUT FBH PRES BED DP PLENGAD DP FBH NOX FBH SO2 ANTR AIR (M FBC MADA (M) FEG NGAD (M) FEG NGAD (M) FEG NGAD (M) FELENUAL DP FBL NUM T PLENUAL T PLENUAL T PLENUAL T PLENUAL T PLENUAL DP PLENUAL DP PLENUAL DP PLENUAL DP	TE - 373 FY - 46 FY - 46 FY - 46 SY - 30 SY - 30 TE - 370 TE - 376 PT - 377 TE - 376 PT - 377 PDT - 377 PDT - 377 PDT - 377 PDT - 377 FY - 30 FY - 30	7 MAR 7 MAR 7 MAR 7 MAR 7 MAR 7 MAR 7 MAR 1	6.03 272.6 3.00 19.02 19.96 982 982 982 982 9.29 9.29 9.29 9.29 9.2	1076 8.32 278.4 3.00 19.60 19.60 19.60 19.60 19.60 10.00	6.27 280.0 3.000 19.60 19.60 19.60 19.60 19.60 19.60 19.60 19.60 19.67 3.19 0.000 67.4 0.022 0.000 19.0.67 19.62 0.000 19.00 19.62 0.000 19.60 19.00 10.00 19.	1078 1078
FLUD SED COOLER FLE	TSORB(12) MATURAL GAS AHTR AIR GA FBH VEL FBH VEL FBH VEL TAHTR OUT TPLENUM TSORB(AY) TWENT THEN OUT FBH PRES BED DP FBH PRES BED DP FBH NOX FBH SO2 AHTR AIR (M) FBC ARIVEL AB CM T LOWER BED DP FBC NAGA (M) FBC NAGA (M) FBC BED DP FBC NAGA (M) FBC BE DP FBC PLENUM DP FBC PRES FBC DPER	TE - 373 FY - 45 FY - 45 FY - 45 FY - 45 FY - 30 SY - 30 TE - 376 TE - 376 TE - 376 FT - 376 FT - 376 FT - 376 FT - 376 FT - 376 FT - 376 FY - 376 FY - 3008 FY - 3008 FY - 340 FY - 340 FY - 340 FY - 340 FT - 346 FT - 346 FT - 346	7.144 7.144 7.1756C 7.1756C 7.1756C 7.1756C 7.17577 7.17577 7.17577 7.17577 7.17577 7.17577 7.17577 7.175777 7.175777 7.175777 7.175777 7.1757777 7.1757777 7.1757777777777	6.03 272.6 3.00 19.02 784 784 1006 982 3.36 8.45 9.27 9.29 9.23 10.91 9.27 9.23 9.23 9.23 10.91 9.27 9.23 9.23 10.91 9.27 9.23 10.00	1075 8.32 278.4 3.00 19.60 19.60 19.60 19.60 3.62 3.62 3.62 13.30 9.67 3.41 0.00 9.67 1.007 9.000 196.5 1007 9.000 196.5 1007 1	527 200.0 3.000 19.80 19.80 19.80 19.80 19.80 9.40	1078 6.42 278.1 3.000 20.47 1430 818 1072 956 3356 1.14 13.64 1.34 9.71 0.68 0.90 76C08 76C08 76C08 188.5 900 1188.5 900 900 900 900 900 900 900 90
	TSORB(12) MATURAL GAS AHTR AIR GA FBH VEL FBH VEL FBH VEL TOTORIA TOTORIA TOTORIA TOTORIA TOTORIA AHTR AIR GAS TOTORIA TOTORIA <	TE - 373 FY - 45 FY - 45 FY - 45 FY - 45 FY - 45 FY - 30 SY - 30 TE - 370 TE - 370 TE - 376 TE - 376 TE - 376 FT - 376 FT - 376 FT - 376 FT - 376 FT - 377 FT - 377 FT - 377 FY - 30 FY - 30 FY - 300 FY - 340 FY	2744 2744 27436 274362 274362 27437 27477 27477 27477 27477 274777 274777 2747777 27477777777	6.03 272.6 3.00 18.02 1384 784 1099 882 3.36 6.45 10.91 8.27 9.28 10.91 0.91 0.91 0.91 0.91 0.91 0.91 0.92 18.02 1.94 0.91 0.92 0.91 0.91 0.91 0.92 0.91 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.91 0.92 0.94 0.95 0.9	0776 0776 0776 0776 0776 0776 0776 0776 0777 077 0777 0	6.27 200.0 3.000 1.384 804 946 946 946 946 946 946 946 946 946 94	1078 1078 142 278.1 3.000 20.47 1430 1072 336 1072 336 1.14 13.64 13.64 13.64 1.14 9.72 0.68 0.68 0.68 0.68 0.68 0.66 0.000 FBC029 1.8.00 18.000 18.000 18.000 18.000 18.000 19.0000 19.00000 19.0000 19.00000 19.0000 19.00000 19.00000 19.00000 19.00000 19.00000 19.00000 19.00000 19.00000 19.00000 19.00000 19.00000 19.00000 19.000000 19.000000 19.000000 19.0000000 19.0000000000 19.000000000000000000000000000000000000
FLUID BED COOLER FLE	TSORB(12) MATURAL GAS AHTR AIR GA FBH VEL FBH VEL FBH VEL TAHTR OUT T PLENUM TSORB(24) TSORB(24) TSORB(24) TRORB BED DR BED DP FBH NOX FBH NOX FBH NOX FBH NOX FBH NOX FBH SO2 AHTR AIR (M) FBC RAG (M) FBC DD FBC RAG (M) FBC DD FBC PARS (M) FBC DD FBC PARS (M) FBC PARS (M) FBC PARS (M)	$\begin{array}{c} TE = 373\\ FY = 45\\ FY = 730\\ SY = 30\\ TE = 376\\ TE = 376\\ TE = 377\\ TE = 377\\ TE = 376\\ TE = 376\\ TE = 376\\ TE = 376\\ TT = 376\\ PDT = 377\\ PT = 376\\ TE = 376\\ TT = 340\\ $	2 MA 2 MA	6.03 272.6 272.6 272.6 272.6 272.6 272.6 272.6 272.6 272.6 272.6 272.6 284.6 2.241 2.22 2.21 2.22	072 072 072 072 075 075 075 075 075 075 075 075	6.27 200.0 3.000 1.384 506 545 3.47 1.62 5.57 3.18 0.000 91.4 0.22 0.22 0.000 91.4 0.02 0.000 91.4 0.020 91.4 0.020 91.4 0.000 91.4 0.020 91.4 0.0000 91.4 0.00000 91.4 0.00000 91.4 0.00000 91.4 0.0000000000000000000000000000000000	1078 0.42 278.1 3.00 20.67 1430 1072 989 328 1.14 1.54 1.15 0.68 0.66 0.00 1.8.4 0.66 0.66 0.00 1.8.4 0.66 0.00 0.66 0.00 0.66 0.00 0.66 0.00 0.66 0.00 0.66 0.00 0.66 0.00 0.66 0.00 0.66 0.00 0.66 0.00 0.66 0.00 0.66 0.00 0.66 0.00 0.66 0.00 0.66 0.00 0.66 0.00 0.00 0.66 0.00 0.00 0.66 0.00
	TSORB(12) TSORB(12) MATURAL GAS AHTR AIR GA FBH VEL FBH VEL TAHTR OUT TPLENUM TSORB(24) TVENT THUM OUT FBH PRES BED DP PLENUM DP FBH NOX FBH SO2 AHTR AIR (M) REG MAS (M) REG MAS (M) REG R2 (M) PEC AIR VEL AR (M) FBU NOX	$\begin{array}{c} TE = 373\\ FY = 45\\ FY = 50\\ SY = 30\\ AT = 0273\\ TE = 376\\ PDT = 377\\ AT = 502\\ PDT = 377\\ AT = 502\\ FT = 376\\ PDT = 377\\ AT = 502\\ FT = 376\\ TE = 340\\ TE = 340$	7 Min 7 Min 7 Min 7 Min 7 Min 7 Min 7 Min 7 Min 8 C 1 Min 9 C 1 Min 1	6.03 272.6 3.22.0 13.00 18.02 1366 9.62 3.36 6.45 10.91 10.91 10.91 10.91 10.91 10.91 10.91 10.91 10.91 10.91 10.91 10.92 3.00 10.12 10.00	072 072 072 072 073 074 075 075 075 075 075 075 075 075	6 227 280.0 3.000 19.60 19.00 19	1078 1078 1430 20.87 1430 20.87 1430 20.87 1430 20.87 1430 20.87 1430 20.87 1430 20.87 1430 20.87 20.87 1430 20.87 20.97 20.87
	TBORB(12) MATURAL GAS AHTR AIR GAS AHTR AIR GAS FBH VEL FBH VEL FBH 02 TAHTR OUT TPUENUAL TBORB(A1) TWENT THUR OUT FBH PRES DED DP PLEMAA DP FBH NOX FBC DDP FBC DDP PLENUAD DP PLENUAD DP PLENUAD DP PLENUAD DP PLENUAD DP PLENUAT PRS ARI PRS ARI PRS ARI	$\begin{array}{c} TE = 373\\ FY = 45\\ FY = 45\\ FY = 730\\ SY = 30\\ TE = 370\\ TE = 370\\ TE = 376\\ TE = 376\\ TE = 376\\ PT = 378\\ PDT = 383\\ TE = 384\\ TE$	7 Min 7 Min 7 Min 7 Min 7 Min 7 Min 7 Min 7 Min 8 Com 9 Min 9	6.03 272.6 3.22.6 3.200 18.022 1386 784 1008 982 336 6.645 10.81 9.27 9.29 2.21 9.22 9.2.21 9.22 9.2.21 9.2.22 9.2.21 9.2.22 9.2	1075 8.32 278.4 3.00 19.60 19.60 19.60 19.67 3.38 9.87 3.38 9.87 3.38 9.87 3.38 9.87 3.38 9.87 9.87 9.67 9.00 10.0	6.27 280.0 3.000 19.60 19.60 19.60 19.60 19.60 19.60 19.67 3.16 9.67 9.11 6.22 0.000 6.7 0.000 FBC264.27 8.53 12.30 23.66 19.5 8.53 12.30 23.66 13.54 12.55 5.5	1078 1078 1078 1078 1078 1078 1078 1078 1072 1430 1077 1430 1077 1430 1077 1430 1077 1430 1077
	TSORB(12) MATURAL GAS ANTR AIR GAS ANTR AIR GAS FBH VEL FBH 02 TAHTR OUT TPLENUM TSORB(A1) TORB(A1) TORB(A1) TORB(A1) TORB(A1) TORB(A1) TORB(A1) TORB(A1) TORB(A1) THUM OUT FBH NOX FBH NOX FBH NOX FBH NOX FBH NOX FBH SO2 AHTR AIR (M) REG N2A(M) REG N2A(M) REG N2A(M) FBC DE PLENUM TLOWER PLENUM TLOWER BED DP PLENUM DP <t< td=""><td>TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 370 TE - 370 TE - 376 FY - 377 FY - 377 FY - 377 FY - 30 FY - 300 FY - 3100 FY - 340 FY - 340 FY - 340 FY - 340 FY - 340 FT - 340 F</td><td>7 MAR 7 MAR 7</td><td>6.03 272.6 272.6 272.6 272.6 272.6 272.6 272.6 272.6 272.6 201.6 20.</td><td>1070 8.32 278.4 3.86 19.60 19.60 19.60 19.60 19.60 19.60 10.00</td><td>502 502 502 502 502 502 502 502</td><td>1078 1078</td></t<>	TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 370 TE - 370 TE - 376 FY - 377 FY - 377 FY - 377 FY - 30 FY - 300 FY - 3100 FY - 340 FY - 340 FY - 340 FY - 340 FY - 340 FT - 340 F	7 MAR 7	6.03 272.6 272.6 272.6 272.6 272.6 272.6 272.6 272.6 272.6 201.6 20.	1070 8.32 278.4 3.86 19.60 19.60 19.60 19.60 19.60 19.60 10.00	502 502 502 502 502 502 502 502	1078 1078
	TSORB(12) TSORB(12) MATURAL GAS ANTR AIR 64 FBH 02 FBH 02 TAHTR OUT TPLENUM TSORB(47) TVENT THEN OUT FBH 602 TAHTR OUT TPLENUM TSORB(47) TRENT THEN OUT FBH PRES BED DP PLENUM OP FBH NOX FBH SO2 AHTR AIR (M) FEG NGAS (M) REG MAGA (M) FBC PRES BED DP FBC PRES PLENUM FBC PRES BED DP FBC PRES PLENUM DP FBC PRES AR M BED DPER T HEATER T HEATER T HEATER AR M AR M PRES 2020AD NAET NOX(ADA) OUTLET SO20ADA AR M <	TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 370 TE - 370 TE - 376 PT - 376 PT - 376 PT - 376 PT - 377 FY - 376 FY - 377 FY - 3008 FY - 3106 FY - 340 FY - 340 FY - 340 FY - 340 FT - 34	7 MAR 7	6.03 272.6 3.000 19.02 1.384 784 1.096 9.23 9.23 9.23 9.23 9.23 9.23 9.23 9.23	1075 8.32 278.4 3.00 19.60 19.60 19.60 19.60 3.62 3	5.2.2.2.2.2.2.2.2.2.2.2.2.2.2.2.2.2.2.2	1078 1078 1078 1078 1078 1072 1430 1072 1430 1072 1430 1072 1430 1072 1430 1072 1430 1072 1430 1072 1430 1072 1430 1072 1430 1072 1430 1072 1430 1072 1430 1072 1430 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 1440 1072 107 1072 1
		$\begin{array}{c} TE = 373\\ FY - 45\\ FY - 50\\ SY - 30\\ SY - 30\\ TE - 370\\ TE - 373\\ TE - 376\\ TE - 378\\ TE - 376\\ TT - 376\\ PD - 377\\ PD - 377\\ PT - 377\\ PT - 377\\ PT - 377\\ AT - 802 - 3\\ FY - 300\\ FY - 300\\$	7.148 7.148 7.148 7.148 7.138C PT/38C PT/38C PT/38C PT/38C PT/38C PERCENT DEG.F PPM PPM PPM PPM PPM PPM	6.03 272.6 3.00 19.02 1.384 784 1.984 9.27 9.29 9.29 9.21 10.91 9.27 9.29 9.21 10.91 9.27 9.29 9.21 9.27 9.29 9.21 9.27 9.29 9.21 9.27 9.29 9.21 9.27 9.29 9.21 9.27 9.29 9.29 9.21 9.27 9.29 9.29 9.29 9.21 9.27 9.29 9.29 9.21 9.27 9.29 9.21 9.27 9.29 9.21 9.27 9.29 9.21 9.27 9.29 9.21 9.27 9.29 9.21 9.27 9.29 9.21 9.27 9.29 9.21 9.27 9.29 9.21 9.27 9.29 9.21 9.21 9.27 9.29 9.21 9.27 9.29 9.21 9.27 9.29 9.21 9.21 9.21 9.21 9.27 9.29 9.21 9.21 9.21 9.21 9.21 9.21 9.21 9.21 9.21 9.21 9.21 9.22 9	075 075 075 075 075 075 075 075	6.27 200.0 3.000 1.946 3.000 1.946 3.47 3.47 3.19 3.47 3.19 0.000 10.0 946 0.022 0.000 10.0 95 2.000 10.0 95 2.000 10.0 95 2.000 10.0 95 2.000 10.0 95 2.000 10.0 95 2.000 10.0 95 2.000 10.0 95 2.000 10.0 95 2.000 10.0 95 2.000 10.0 95 2.000 10.0000 10.00000 10.00000 10.00000 10.00000 10.00000000	1078 1078 142 279.1 3.00 20.47 14.30 1072 348 1072 348 348 348 348 1.14 1.14 1.14 1.14 1.14 1.15 1.15 1.14 1.15 1.14 1.15 1.14 1.15 1.14 1.15 1.14 1.15 1.14 1.15 1.14 1.15 1.14 1.15 1.14 1.15 1.25 1.33 1.35 1.3
	TSORB(12) TSORB(12) MATURAL GAS AHTR AIR 60 FBH VEL FBH 02 TAHTR OUT T PLENUM TSORB(24) TOORGAN TWENT THUM OUT FBH PAS BED DP FBH NOX AR MA PLENUM FBC PRES FBC PRES FBC PRES TUPER T HEATER T AR	TE - 373 FY - 45 FY - 45 FY - 45 FY - 45 FY - 45 FY - 30 SY - 30 TE - 370 TE - 370 TE - 377 TE - 377 FT - 377 FT - 377 FT - 377 FT - 377 FT - 377 FY - 30 FY -	7 MHR 7 MHR 7 MHR 7 T/3EC 7 ECC MHR 7 T/3EC 7 ECC MHR 7 ECC MHR 7 MHR 8 GFM 8 GFM 8 GFM 8 GFM 8 GFM 8 GFM 8 GFM 9 FM 9 FM	€.03 272.8 3.20 17.8 18.02 1.366 4.4 1.059 1.059 1.059 2.21 3.36 4.4 6.4 5.27 3.00 1.8 1.2.21 3.00 1.8 1.2.21 3.00 1.8 1.2.21 3.00 1.8 1.2.21 3.00 1.8 1.2.21 3.00 5.00 1.8 1.2.21 3.00 5.00 5.00 5.00 5.00 5.00 5.00 5.00	075 075 075 075 075 075 075 075	6.27 200.0 3.000 1.8400 1.8400 1.8400 1.8400 1.8400 1.84000 1.8400000000000000	1078 1078 1430 20.67 1430 20.67 1430 1072 20.67 1430 1072 20.67 1430 1072 20.67 1430 1072 20.67 1072 20.67 1072 20.67 20.68 20.00 20.68 20.00 20.68 20.00 20.68 20.00 20.68 20.00 20.68 20.00 20.68 20.00 20.68 20.00 20.68 20.00 20.68 20.00 20.68 20.00 20.68 20.00 20.68 20.00 20
	ТВОРВ(12) MATURAL GAS ANTR AIR GM FBH VEL FBH VEL FBH 02 TAHTR OUT TPLENUM TSORB(24) TORGE THEN OUT THENAM BED DP FBH NOX FBH RO2 AHTR AIR (M FBC DP PLENAM DP FBC DP FBC AIR VEL AIR (M BED DP PLENAM DP FBC DP PLENAM DP THEATRAR AND THEATRAR AIR DP	TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 SY - 30 XT - 370 TE - 370 TE - 370 TE - 370 PD - 377 PD - 378 PD - 378 FY - 300 FY - 300 FY - 300 FY - 360 FY - 360 FY - 360 FY - 360 FY - 360 FT - 360	7 /HR 7 /HR 7 /HR 7 /HR 7 /HR 7 /HR 7 /HR 7 /HR 10 //HR 10 //HR 1	€.03 272.6 322.6 326.7 326.7 300 1002 306 400 306 400 400 400 400 400 400 400 4	075 8.32 278.4 3.00 19.40 19.40 19.40 19.40 19.40 1071 3.35 3.42 3.42 3.42 3.42 3.42 13.30 9.87 3.41 0.00 9.87 3.41 0.00 9.87 9.67 9.67 9.67 9.67 9.67 9.00 10.00 10.00 9.87 9.67 9.07	627 627 280.0 3.000 19.60 19.60 19.60 19.60 19.60 19.67 3.16 0.000 76.000 76.000 76.000 10.8 573 0.00 10.00 10.00 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.00000 10.0000 10.00000 10.00000 10.0000 10.00000 10.0000 10.	1078 1078 1430 20.67 1430 20.67 1430 20.67 1430 20.67 1430 20.67 1430 20.67 20.68 20.00 20.67 20.68 20.00 20.68 20.68 20.00 20.68 20.
	TSORB(12) TSORB(12) MATURAL GAS ANTR AIR 64 FBH 02 FBH 02 TAHTR OUT TPUENUM TSORB(24) TORB(24) TWENT THUB OUT FBH 02 TAHTR OUT TPUENUM TSORB(24) TPUENUM BED 07 FBH NOX TPUENUM TLOWER BED DP <t< td=""><td>TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 370 TE - 370 TE - 376 PT - 377 FY - 378 FY - 378 FY - 378 FY - 30 FY - 3</td><td>7 MAR 7 MAR 7 MAR 7 MAR 7 MAR 7 MAR 7 MAR 10 EG F 10 EG F</td><td>€.03 272.6 322.6 3.00 1.05 784 1.005 882 3.36 6.45 1.0.51 9.27 9.29 2.21 0.01 1.0.51 1.0.51 1.0.51 1.0.51 1.0.51 1.0.52</td><td>074 075 076 076 076 076 076 076 076 076</td><td>522 522 522 522 522 522 522 522</td><td>1078 10 1078 10</td></t<>	TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 370 TE - 370 TE - 376 PT - 377 FY - 378 FY - 378 FY - 378 FY - 30 FY - 3	7 MAR 7 MAR 7 MAR 7 MAR 7 MAR 7 MAR 7 MAR 10 EG F 10 EG F	€.03 272.6 322.6 3.00 1.05 784 1.005 882 3.36 6.45 1.0.51 9.27 9.29 2.21 0.01 1.0.51 1.0.51 1.0.51 1.0.51 1.0.51 1.0.52	074 075 076 076 076 076 076 076 076 076	522 522 522 522 522 522 522 522	1078 10 1078 10
FLUD BED COOLER FLE	TSORB(12) TSORB(12) MATURAL GAS ANTR AIR 64 FBH 02 FBH 02 TAHTR OUT TPLENUM TSORB(24) TORNT TPLENUM TSORB(24) TORNT TPLENUM FBH PAES BED 0P FBH NOX FBH SO2 ANTR AIR (M) PLENUM FBC NEG NEG (M) PEG NEG NEG (M) OUTLET SOZADA)	TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 376 TE - 376 FY - 377 FE - 376 FY - 377 FY - 377 FY - 377 FY - 30 FY - 377 FY - 30 FY -	Fride Finite Finite Finite Finite DEGF DEGF DEGF DEGF Hao Hao Hao Hao Hao Hao Hao Hao	€.03 272.6 272.6 272.6 272.6 272.6 272.6 272.6 272.6 272.6 201.6 20	1075 8.32 278.4 278.4 278.4 18.60 19.60 19.60 19.60 10.11 9.60 10.30 9.67 3.41 0.00 9.67 10.00 10	6.27 200.0 3.000 19.	1078 1078 1078 1078 1078 1072 1430 1072 1430 1072 1430 1072 1430 1072 1430 1072 1440 1440
	TSORB(12) TSORB(12) MATURAL GAS ANTR AIR 64 FBH 02 TAHTR OUT TPLENUM TSORB(24) TORNU TORNU TORNU PHENUM TORNU PUENUM TORNU FBH PAES BED DP FBH NOX FBH NET NOXADA NUET NOXADA AIR (M) <t< td=""><td>TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 376 TE - 376 TE - 376 FT - 376 PD - 377 PD - 377 PD - 377 PD - 377 FY - 300 FY - 300 F</td><td>7 MAR 7 MAR 7</td><td>6.03 272.6 3.000 18.02 1.384 784 1.096 862 3.366 8.45 9.27 9.29 2.21 9.29 2.21 0.11 0.00 18.1.2 10.52 10.52 10.52 10.55 1.0.5</td><td>1075 8.32 278.4 3.00 19.60 19.60 19.60 19.60 19.60 19.60 10.71 3.06 3.062 3.062 3.062 3.062 13.30 9.87 3.41 0.00 0.01 10.00 10.</td><td>6.27 200.0 3.000 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 1.42 0.000 190.9 190.</td><td>1078 1078 1078 1078 1078 1072 1007 1007 1007 1072 1075</td></t<>	TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 376 TE - 376 TE - 376 FT - 376 PD - 377 PD - 377 PD - 377 PD - 377 FY - 300 FY - 300 F	7 MAR 7	6.03 272.6 3.000 18.02 1.384 784 1.096 862 3.366 8.45 9.27 9.29 2.21 9.29 2.21 0.11 0.00 18.1.2 10.52 10.52 10.52 10.55 1.0.5	1075 8.32 278.4 3.00 19.60 19.60 19.60 19.60 19.60 19.60 10.71 3.06 3.062 3.062 3.062 3.062 13.30 9.87 3.41 0.00 0.01 10.00 10.	6.27 200.0 3.000 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 19.80 1.42 0.000 190.9 190.	1078 1078 1078 1078 1078 1072 1007 1007 1007 1072 1075
FLUID BED COOLER FLE	TSORB(12) MATURAL GAS AHTR AIR 60 FBH VEL FBH VEL FBH 02 TAHTR OUT T PLENUM TSOR6(24) TVENUM TREG PRES BED DP FBH NOX FBH NAND FBC PRES TLOWER BED DP <t< td=""><td>TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 370 TE - 376 TE - 376 TE - 376 FT - 377 PDT - 377 PT - 377 PT - 377 FT - 377 FT - 377 FT - 377 FY - 30 FY - 30 F</td><td>Prive C Prive C Pri</td><td>€.03 272.8 27</td><td>075 076 077 078 078 078 078 078 078 078</td><td>521 522 5200.0 5300 19.80</td><td>1078 1078 142 279.1 20.67 1430 20.67 1430 20.67 1430 20.67 1430 20.67 20.68 20.69 20.</td></t<>	TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 370 TE - 376 TE - 376 TE - 376 FT - 377 PDT - 377 PT - 377 PT - 377 FT - 377 FT - 377 FT - 377 FY - 30 FY - 30 F	Prive C Prive C Pri	€.03 272.8 27	075 076 077 078 078 078 078 078 078 078	521 522 5200.0 5300 19.80	1078 1078 142 279.1 20.67 1430 20.67 1430 20.67 1430 20.67 1430 20.67 20.68 20.69 20.
	TBORB(12) TBORB(12) MATURAL GAS ANTR AIR GA FBH VEL FBH 02 TAHTR OUT TPUENUAL TORREAT TORREAT THUR OUT FBH 02 TAHTR OUT TPUENUAL TBORB(24) THUR OUT FBH PRES DED DP PLEMAN DP FBH NOX FBC NEAG (M) REG NGA (M) FBC DDP PLENUAD (M) FBC DDP PLENUAD (M) FBC DDP PLENUAD (M) FBC DDP PLENUAD (M) FBC DP PLENUAD (M) FBC DDP PLENUAD (M) PLENUAT (M) <t< td=""><td>$\begin{array}{c} TE = 373\\ FY = 46\\ FY = 30\\ SY = 30\\ TE = 376\\ TE = 374\\ TE = 376\\ PDT = 378\\ PT = 368\\ TE = 384\\ TE =$</td><td>7 AHR 7 AHR 7 AHR 7 T/3EC 7 HOR 7 T/3EC 10 EG F DEG F DEG F DEG F DEG F 1300 1400 1</td><td>€.03 272.8 322.8 322.8 326 326 326 300 1002 326 445 300 522 326 445 300 522 326 3.00 000 000 000 000 10.11 0.01 10.9</td><td>075 8,32 278.4 3,00 19.40 19.40 19.40 19.40 19.40 19.41 3,35 3,35 9,87 9,97 9,000 10,000 11,70 9,07 1,08 4,10 9,07 1,170</td><td>6.27 280.0 3.000 19.60 19.60 19.60 19.60 19.60 19.60 19.60 19.60 0.22 9.67 0.00 0.00 0.00 19.67 0.00 0.02 0.00 19.67 0.00 0.00 0.00 19.67 0.00 0.00 0.00 19.67 0.00 0.00 0.00 19.67 0.00 0.00 0.00 19.67 0.00 0.00 0.00 19.67 0.00 0.00 19.60 0.00 0.00 19.67 0.00 0.00 19.67 1.62 0.00 19.67 1.62 0.00 19.67 1.62 0.00 19.67 1.62 0.00 19.67 1.62 0.00 19.00 19.3 0.00 19.00 19.3 0.00 19.00 10.00 19.</td><td>1078 1078 1430 20.67 1430 20.67 1430 1072 20.67 1430 20.67 1430 20.67 1430 20.67 20.68 20.00 20.0</td></t<>	$\begin{array}{c} TE = 373\\ FY = 46\\ FY = 30\\ SY = 30\\ TE = 376\\ TE = 374\\ TE = 376\\ PDT = 378\\ PT = 368\\ TE = 384\\ TE = $	7 AHR 7 AHR 7 AHR 7 T/3EC 7 HOR 7 T/3EC 10 EG F DEG F DEG F DEG F DEG F 1300 1400 1	€.03 272.8 322.8 322.8 326 326 326 300 1002 326 445 300 522 326 445 300 522 326 3.00 000 000 000 000 10.11 0.01 10.9	075 8,32 278.4 3,00 19.40 19.40 19.40 19.40 19.40 19.41 3,35 3,35 9,87 9,97 9,000 10,000 11,70 9,07 1,08 4,10 9,07 1,170	6.27 280.0 3.000 19.60 19.60 19.60 19.60 19.60 19.60 19.60 19.60 0.22 9.67 0.00 0.00 0.00 19.67 0.00 0.02 0.00 19.67 0.00 0.00 0.00 19.67 0.00 0.00 0.00 19.67 0.00 0.00 0.00 19.67 0.00 0.00 0.00 19.67 0.00 0.00 0.00 19.67 0.00 0.00 19.60 0.00 0.00 19.67 0.00 0.00 19.67 1.62 0.00 19.67 1.62 0.00 19.67 1.62 0.00 19.67 1.62 0.00 19.67 1.62 0.00 19.00 19.3 0.00 19.00 19.3 0.00 19.00 10.00 19.	1078 1078 1430 20.67 1430 20.67 1430 1072 20.67 1430 20.67 1430 20.67 1430 20.67 20.68 20.00 20.0
	TBORB(12) MATURAL GAS ANTR AIR GA ANTR AIR GAS FBH 02 FBH 02 TAHTR OUT T PLENUM TBORB(A1) TBORB(A1) TBORB(A1) TBORB(A1) TBORB(A1) TBURNA TBORB(A1) TBURNA TBORB(A1) TBURNA BED 0P FBH NOX FBH SO2 AHTR AIR (M) REG NGAS (M) PLENUM T PLENUM T LOWER BED DP PLENUM T PLENUM T LOWER BED DP PLENUM T LOWER T LOWER T AIR AIR OPE OUTLET NOX(ADD) NUELET NOX(ADD) NUELT NOX(ADD) OUTLET N	TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 370 TE - 370 TE - 370 TE - 376 PD - 377 FY - 377 FY - 377 FY - 30 FY - 3	Fride Finite Fride Fride DEG F DEG F DEG F DEG F DEG F DEG F Hao Hao Hao Hao Hao Hao Hao Hao Hao Hao	€.03 272.6 3.000 1.022 1.0365 784 1.006 9822 3.366 6.456 0.011 9.27 9.29 2.21 9.29 2.21 9.456 0.011 9.27 9.29 2.21 9.20 10.011 9.27 9.29 9.22 9.221 9	072 072 072 072 072 072 074 075 0 0 0 0 0 0 0 0 0 0 0 0 0	5 2 2 2 8 0 0 1 9 2 7 2 8 0 0 1 9 2 9 2 8 0 0 1 9 2 9 2 9 2 9 2 9 2 9 2 9 2 9 2 9 2 9	1078 1078 1078 1078 1078 1079 1630 1078 1630 1078 1630 1078 1630 1078 1630 1078 1630 1078 1630 10788 10788 10788 10788 10788 10788 10788 10788 10788 107
FLUID BED COOLER FLE		TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 376 TE - 376 FY - 30 FT - 376 FY - 377 FT - 377 FY - 377 FY - 30 FY - 377 FY - 30 FY - 3	Fride Fina Fride Fride DEG F DEG F DEG F DEG F DEG F Hao Hao Hao Hao Hao Hao Hao Hao Hao Hao	€.03 272.6 3.000 1.025 784 1.005 882 3.366 8.456 8.456 9.271 9.29 2.211 9.29 2.211 9.29 2.211 0.000 10.111 0.000 10.52 9.29 2.211 0.000 10.55 10	075 075 075 075 075 075 075 075	6.27 200.0 3.000 19.00 19.00 19.00 19.00 19.00 19.00 19.00 19.00 19.00 19.00 19.00 19.00 19.00 10.0000 10.000 10.000 10.000 10.00000 10.00000 10.00000 10.00000 10.00000 10.0000000 10.0000000000	1078 1078 1078 1078 1078 1079 10700 10700
	TSORB(12) MATURAL GAS ANTR AIR 640 FBH VEL FBH 02 TAHTR OUT TPLENUM TSORB(24) TORIGAN TORIGAN TRATE OUT TPLENUM TSORB(24) TORIGAN TRENT TPLENUM TORIGAN FBH PAES BED DP FBH NOX FBH NOX FBH NOX FBH SO2 AHTR AIR (M) FBC NEAS (M) SCOMB ART (M) COMB ART (M) </td <td>TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 370 TE - 370 TE - 376 TE - 376 FT - 376 PDT - 377 PDT - 377 PDT - 377 PDT - 377 PDT - 377 FY - 300 FY - 300 FT - 340 SO 20 FT - 340 FT - 340 FT</td> <td>7.148 7.148 7.148 7.178C 7.178C DEG F DEG F DEG F DEG F DEG F DEG F H30 H30 H30 H30 H30 H30 H30 H30 H30 H30</td> <td>6.03 272.8 272.8 272.8 272.8 272.8 272.8 272.8 272.8 272.8 272.8 272.8 284.8 294.8 294.8 294.8 294.8 294.8 294.8 294.8 205.8 20.</td> <td>1075 0.2278.4 3.00 19.60</td> <td>5.25</td> <td>1078 1078 1078 1078 1078 1078 1078 1078 1072 1088 1072 1098 1072 1098 1072 1098 1072 1098 1072 1098 1072 1098 1072 1098 1097 1098 10 10 10 10 10 10 10 10 10 10</td>	TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 SY - 30 TE - 370 TE - 370 TE - 376 TE - 376 FT - 376 PDT - 377 PDT - 377 PDT - 377 PDT - 377 PDT - 377 FY - 300 FY - 300 FT - 340 SO 20 FT - 340 FT	7.148 7.148 7.148 7.178C 7.178C DEG F DEG F DEG F DEG F DEG F DEG F H30 H30 H30 H30 H30 H30 H30 H30 H30 H30	6.03 272.8 272.8 272.8 272.8 272.8 272.8 272.8 272.8 272.8 272.8 272.8 284.8 294.8 294.8 294.8 294.8 294.8 294.8 294.8 205.8 20.	1075 0.2278.4 3.00 19.60	5.25	1078 1078 1078 1078 1078 1078 1078 1078 1072 1088 1072 1098 1072 1098 1072 1098 1072 1098 1072 1098 1072 1098 1072 1098 1097 1098 10 10 10 10 10 10 10 10 10 10
		TE - 373 FY - 46 FY - 46 FY - 46 FY - 46 FY - 30 AT - 02 - 3 TE - 370 TE - 370 TE - 376 TE - 376 FT - 376 PD - 377 PD - 377 PD - 377 PD - 377 PD - 377 FY - 300 FY -	7 Min 7	6.03 272.8 272	1075 0.075 0	6 227 280.0 3.000 19.60 19.60 19.60 19.60 19.60 19.60 19.60 19.60 0.000 0.000 0.000 0.000 0.000 19.62 11.52 9.67 3.00 10.65 9.67 3.000 10.65 10.55 9.67 3.000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000 10.0000	1078 1078 1078 1078 1078 1078 1078 1078 1072 1087 1072 1075

Table 6. Detailed Information for Test MBCUO-2

MBCUO-04	PARAMETER	TAG	E/U	1	2	3	•			7		•	10	11	12	13	14
					0.0140.000	0.0448.000	00148400	00148004	COMPOS	COMBOOK	00448004	C0448007	COMPANY	COMPANY	0.0148000	COM 8000	COMPOSE
COMBUSTONFILE	COMB AR	FY-1	#/HR	438.5	438.6	438.8	438.8	438.3	438.6	438.6	438.5	438.6	438.4	438.4	439.3	438.3	408.2
	MOTINE AIR	FY-3	J/HR	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
	COAL	WKT-26	#/HR	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
	FEEDERWT	WT-26	LBS	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
	HEATINPUT	BTU	BTUMR	613884	617031	617160	616585	616986	617081	617065	617008	\$17007	617032	617012	618202	618184	561851
· · · · · · · · · · · · · · · · · · ·	FLUE GAS (M)	AT-02-0	S/HR S	536.4	535.8 4,43	4.36	634.6	4.78	6.27	4.38	4.38	<u>531.9</u> 4.32	538.8	533.4 4.22	4.12	4.26	499.8
	FURNACE P	PT-6	H20	-1.00	-1.06	-0.90	-1.01	-0.98	-1.04	-1.01	-1.00	-1.04	-1.00	-1.00	-0.99	-1.01	-1.05
	MOTIVE AR P	PT-3	PSIG	107.65	4.62	108.18	107.28	107.87	107.72	106.52	96.22	4.31	4.87	94.42	4.26	\$4.90	96.29
	NATURAL GAS P	PT-20	PSiQ	4.17	4.19	4.13	4.17	4.16	4.13	4.22	4.22	4.12	4.22	4.22	4.16	4.20	4.23
	COOL H20 P	PT-26	PSIQ	116.72	118.66	110.60	117.13	116.88	117.16	116.43	116.33	117,43	116.61	116.78	117.29	118.64	116.66
	THEORAIR	BY-X	FILEOAR	343.66	363.75	383.81	343.41	363.70	383.74	383.74	363.71	343.72	383.74	383.72	384.46	384.45	358.45
	FURNACE CO	AT-00-0	PPM	10.30	7.61	11.71	10.96	11.62	9.97	11.88	9.93	9.94	10.17	9.86	10.38	9.92	9.85
	MOTIVE AIR V	3Y-3 FY-16	FT/SEC SCFM	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	107.2
				7													
ABSORBER FILE	WLET 802	AT-802-1	PPM	2237	A55031 2277	A86032 2266	A65032 2242	A55033 2223	2218	1500	3244	A55037 2252	A85037 2261	A53037 2261	2276	2277	2249
	MLET NOX	AT-NOX-1	PPM	\$19	474	101	\$23	494	100	622	613	104	493	401	78	74	87
	OUTLET SO2	AT-802-2	PPM	208	242	171	143	164	123	54	606	206	303	390	63.8	128	521
	OUTLET NOX	AT-NOX-2	PPM	19	23	M	31	31	103	42	31	96	39	32	81		62
	NO SPIKE	PT-101	#/HR	0.12	0.12	0.00	0.12	0.11	0.00	0.11	0.11	0.00	0.11	0.11	0.00	0.00	0.00
	SO2 SPIKE	FT-108	#/HR #/HR	0,114	0.107	1.46	0,133	1.46	0.000	0.87	0.121	0.000	0.117	0.123	0.000	0.000	0.000
	SED DP	POT-18	HEO	2.26	2.55	2.90	3.30	4.48	3,15	4.20	4.95	6.22	6.72	6.16	6.17	2.48	3.48
	INLET P	PT-17	-1120	6.79	499.8	6.00	6.74	6.91	6.84	4.76	6.81	497,3 6.61	490.8	6.94	6.73	6.76	6.64
	GAA MET	PDT-21	H2O	0.86	0.97	0.96	1,10	1.82	1.30	1.88	1.28	1.19	1.27	1.66	0.66	1.10	0.88
	GAS OUTLET	12-21	DEGF	678	6.37	633	676	719	673	870	645	\$75	871	676	667	672	562
	SORE IN SORE OUT	TE-380 TE-381	DEGF	761	701	712	761	801 784	766	784	762	784	727	761	735	768	584
	SO2 REMOVAL	SOZREF	PERCENT	90.6	\$9.2	92.4	93.2	92.6		96.3	01.2	\$0.9	86.8	91.1	71.7	94.3	78.6
	FLUE GAS (V)	FY-17	SOFM	96.3	107.0	107.0	107.1	93.6	3.6	107.0	93.9 107.4	5.5 106.4	92.0	93.3	106.9	0.0	5.2 106.7
REGENERATOR FLF				REGONO	REGONI	REGODO	REGONO	REGONA	REGONE	REGONE	REGORE	RE 0017	RE GOAT	RE GOAT	REGOSA	REGONA	REGONA
	QUICK REP 02	AT-02-44	PERCENT	0.00	0.00	0.01	0.02	0.00	0.00	0.02	0.00	0.00	0.00	0.00	0.00	0.41	0.19
	REGEN CH4	AT-602-4	PERCENT	8.71	13.73	30.78	4.49	31.66	23.25	24.07	11.96	33,01	14.35	29.06	13.17	5.30	31.44
	REGEN CO2	AT-C02-4	PERCENT	37.72	40.00	40.00	39.46	37.73	40.00	38,94	37.24	39.83	36.77	39.02	35.92	40.00	39.99
	REGEN 02	AT-02-48	PERCENT	0.06	0.00	0.17	1.10	0.34	0.00	0.16	0.19	0.01	0.01	0.13	1.46	0.01	0.18
	NATOHAL GAS	FY-300	#/HR #/HR	0.60	0.00	0.60	0.00	0.00	0.00	0.60	0.82	0.60	0.00	0.60	0.00	0.00	0.00
	REGEN P SORBLEVEL	PT-360	H20	3.84	4,12	3.38	3.80	6.34	3.48	2.91	\$.70 45.64	4.28	4.26	3.47	2.51	9.16	2.81
	130R8 (2)	TE-381	DEGF	561	354	872	344	566	930	\$77	844	839	919	881	844	838	841
	130R8 (32)	TE-343	DEGF	622	640	843	854	864	\$37	544	834	442	876	877	544	841	862
	TSORE (47)	TE-384 TE-386	DEGF	872	883 763	883 767	887	584	872	389	876	882	847	846 750	580	884	812
	T OFFGAS	TE-306	DEGF	184	167	160	162	163	167	162	173	160	160	161	169	164	165
	TINC EX	TE-200	DEGF	401	392	411	443	460	485	427	420	479	426	421	434	424	443
	INCIN 02	AT-02-5 AT-802-6	PERCENT	19.84	19,78	20.52	20.41	21.62	21.32	21.83	19.76	19.64	20.82	20.29	20.11	19.77	19.60
				FRHOM	Fallons	5844444	EBHOTO	6.8.4044	FEMORE	Salions	SEHAM	SELLANT.	FRHMAT	EBMAAT	584038	ERMOTE	ERMON
FLORD BED HEATERFEE	TSORB(12)	TE-373	DEGF	1024	1023	1026	1026	1026	1026	1026	1026	1026	1026	1024	1026	1026	1026
	AHTRAIL GAS	FY-86 FY-30	#/HR #/HR	8.78	6.83 287.7	5.93 289.8	5.89	8.76 291.7	8.02 290.0	<u>5.84</u> 291.7	5.96 290.8	288.3	6.82 289.1	5.87 206.6	207.4	5.80	5.88
	FBH VEL	SY-30	FT/SEC	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00
	TANTR OUT	TE-370	DEGF	1296	1 301	1013	1316	1287	1336	1293	1311	1296	1293	1314	1290	1302	1313
	TSORB(24)	TE-372	DEGF	1020	1020	1021	1020	1021	1021	1021	1021	1020	1021	1020	1021	1022	1020
	TVENT THUM OUT	TE-376	DEGF	914	906	906	901	902	914	901 500	910 500	900	926	904	903	903	398 500
	FBH PRES	PT-376	H20	4.92	8.01	4.86	4.80	4.73	4.81	4.84	4.02	4.68	2.60	3.11	1.76	1.80	2.02
	PLENUM OP	PDT-370 PDT-377	H20	10,11	9.30	9.62	9.60	9.14	9.67	6.80 9.61	\$.72	9.43	16.06	9.53	9.34	9.64	9.54
	FBH NOX	AT-NOX-3	PPM	0.96	3.02	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
	AHTR AIR (V)	FY-30	SCFM	62.9	63.1	63.5	63.4	63.9	63.6	63.9	63.7	63.2	63.4	62.8	63.0	63.2	63.1
	REG N2 (V)	FY-3108	SCFM	0.22	0.22	0.22	0.22	0.22	0.22	0.16	0.30	0.22	0.22	0.22	0.22	0.22	0.22
FLUID BED COOLER FLE				FBC0ag	FBC031	FBC082	FBC032	FBC033	FBCOSE	FBC016	FBCode	FBC017	F8C037	FBC037	FBCOSE	FBC019	FBC039
	FBC AN VEL	3Y-300	FT/SEC	3.01	3.00	3.00	3.00	3.01	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00	3.00
	TPLENUM	TE-342	DEGF	945	797	856	961	1089	961	961	942	934	987	914	960	948	642
	TLOWER BED DP	TE-343 PDT-346	DEGF H2O	931	826 11.02	11.87	911 13.06	990	930	920	928	921	926	897	919	922	700
	PLENUM OP	PDT-347	H2O	6.89	5.96	8.96	7.02	6.94	6.94	6.90	6.84	6.35	6.90	6.83	6.62	6.66	6.80
	TUPPER	TE-364	DEGF	933	827	641	912	991	931	921	929	923	927	699	920	923	792
	T HEATER	TE-361 TE-360	DEGF	506 82	426	436	520	662	576 113	510 91	496	497	538	486	508	502	340
	AIR PRES	PT-360	PSIG	2.77	2.76	2.77	2.62	2.66	2.64	2.80	2.80	2.60	2.74	2.66	2.68	2.66	2.62
	INLET SO2(ADJ)	SO2REF	PPM	2426	2462	2439	2439	2409	2404	1626	3497	2418	2430	2421	2423	2441	2429
	INLET NOX(ADJ	NOXREF	PPM PPM	231	266	109	166	181	135	61 5 66	658	220	329	218	687	136	547
	AIR M	NOXREF	PPM SCFM	22	26	102	34	34	113	45	34	108	42	35	67	93	69
	COMB AIR T	TE-1	DEGF	93	92	1EN023	116	1211	119	92	1E.M#*026 90	118	97	1CMP/027 98	117	105	110
	CO AIR HTR T MOT AIR T	TE-3	DEGF	640	676 54	678	675	676 78	678 82	675	676	678	675	678	678	678 72	460
	FUR REFR T	TE-4	DEGF	1767	1637	1624	1620	1626	1626	1621	1624	1634	1622	1826	1608	1606	1596
	TOT FGAS T	TE-16	DEGF	839	780	779	830	904	830	841	841	837	841	840	630	840	663
	ABS FGAS T HUM EXIT T	TE-18 TE-27	DEGF	750	700	700	744	802	746	750	750	750	750	750	750	750	\$00 179
	BGHS TOP T	TE-20	DEGI	364	364	384	364	346	367	355	354	356	356	386	357	366	347
	A85 21 T	TIC-86	DEGF	367	701	356	368 748	358	358 753	356 780	356	369	750	358	750	358 750	595
	A88 22 T A88 23 T	TIC-88 TIC-91	DEGF	780	704	701	738	\$02	753	750	750	780	750	761	750	750	500
	A88 24 T	THC-94	DEGF	750	700	700	760	500	780	780	750	750	750	750	750	750	500
	CW SUP T	TE-42	DEGP	96	100		107	109	107	101	106	112	104	106	115	108	103
	CW FUR EXT	TE-43	DEGF	.129	132	133	142	143	143	135	138	147	138	139	150	140	136
· · · · · · · · · · · · · · · · · · ·	NAT CAR T	TE - MO	DECE	70	47	71							701				

Table 7. Detailed Information for Test MBCUO-3

MBCUO-04	PARAMETER	TAG	E/U	1	2	3	4	5		7			10
COMBUSTOR FLE		+	+	COMBOSO	COMBON	COMBON	2 COMBON	COMBOS	A COMISES	COMBONT	COMPANY	COMPANY	
	COMEAR	FY-1	#/HR	422.0	421.1	422.	0 422.	0 421.	\$ 430.4	430.4	430.4	430.3	430.4
	NATURAL GAS	FY-20	#/HR	21.84	21.0	21.8	0 0.0	0 0.0	0 0.00	0.00	0.00	0.00	0.00
······································	COAL	WKT-26	S/HR	0.00	0.00	0.0	0.0	0 0.0	0.00	0.00	0.00	0.00	0.00
	EXCESS AR	BY-X	%XSA	0.00	0.00	0.0	0 0.0	0.0	0 0.00	0.00	0.00	0.00	0.00
	HEATINPUT	BTU	BTUMR	672617	672661	67245	4 67262	6 87255	8 683473	583366	683394	583406	583616
	FURNACE OF	AT-02-0	×////	4.24	617.4	4.4	2 515.	4 514.	3 <u>624.</u>	524.2	524.1	523.9	823.0
	FURNACEP	PT-8	H20	-0.96	-0.94	-0.9	-1.0	1 -1.0	0 -1.04	-0.90	-0.97	-0.80	-0.97
	MOTIVE AR P	PT-3	PBIG	96,40	9.85	87.4	8 4.4 8 90.5	4.3 1 96.7	8 4.40	97.14	4,31	4.38	4.48
	NATURAL GAS P	PT-20	PSKG	4.17	4.21	4.2	1 4.1	4.1	6.17	4.17	4.10	4.16	4.18
	COOL HEOP	PT-26	PBIG	116.22	113.83	113.0	6 114.8	7 114.0	0 5.10 6 114.00	113.02	5.10	5.12	8.00
	THEORAIR FURNACE COS	SY-X	PERCENT	348.20	348.33	348.2	9 344.3	344.3	2 376.34	376.27	376.29	376.29	378.46
	FURMACE CO	AT-CO-0	PPM	11.06	13.60	13.6	4 11.7	11.0	7 11.44	12.07	9.40	9.43	12.07
	FLUE GAS M	SY-3 FY-18	FT/SEC	0.00	0.00	0.0	0.0	0.0	0 0.00	0.00	0.00	0.00	0.00
							110.		112.0	112.0	112.4	112.4	112.2
ABSORDER FLE	INLET SOR	AT-802-1	PPM	A88042	A85043	A88044	A88048	A88046	A55047	A88048	A88049	A88060	A88061
	INLET NOX	AT-NOX-1	PPM	504	494	49	7	7	7 494	501	491	473	2220
	OUTLET 802	AT-02-1	PERCENT	4.91	5.01	5.00	0 4.84 5 34	4.8	4.76	4.80	4.81	4.81	4.60
	OUTLET NOX	AT-NOX-2	PPM	17	26	21	5 7	2 74	4 18	25	27	11	74
	NO SPICE	FT-101	#/HR	0,11	8.27	6.64	5 <u>5.5</u>	8.2	6.18	6.06	4.90	6.56	8.66
	802 SPICE	FT-102	\$/HR	1.46	1.47	1.44	1.44	1.4	1,46	1.46	1.44	1.46	1.46
	BED OP	PDT-19	H2O	0.087	0.006	0.004	0.000	0.000	0.005	0.000	0.083	0.084	0.000
}	FLUE GAS 64	FY-17	#/HR	490.5	\$00.1	\$00.7	498.0	487.4	607.2	\$07.8	\$08.7	807.0	507.8
	SCREEN DP	PDT-21	H2O	1.70	1.63	1.44	1.64	0.44	6.63	0.65	0.66	6.62	6.60
	GAS MLET	TE-18 TE-91	DEGF	747	747	747	747	. 747	747	747	747	747	746
	SOREIN	TE-390	DEGF	746	767	744	744	784	784	752	766	643 748	768
	SORE OUT	1E-301 S02REF	PERCENT	712	707	706	70	711	707	700	704	700	699
	NOX REMOVAL	NOXNEP	PERCENT	94.8	34.6	\$4.7	1.3	1.0	14.2	16.4	83.6 94.4	97.4	51.8 2.1
	FLUE GAS (V)	PV-17	SCFM	107.1	107.3	107.4	106.9	106.7	108.8	108.9	108.7	108.7	108.9
REGENERATOR FLE		AT-00-11		RE GO42	REG043	RE GO44	REGOLIS	REGONS	RE 0047	RE GO48	RE GO49	REGOSO	REGOSI
	REGEN SO2	AT-802-4	PERCENT	39.75	0.00	0.11	0.02	0.07	25.87	0.00	0.00	0.01	0.00
	REGEN CH4	AT-CH4-4	PERCENT	18.01	6.36	0.71	28.64	31.60	31.27	32.80	34.22	42.00	0.02
	REGEN H26	AT-H28-4	PERCENT	0.00	0.00	0.00	0.00	37.69	0.00	37.78	34.08	23.96	0.00
······	NATURAL GAS	AT-02-48	PERCENT	0.13	0.01	0.30	0.14	0.16	0.09	0.24	0.26	0.18	0.45
	NITROGEN	FY-310	F/HR	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.60	0.88
	SORB LEVEL	PT-380 LT-380	H2O INCHES	6.39	3.96	7.07	-0.91	-0.30	-1,31	-1.84	-1.79	-1.73	-0.60
	TSORE (27)	TE-301	DEGF	846	861	839	459	20.49	23.23	902	843	792	796
	TSORE (32')	TE-302 TE-303	DEGF	816	\$27	830	836	911	915	945	883	636	780
	TSORE (47)	TE-384	DEGF	829	836	\$1.0	\$20	184	445	647	824	776	735
	TOFFGAS	TE-346	DEGF	166	159	786	148	1200	136	814	778	738	270
	T CONDEX TINC FX	TE-367	DEGF	78	63	72	76	76		84		62	80
	INCIN 02	AT-02-8	PERCENT	18.86	18.26	19.83	19.06	18.12	19.32	19.40	19.66	19.70	19.74
	INCIN 302	AT-502-6	PPM	347	379	144	241	226	271	306	434	413	430
FLUID BED HEATER FLE	78088445		-	FBH042	FBH043	F 5H044	FBH046	FBH046	FBH047	FBH048	FBH049	FBHOSO	F8H061
	NATURAL GAS	FY-44	PEG F	1026 I	1025	1024	1090	1169	1193	1110	1078	1000	673
		FY-30	F/HR	206.1	288.0	288.8	274.6	264.3	268.7	271.3	276.9	293.0	380.6
	FBH 02	AT-02-3	PERCENT	21.03	21.02	21.02	20.96	20.93	3.00	3.00	3.00	15.10	3.00
	TAHTR OUT	TE-370	DEGF	1303	1307	1284	1386	1665	1570	1418	1 360	1244	726
	TSOR8(24)	TE-374	DEGF	1020	1020	1020	1006	1186	1166	1106	1073	70 8	525
	THUM OUT	TE-376	DEGF	500	912	904	563	1034	1048	977	968	889	623
	FBH PRES	PT-376	H20	\$.26	5.79	2.92	1.78	1.27	5.23	6.73	8.39	6.00	8.41
	PLENUM OP	PDT-377	H20	9.62	9.60	0.50	11.90	11.68	8.24	9.14	8.37	8.99	9.81
	FBH NOX	AT-NOX-3	PPM	0.00	0.00	0.00	0.00	0.00	27.60	6.45	20.79	16.04	8.76
	AHTR AIR (M	FY-30	SCFM	62.72	63.13	63.31	50.19	54.17	56.04	59.46	60.69	64.22	83.42
	REG NGAS (V)	FY-3008	SCFM SCFM	0.22	0.16	0.11	0.22	0.22	0.22	0.22	0.22	0.22	0.32
				PROVIDE			5.00			0.00	0.00	0.30	0.00
CONTRACT OVOLEN FLE	FBC AIR VEL	SY-340	FT/SEC	3.00	3.00	3.00	FBC045 3.00	FBC046 3.00	FBC047 3.00	3.90	5BC049	FBC060 F	1.00
	T PLENUM	FY-360 TE-362	DEGF	183.9	186.3	188.6	184.3	183.4	183.9	186.8	186.4	184.6	183.6
	TLOWER	TE-363	DEGF	919	909	696	922	924	919	996	976	906	976
	PLENUM OP	PDT-345 PDT-367	H20 H20	12.07	12.47	10.41	11.10	10.35	9.90	12.24	10.48	9.96	10.07
	FBCPRES	PT-366	H20	1.64	1.79	1.78	1.69	1.74	1.70	1.73	1.66	1.72	1.70
	THEATER	TE-361	DEGF	#21 823	911	897	923	926 537	920	594	911	907	929
	AIR PRES	TE-360	PSIG	112	97	91	102	100	107	100	115	110	101
	AIR OP	FT-340	H2O	0.47	0.47	0.47	0.46	0.47	0.47	2.69	2.56	2.60	2.66
	OUTLET SO2(AD.)	SO2REF SO2REF	PPM	2467	2471	2449	2414	2451	2417	2481	2404	2396	2399
	INLET NOXIADA	NOXREF	PPM	645	638	542	\$2	42	529	530	520	607	437
	AIR (V)	FY-380	SCFM	40.3	40.8	41.3	81 40,4	40.2	40.3	27	30	12	84
TEMPERATURE FLE				EMPOSA	FMPost	FMPara	TEMPACE	TEMPART	The second	K140 ****	EL MARCE		
	COMB AR T	TE-1	DEGF	118	97	90	101	109	108	111	119	114	101
	MOTAIRT	12-3 TE-6	DEGF	800	500	500	500	500	500	500	500	500	500
	FUR REFR T	TE-4	DEGF	1556	1641	1870	1596	1684	1690	1594	1596	1892	1594
	TOT FGAST	TE-14	DEGF	\$50	1110	1118	1116	1122	1134	1130	1136	1131	1131
	ABS FGAST	TE-16	DEGF	750	750	750	750	780	750	750	750	750	748
	BGHS TOP T	TE-28	DEGF	366	365	385	386	385	386	385	365	386	386
	ABS Z1 T	TE-30 TIC-6E	DEGF	387	366	358	366	347	192	165	159	336	360
	ABS Z2 T	TIC-88	DEGF	750	760	750	750	780	780	760	760	750	750
	A83 Z3 T	TIC-\$1	DEGF	780	750	750	750	760	780	750	760	760	760
	ABS ZS T	TIC-97	DEGF	750	750	780	750	760	760	750	750	750	760
	CWFUREXT	TE-43	DEGF	109	134	100	142	113	112	113	111	110	106
	CW FGC EXT	TE-44	DEGF	93	90	77	86	56	87	92	97	90	66
······································			- wr	0.01	03	07		82	83	80	85	80	77

Table 8. Detailed Information for Test MBCUO-4

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| MBCUO-06 | PARAMETER | TAG | EN | 1

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 | | 10
 | 11 | 12 | 13
 | 14 | 18 | 18 |
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 | COMBONS

 | COMBONS

 | COMBONA

 | 0000046
 | COMBONE
 | COM8047

 | COMBAN
 | C048049 | C048049
 | COMBOSO | COMBOST | COMBOSE
 | COMBOSS | COM8063 | COMBOS |
| CONSUSTONTES | COMB AIR | FY-1 | #/H | 446.9

 | 448.6

 | 447.1

 | 446.8

 | 446.8
 | 446.0
 | 446.8

 | 447.9
 | 448.9 | 444.8
 | 430.2 | 430.1 | 438.0
 | 432.0 | 432.8 | 432. |
| | NATURAL GAS | FY-20 | 5/HR | 21.73

 | 221.71

 | 22.71

 | 22.71

 | 22.72
 | 22.71
 | 22.72

 | 22.64
 | 22.72 | 22.71
 | 4.87 | 4.47 | 4.64
 | 22.72 | 22.72 | 22.7 |
| | COAL SECOND W/T | WKT-26 | #/HR | 0.00

 | 0.00

 | 0.00

 | 0.00

 | 0.00
 | 0.00
 | 0.00

 | 0.00
 | 0.00 | 0.00
 | 30.71 | 30.80 | 30.73
 | 0.00 | 49.19 | 48,8 |
| | EXCESS AM | BY-X | XXSA | 16.80

 | 10.86

 | 16.00

 | 16.86

 | 16.86
 | 16.94
 | 16.85

 | 17.37
 | 17.40 | 16.36
 | 22.77 | 22.51 | 22.40
 | 13.20 | 13.22 | 13.1 |
| | FLUE GAS (A) | FY-18 | \$/HR | 638.1

 | 537.0

 | 537.4

 | 639.7

 | 630.7
 | 638.0
 | 637.4

 | 539.4
 | 543.6 | 540.4
 | 544.5 | 547.7 | 544.8
 | 622.1 | 523.1 | 626. |
| | FURNACE OR | AT-08-0
PT-6 | H20 | 4.48

 | 4.32

 | 4,41

 | 4.40

 | 4.84
 | 4.60
 | 4.67

 | 4.73
 | 4.82 | 4.87
 | 3.90 | 3.82 | 6.83
 | 4.21 | 4.30 | 4.3 |
| | COMB ANP | PT-1 | PBIQ | 4.20

 | 4.36

 | 4.27

 | 4.44

 | 4.30
 | 4.27
 | 4.26

 | 4.29
 | 4,49 | 4.38
 | 4.42 | 4.86 | 4.16
 | 4.10 | 4.28 | 4.3 |
| | NATURAL GAS P | PT-20 | PSIA | 4.13

 | 4.17

 | 4.14

 | 4.19

 | 4.18
 | 4.14
 | 4.18

 | 4.14
 | 4.16 | 4.13
 | 4.63 | 4.63 | 4.60
 | 4.13 | 4.14 | 4.1 |
| | FLUE GAS P | PT-16
PT-25 | -H20
P643 | 8.31

 | 5.30

 | 8.42
116.41

 | 114.54

 | 115.40
 | 115.30
 | 8.38
115.21

 | <u> </u>
 | 113.30 | 6.41
113.60
 | 113.25 | 112.00 | <u> </u>
 | 112.11 | 111.26 | 110.8 |
| | THEOR AIR | BY-X | THEOAR | 342.56

 | 342.22

 | 382.13

 | 382.36

 | 342.33
 | 382.18
 | 382.37

 | 301.63
 | 342.33 | 342.29
 | 370.97 | 372.10 | 371.48
 | 382.34 | 342.26 | 302.3 |
| | FURNACE CO | AT-CO-0 | PPM | 12.46

 | 13.66

 | 12.21

 | 13.50

 | 11.88
 | 11.87
 | 11.82

 | 11.72
 | 11.80 | 11.86
 | 66.90 | 81.37 | 123.34
 | 14.63 | 11.70 | 11.8 |
| | FLUE GAS (V) | 8Y-3
FY-16 | SCPM | 118.4

 | 0.00

 | 0.00

 | 0.00

 | 0.00
 | 0.00
 | 116.2

 | 118.7
 | 116.6 | 0.00
 | 116.8 | 117.6 | 116.8
 | 112.0 | 112.2 | 112.3 |
| ABSORBERFLE | | | | A85054

 | A88065

 | A8.9066

 | A85057

 | A85050
 | A88060
 | A88000

 |
 | A88064 | A88064
 | ABSORE | A88086 | A88067
 | A85068 | A8.5066 | A85068 |
| | NLET SO2 | AT-SOR-1 | PPM | 2166

 | 2207

 | 2197

 | 2330

 | 2236
 | 2261
 | 2250

 | 2264
 | 2241 | 2297
 | 2062 | 2117 | 2074
 | 2201 | 2209 | 222 |
| | NLET 02 | AT-02-1 | PERCENT | 4.74

 | 4.67

 | 4.74

 | 4.79

 | 4.87
 | 4.92
 | 4.91

 | 8.01
 | 5.19 | 5.17
 | 4.69 | 4.40 | 4.45
 | 4,61 | 4.56 | 4.6 |
| | OUTLET NOX | AT-NOK-2 | PPM | 130

 | 23

 | 60

 | 42

 | 69
 | 67
 |

 | 200
 | 73 | 22
 | 19 | 647 | 623
 | 97 | 100 | 100 |
| | NO SPIKE | AT-02-2 | PERCENT | 8.14
0.16

 | 5.06

 | 6.11

 | 8.21

 | <u>5.30</u>
0.00
 | 8.47
0.00
 | 0.11

 | 0.12
 | 6.64 | 6.70
 | 6.74 | 6.76 | 5.50
 | 5.04 | 0.00 | 5.19 |
| | 502 8PHCE | FT-102 | #/HR | 1.46

 | 1.51

 | 1.\$1

 | 1.61

 | 1.61
 | 1.41
 | 1.61

 | 1.61
 | 1.61 | 1.61
 | 0.26 | 0.26 | 0.27
 | 1.62 | 1.52 | 1.84 |
| | BED DP | PDT-19 | H2O | 1.40

 | 1.66

 | 1.44

 | 1.87

 | 2.16
 | 2.44
 | 1.83

 | 1.70
 | 1.36 | 1.73
 | 12.25 | 17.78 | 14.90
 | 1.62 | 1.73 | 1.64 |
| | PLUE GAB 140 | PT-17 | -H20 | 8.80

 | 496.3
6.84

 | \$01.5
8.82

 | 6.87

 | 6.86
 | 6.79
 | 6.76

 | 6.84
 | 6.97 | 6.44
 | 6.49 | 6.62 | 8.54
 | 6.50 | 8.46 | 6.63 |
| | SCREEN OP | PDT-21 | HeO
DEAF | 0.70
748

 | 0.71

 | 0.71

 | 0.81

 | 1.06
 | 1.14
 | 0.87

 | 0.62
 | 0.67 | 0.64
 | 7,17 | 14.18 | 12.28
 | 0.83 | 1.12 | 1.2 |
| | GAS OUTLET | TE-21 | DEGF | 671

 | 867

 | 647

 | 647

 | 441
 | 450
 | 647

 | 644
748
 | 6461
74.9 | 844
 | 618 | 601
711 | 596
 | 696 | 508 | 61 6
802 |
| | SORE OUT | TE-301 | DEGF | 690

 | 690

 | 687

 | 687

 | 677
 | 679
 | 693

 | 647
 | 642 | 691
 | 723 | 714 | 632
 | 647 | 718 | 718 |
| | SO2 REMOVAL
NOX REMOVAL | SO2REF
NOXREF | PERCENT | 93.8
94.8

 | 93.8

 | 92.4

 | 93.6

 | 91.6
 | 88.4
12.0
 |

 | 90.8
 | 89.8 | 92.4
96.4
 | 90.3 | \$7.9
0.5 | 82.7
 | 90.3 | 96.8 | 946.7 |
| | FLUE GAB (V) | FY-17 | SCPM | 110.7

 | 107.0

 | 107.6

 | 107.7

 | 107.7
 | 107.3
 | 107.7

 | 107.9
 | 108.4 | 107.7
 | 54.9 | 54.2 | 84.7
 | 87.3 | 50.0 | 58.1 |
| REGENERATOR FLE | | AT-00-44 | DEDCENT | REGOS4

 | REGOSS

 | REGOSS

 | REGOS7

 | REGOSA
 | REGOS
 | REGOOD

 | REG61463
 | REGORA | REGOSA
 | REGOSS | REGOOS | REGOS7
 | REGOSS | REGOSS | REGOSS |
| | REGEN 802 | AT-802-4 | PERCENT | 42.13

 | 26.66

 | \$0.14

 | 41.82

 | 22.62
 | 81.26
 | 13.56

 | 16.36
 | 46.96 | 43.18
 | 22.00 | 0.71 | 17.86
 | 12.42 | 30.04 | 33.64 |
| | REGEN CH4
REGEN CO2 | AT-CH4-4 | PERCENT | 41.48

 | 23.81

 | 0.18
48.14

 | 11.74

 | 0.00
 | 0.00
 | 2.06

 | 0.00
 | 16.08 | 38.92
 | 0.00 | 23.19 | 0.00
 | 0.00 | 0.00 | 0.00 |
| | REGEN HOS
REGEN OR | AT-H28-4 | PERCENT | 0.06

 | 0.05

 | 0.06

 | 0.04

 | 0.06
 | 0.04
 | 0.04

 | 0.05
 | 0.04 | 0.04
 | 0.04 | 0.04 | 0.05
 | 0.04 | 0.03 | 0.03 |
| | NATURAL GAS | FY-300 | 8/HR | 0.60

 | 0.60

 | 0.30

 | 0.60

 | 0.88
 | 0.88
 | 0.80

 | 0.84
 | 0.60 | 0.00
 | 0.26 | 0.20 | 0.41
 | 0.44 | 0.88 | 1.23 |
| | REGEN P | PT-380 | H2O | 0.56

 | 3.60

 | 0.34

 | 6.60

 | 0.04
 | 1.56
 | 60.76

 | 14.92
 | 0.66 | 1.83
 | 1.76 | -0.86 | 1.27
 | 1.30 | 5.06 | 7.47 |
| | TSORE LEVEL | TE-381 | DEGF | 30.12

 | 26.60

 | 26.26

 | 23.84

 | 26.27
 | 28.40
 | 26.80

 | 770
 | 27.86 | 28.23
 | 24.05 | 24.32 | 28.68
608
 | 806 | 27.30 | 26.60 |
| | TSORB (17)
TSORB (32) | TE-382
TE-383 | DEGF | 196

 | 840

 | 844

 | 349

 | 1106
 | 840
 | 846

 | 768
 | 788 | 836
 | 876 | 763 | 801
737
 | 790 | 783 | 790 |
| | TSORE (47) | TE-384 | DEGF | 848

 | 945

 | 861

 | 348

 | 847
 | \$32
 | 662

 | 760
 | 819 | 961
 | \$76 | 747 | 300
 | 763 | 777 | 787 |
| | TGASCEDED | 17-365 | DEGE |

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 | 807
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 | 5 0 1
 | |
 | 976 | / | / 64/
 | | | |
| | TGAS(E)(T)
TOFFGAS | TE-306
TE-306 | DEGF | 166

 | 183

 | 143

 | 162

 | 210
 | 197
 | 267

 | 217
 | 162 | 164
 | 976 | 110 | 168
 | 180 | 178 | 191 |
| | TGAS(ENT)
T OFFGAS
T COND EX
T INC EX | TE-386
TE-386
TE-387
TE-200 | DEG F
DEG F
DEG F | 918
166
69
343

 | 931
183
76
338

 | 143
143
94
412

 | 162
73
346

 | 210
79
373
 | 807
197
94
366
 | 267
56
386

 | 217
65
360
 | 162
76
376 | 184
72
373
 | 146
70
396 | 110
70
339 | 148
148
81
392
 | 180
72
378 | 178
63
371 | 1 \$1
61
341 |
| | TGAS(EDIT)
T OFFGAS
T CONDEX
T INC EX
INCIN 02
INCIN 502 | TE-365
TE-365
TE-367
TE-200
AT-02-6
AT-802-6 | DEG F
DEG F
DEG F
PERCENT
PPM | 166
89
343
20.07
696

 | 931
183
76
338
20.06
601

 | 143
94
412
19.78
500

 | 1 62
73
344
20.02
543

 | 210
79
373
19.97
447
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356
20.06
503
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 | 217
65
360
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646
 | | 184
72
373
16,25
580
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146
70
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19.84
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70
339
20.00
134 | 780
148
81
392
19.61
412
 | 180
72
378
19,83
320 | 178
63
371
19.93
676 | 191
61
361
19.94
644 |
| | TGAS(ENT)
T OFFGAS
T COND EX
T INC EX
INCIN 02
INCIN 02 | TE-385
TE-385
TE-387
TE-200
AT-02-5
AT-302-5 | DEG F
DEG F
DEG F
DEG F
PERCENT | 918
186
89
363
20.07
696
FBH064

 | 931
183
76
338
20.06
601
FBH066

 | 143
94
412
19.78
500
FBH066

 | 1 82
73
344
20.02
583
FBH067

 | 210
79
373
19.97
447
 | 507
197
94
356
20.06
503
78/1069
 | 267
56
388
19.90
616
78H080

 | 217
45
360
20.01
645
645
 | 670
182
76
376
19.93
691
FBH064 | 943
184
72
373
16.25
580
FBH084
 | 978
148
70
398
19.84
400
FBH066 | 700
110
70
339
20.00
134
FBH066 | 148
81
392
19.01
412
FBH067
 | 541
180
72
378
19.93
320
FBH066 | 178
63
371
19,93
678
FBH068 | 131
61
361
19.94
640
FBH066 |
| | TGAS(E)(TT)
TOPFGAS
TCONDEX
TINCEX
INCIN 62
INCIN 602
TSORB(127)
NATURAL GAS | TE-346
TE-360
TE-367
TE-300
AT-02-6
AT-302-6
TE-373
TE-373 | DEG F
DEG F
DEG F
PERCENT
PPM | 918
166
89
343
20.07
696
FBH064
976
5.36

 | 931
183
76
338
20.06
601
FBH066
999
8.66

 | 143
94
412
19.75
500
FBH066
960
5.29

 | FBH067
162
73
346
20.02
643
FBH067
1000
6.70

 | 210
210
79
373
19.97
447
FBH068
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94
356
20.08
503
FBH069
1007
5.46
 | 267
56
366
19.90
616
FBH060
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5.92

 | 217
65
360
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 | 670
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19.93
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8.46 | 963
164
72
373
16.25
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 | 978-
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70
396
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400
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930
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110
70
338
20.00
134
FBH066
5.36 | 780
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19.01
412
FBH087
901
4.69
 | 541
180
72
378
19.93
320
F8H066
592
5.37 | 178
63
371
19,93
678
78H048
901
8,89 | 191
191
361
19.94
648
FBH068
900
8.78 |
| RUD BED HEATER FLE | TGAS (EIGT)
T OFF CAS
T COND EX
T INC EX
INCIN 502
INCIN 502
INCIN 502
INCIN 502
INCIN 502
INCIN 502
INCIN 502 | TE-346
TE-346
TE-340
AT-02-6
AT-02-6
AT-302-6
TE-373
FY-66
FY-30 | DEG F
DEG F
DEG F
PERCENT
PPM
DEG F
JANA
JANA
FARE | 918
156
09
343
20.07
596
596
596
596
596
596
536
316.9

 | 531
183
76
338
20.08
601
FBH066
586
5.66
312.4

 | 004
145
94
412
19.78
500
FBH066
960
6.29
319.8

 | FBH057
1000
543
73
344
20.02
543
78H057
1000
6.70
311.6

 | 210
78
373
19.97
447
FBH068
997
5.80
312.0
 | 507
197
346
20.06
503
FBH059
1007
5.46
313.6
 | 78H040
1026
78H040
1026
5.92
307,3
200

 | 500
217
65
340
20.01
645
FBH61563
900
6.10
336.4
 | 670
182
76
376
19,93
691
FBH064
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326.0
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184
72
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326.5
 | 976
146
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400
FBH065
930
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341,7 | 700
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20.00
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412
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 | 541
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72
378
19,83
320
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882
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271,8 | 178
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63
371
19.93
678
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901
5.69
369.1
1.50 | 500
191
01
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19.94
640
FBH068
900
6.78
369.2
1.50 |
| AUD BED HEATER FLE | TGAAGERT)
TGAAGEX
TGAAGEX
TGAAGEX
INCEX
INCEX
INCEN 502
NATURAL GAG
ANTRAIR GA
FBH VEL
FBH 02 | TE -346
TE -346
TE -367
TE -260
AT-02-6
AT-302-8
FY-86
FY-80
SY-30
AT-02-3 | DEG F
DEG F
DEG F
PERCENT
PPM
DEG F
JANR
FT/SEC
PERCENT | 918
166
89
343
20.07
696
FBH064
976
5.36
5.36
316.9
3.20
15.46

 | 533
76
3330
20.08
601
78H055
999
5.66
5.12.4
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3.20
15.20

 | 145
145
94
412
19.78
500
FBH046
960
5.29
319.8
3.20
18.77

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182
73
344
20.02
643
78H057
1000
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311.6
3.20
15.27

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210
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373
19.97
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FBH068
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3.20
16.20
 | 807
197
94
386
20.04
603
78H069
1007
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313.6
3.20
18.32
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 | 976
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| AUD BED HEATER FLE | TGAS (EXT)
T GAP GAS
T COND EX
T INC EX
INC IN G2
NCIN 502
NATURAL GAS
ANTR AIR (M
FBH VEL
FBH G2
TANTR GUT
T PLENAM | TE -346
TE -367
TE -367
TE -200
AT-02-6
AT-802-6
TE -373
FY-66
FY-60
SY-30
AT-02-3
TE -370
TE -370 | DEG F
DEG F
DEG F
PERCENT
PERCENT
PERCENT
PERCENT
FT/BEC
PERCENT
DEG F
DEG F | 918
156
383
20.07
596
FBH054
FBH054
FBH054
5.38
316.5
3.20
18.64
1193
669

 | 533
78
20.08
601
FBH055
5.46
312.4
3.20
15.30
1246
680

 | 143
143
19.78
500
FBH056
600
6.29
319.5
3.20
15.77
11.78
684

 | 73
182
73
344
20.02
643
FBH057
1000
6.70
311.6
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18.27
1247
702

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373
18.97
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708
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356
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603
78/056
78/056
1007
5.46
313.6
313.6
320
18.32
1236
697
 | 611
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64
346
19.90
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307.3
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643 | 700
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10
20.00
134
FBH066
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343.6
343.6
16.84
946
5.51
5.51
 | 740
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19.81
412
78H067
901
4.69
349.7
3.50
17.10
930
613 | 381
180
72
378
19.53
320
FBH046
862
8.37
371.8
3.40
16.76
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Table 9. Detailed Information for Test MBCUO-5

MBCUO-06	PARAMETER	TAG	€/U	1	2	3	4	5		7
COMBUSTOR FLE				COM8064	COM674.50	COMBOSI	COMB062	COMBORS	COM8064	COMBOSS
	COMB AN	FY-1	SMR.	428.2	443.1	443.0	443.0	443.0	443.0	443.1
	NATURAL GAS	FY-20	#/HR	22.00	22.93	22.94	22.95	22.93	22.83	22.92
	COAL	WKT-26	4/HR	0.00	0.00	0.00	0.00	0.00	0.00	0.00
	EXCESS AM	8Y-X	%X8A	14.62	14.81	14.81	14.82	14.83	14.80	14.83
	FLUE GAS (M)	FY-16	#/HR	623.4	600301 518.7	\$21.2	623.1	526.9	823.7	518.5
	FURNACE 02	AT-02-0	¥ H2O	4.81	3.77	4.02	4.04	4.07	4.03	3.77
	COME AR P	PT-1	PSKA	4.49	4.36	4.30	4,18	4.64	4.34	4.48
	NATURAL GAS P	PT-3 PT-20	P81G P81G	96.70	96.38	96.90	98.80	97.10 4.18	96.16 4.11	96.88 4.12
	FLUE GAS P	PT-16	- H20	5.61	5.50	6.62	5.60	5.44	5.44	5.39
	THEORAIR	BY-X	THEOAR	371.82	386.89	385.84	386.84	386.63	385.89	385.81
	FURNACE CO2	AT-CO2-0	PERCENT	9.31	9.78	9.70	9.89	9,66	9.67	9.56
	MOTIVE AIR V	3Y-3	FT/SEC	0.00	0.00	0.00	0.00	0.00	0.00	0.00
	FLOE GHO (V)	F1-10	ovrm.	112.0						
ABSORBER FELE	NLET SOR	AT-808-1	PPM	A88071 2276	A88072 2290	AB8078 2259	A88076 2245	A88077 2244	AB8078 2296	A88079 341
	INLET NOX	AT-NOX-1	PPM	108	518	106	104	107	103	98
	OUTLET SOL	AT-802-2	PPM	334	122	130	102	128	172	3
F	OUTLET NOX	AT-NOK-2	PPM	106	4.11	107	101	103	4.42	101
	NO SPIKE	FT-101	S/MR	0.00	0.10	0.00	0.00	0.00	0.00	0.00
	NH3 SPICE	FT-102	#//HR	0.000	0.126	0.000	0.000	0.000	0.000	0.000
	BED DP FLUE GAS AM	PDT-19 FY-17	H2O #/HR	1.60	2.02	2.48	2.87 610.8	3.60	3,93	4.13
	HLETP	PT-17	-H20	7.22	7.06	7.21	7.07	7.10	7.07	6.58
	GAS INLET	TE-18	DEGP	747	747	747	747	747	747	3.81
	GAS OUTLET	TE-21	DEGF	677	778	674 783	679	671	676	784
	SORBOUT	TE-301	DEGF	649	496	644	694	690	684	580
	NOX REMOVAL	NOXREF	PERCENT	0.1	34.7	0.0	3.3	3.9	4.8	0.0
	FLUE GAS (V)	FY-17	SOFM	106.3	109.1	109.4	109.8	110.2	109.9	108.4
REGENERATOR FLE	AL 1844			RE 0071	RE GOT2	RE GO76	RE GOTS	RE 9077	REG078	RE 0079
	QUICK REP 02 REGEN \$02	AT-802-44	PERCENT	0.16	0.46	0.06	0.43	0.62	0.13	18.68
	REGEN CH4	AT-CH4-4	PERCENT	0.61	0.10	6.60	3.66	0.77	0.64	0.04
	REGEN Has	AT-H20-4	PERCENT	0.00	9.00	0.00	0.00	0.00	0.00	0.00
<u>}</u>	REGEN 02 NATURAL GAS	AT-02-48 FY-300	PERCENT #/HR	0.13	0.49	0.26	0.36	0.26	0.07	0.43
	NITROGEN	FY-310	#/MR	1.16	1.15	0.00	0.00	1.22	1.10	0.66
	SORB LEVEL	LT-380	INCHES	14.34	15.64	27.80	36.11	34.02	34,50	36.78
······	TSORE (27) TSORE (17)	TE - 361 TE - 382	DEGF	706	721	840 843	065 861	870	855	761
	TSORE (32)	TE 363	DEGF	664	676	842	832	806	785	716
	TGAS(EXIT)	TE-346	DEGP	647	687	841	177	153	843	782
	T OFFGAS	TE-306 TE-307	DEGF	248 01	264	246 74	248	247 78	249 84	244 82
	T OFFGAS T COND EX T INC EX	TE-306 TE-307 TE-200 AT-02-E	DEG F DEG F DEG F	248 01 445	264 78 437	246 74 488	249 79 494	247 78 443	249 84 486 18.37	244 82 487 19.02
	T OFFGAS T CONDEX T INC EX INCIN 02 INCIN 502	TE-306 TE-307 TE-200 AT-02-6 AT-802-6	DEG F DEG F DEG F PERCENT PPM	248 81 445 19.74 314	264 78 437 19.67 344	246 74 488 19.36 587	249 79 494 18.43 596	247 78 443 18.72 711	249 84 486 18.37 726	244 82 457 19.02 208
	T OFFGAS T COND EX T INC EX INCIN 02 INCIN 602	TE-346 TE-347 TE-200 AT-02-6 AT-802-8	DEG F DEG F DEG F PERCENT PPM	248 01 446 19.74 314 FBH071	264 78 437 19.67 344 FBH072	244 74 488 19.35 587 FBH078	248 79 494 18.43 596 F8H076	247 78 463 18.72 711 FBH077	249 84 486 18.37 726 F 8H078	244 82 487 19.02 208 FBH079
FLUID BED HEATER FLE	T OFFGAS T COND EX T NC EX HICIN 02 INCIN 802 T30R8(12) NATURAL GAS	TE-306 TE-307 TE-200 AT-02-6 AT-802-6 TE-373 FY-64	DEG F DEG F DEG F PERCENT PPM DEG F	248 81 445 18.74 314 FBH071 745 4.74	284 78 437 18.67 344 FBH072 745 4.30	2446 74 488 19.36 5697 FBH078 1082 5.84	248 79 494 18.63 596 FBH078 1051 8.67	247 78 463 18.72 711 FBH077 969 8 90	249 84 486 18.37 726 FBH078 969 8.80	244 82 487 19.02 208 FBH079 826 4.82
FLUID BED HEATER FLE	T OFFGAS T COND EX T INC EX INCIN 02 INCIN 502 T3 ORB(12) NATURAL GAS ANTR AM (M)	TE - 306 TE - 307 TE - 200 AT - 02 - 6 AT - 802 - 6 TE - 373 FY - 66 FY - 30	DEG F DEG F PERCENT PPM DEG F J/HR J/HR	248 81 445 19.74 314 FBH071 745 4.78 4.78	254 78 437 19.67 344 FBH072 745 4.30 364	246 74 488 19.36 587 FBH076 1082 5.96 280.1	248 79 494 18.63 596 F8H076 1961 6.67 3303	247 78 443 18.72 711 FBH077 959 8.90 321.0	249 84 486 18.37 728 FBH076 5.80 317.2	244 82 487 19.02 200 FBH079 828 4.92 349.6
FLUID BED HEATER FLE	T OFFGAS T COND EX T INC EX INCIN 92 INCIN 502 INCIN 502 INCIN 502 INTURAL GAS AHTR AIR (M) FBH VEL FBH 02	TE-346 TE-347 TE-200 AT-02-8 AT-802-8 TE-373 FY-66 FY-30 SY-30 AT-02-3	DEGF DEGF DEGF PERCENT PPM DEGF J/HR FT/SEC PERCENT	248 81 445 19,74 314 FBH071 745 4,78 418,1 3,50 16,89	284 78 437 19.67 344 FBH072 746 4.30 346.1 3.00 16.74	244 74 488 19.38 587 FBH078 1082 5.96 280.1 3.00 20.01	248 79 494 18.43 596 FBH076 1061 6.67 330.3 3.50 18.01	247 78 443 18,72 711 FBH077 959 8,90 321,0 3,19 15,61	249 84 18.37 726 FBH076 849 8.80 317.2 3.20 15.37	244 82 457 19.02 208 FBH079 826 4.82 249.6 3.18 3.18
FLUID BED HEATER FLE	T OFFGAS T COMD EX T NCE EX INCIN 02 INCIN 602 TSORB(12) NATURAL GAS AHTR AIR (MO F8H VEL F8H 02 TAHTR OUT T PLENIM	TE-346 TE-347 TE-200 AT-02-6 AT-002-6 AT-002-6 TE-373 FY-64 FY-30 SY-30 SY-30 AT-02-3 TE-370 TE-370	DEGF DEGF PERCENT PPM DEGF J/HR FT/SEC PERCENT DEGF DEGF	248 81 445 18.74 314 FBH071 746 4.78 418.1 3.60 16.89 791 447	284 78 437 19.67 344 FBH072 746 4.30 336.1 3.00 16.74 676 490	244 74 19.34 587 58H076 5.96 280.1 3.00 20.01 1344 737	248 79 484 18.63 596 FBH076 1061 6.67 330.3 3.50 16.01 1346 744	247 78 463 18,72 711 FBH077 959 8,90 321,0 3,19 16,61 1233 657	249 84 486 18.37 726 FBH076 949 8.80 317.2 3.20 18.37 1237 644	244 82 487 19.02 208 FBH079 826 4.82 348.6 3.16 16.77 962 548
FLUID BED HEATER FLE	T OFFGAS T COMP EX T COMP EX TINC EX INCIN 02 INCIN 602 TSORB(12) NATURAL GAS AHTR AIR (MO FBH VEL FBH 02 TAHTR OUT T PLENUM TSORB(24) TSORB(24)	TE-346 TE-347 TE-200 AT-02-6 AT-02-6 TE-373 FY-64 FY-30 SY-30 AT-02-3 TE-376 TE-372 TE-374 TE-372 TE-374	DEGF DEGF PERCENT PPM DEGF J/HR J/HR F7/SEC PERCENT DEGF DEGF DEGF DEGF	248 81 445 314 78H071 745 4.78 418.1 3.50 16.89 781 487 741	284 78 437 19.67 344 FBH072 746 4.30 346.1 3.00 16.74 978 490 740	244 74 19.34 19.34 547 76H076 1042 5.94 280.1 3.00 20.01 1.344 737 1.047	248 79 494 18.63 596 FBH076 1061 6.67 330.3 3.50 1061 1.346 746 1.047	247 78 443 18,72 711 FBH077 959 8,90 321,0 3,19 16,61 1,233 667 955	249 84 486 16.37 728 FBH078 849 8.80 317.2 3.20 16.37 1237 648 984	244 82 447 19.02 208 FBH078 826 4.82 348.6 3.18 16.77 962 548 548
FLUID BED HEATER FLE	T OFFGAS T COMD EX T NC EX INCIN 02 INCIN 602 TSORB(12) NATURAL GAS AHTR AIR (MO F8H VEL F8H 02 TAHTR OUT T PLENUM T30R8(24) TVENT THUM OUT	$\begin{array}{c} TE-346\\ TE-3467\\ TE-200\\ AT-02-6\\ AT-02-6\\ TE-3773\\ FY-66\\ FY-30\\ SY-30\\ AT-02-5\\ TE-377\\ TE-377\\ TE-377\\ TE-377\\ TE-377\\ TE-377\\ TE-377\\ \end{array}$	DEGF DEGF DEGF PERCENT PPM DEGF S/HR FT/SEC PERCENT DEGF DEGF DEGF DEGF	246 91 445 18,74 314 745 4,79 418,1 3,50 16,89 791 467 741 691 500	284 78 437 18.67 344 745 4.30 18.74 3361 13.00 16.74 4.30 16.74 4.90 16.74 4.90 16.74 4.90 500	244 74 448 19.34 587 58H075 5.84 280.1 3.00 20.01 1.344 737 1.057 947 947	249 79 694 10.43 596 F8H076 1051 6.67 330.3 3.50 16.01 1.346 746 1.047 923 600	247 78 463 18.72 711 FBH077 959 8.90 321,0 3.19 15.61 1.233 667 955 650 600	249 84 486 18.37 726 5.80 317.2 3.20 18.37 1.237 668 964 964 869 860	244 82 457 19.02 208 FBH079 525 4.82 348.6 3.18 16.77 942 548 622 731 500
FLUID BED HEATER FLE	T OFFGAS T COMP EX T COMP EX T COMP EX INCEN 502 INCEN 502 T30 R8(12) NATURAL GAS ANTR AIR (M) FBH VEL FBH 02 TANTR OUT T PLENUM T30 R8(4) T THENUM T THENUM T SORS(4) T THENUM T HUM OUT FBH PRES BED DP	TE - 344 TE - 347 TE - 200 AT-02-6 AT-02-6 FY-30 FY-46 FY-30 SY-30 SY-30 AT-02-3 TE - 376 TE - 376 TE - 376 PT - 376 PT - 376	DEGF DEGF DEGF PERCENT PPM DEGF S/HR FT/9EC PERCENT DEGF DEGF DEGF DEGF DEGF DEGF DEGF DEGF	248 e1 445 19,74 314 745 4,78 4,78 4,78 4,87 16,89 791 407 741 691 600 12,84 12,84 12,84 12,84 12,84 12,84 12,84 12,84 13,74 14,744 14,7	254 78 437 78 78 78 78 78 74 430 344 344 344 344 344 740 740 850 500 500 500	244 74 446 19.35 587 75H076 200.1 3.00 20.01 3.00 20.01 1.344 737 1057 941 600 12.18 5.84	240 79 684 18.43 586 FBH076 1061 6.87 330.3 3.50 18.01 1346 746 746 746 1047 823 600 14.97 8.31	247 78 4613 18,72 711 FBH077 989 321,0 3,19 18,61 12313 667 9668 8600 6000 13,64 11,01	249 84 96 96 96 96 96 96 96 96 96 96 96 96 96	244 82 457 19.02 200 784078 784078 784078 4.82 3.18 16.77 962 548 649 822 731 600 16.11 7.72
	T OFFGAS T COMP EX T COMP EX T THC EX INCEN 502 INCEN 502 T3 ORB(12) NATURAL GAS AMTR AIR GQ FBH VEL FBH 02 TAHTR OUT T PLENAM T DEN FGS BED OP PLENAM OUT	TE - 344 TE - 347 TE - 200 AT-02-6 AT-02-6 TE - 373 FY-46 FY-30 SY-30 SY-30 AT-02-3 TE - 376 TE - 376 TE - 376 PT - 376 P	DEGF DEGF DEGF PERCENT PPM DEGF JHR JHR FT/JEC PERCENT DEGF DEGF DEGF DEGF DEGF DEGF DEGF DEGF	244 61 445 19.74 314 754 479 418.1 3.50 16.89 791 407 711 500 17.36 12.84 11.83 705 71.95 705 705 705 705 705 705 705 70	284 78 437 19.67 78 744 4.30 384 1.3.00 16.74 450 740 740 740 740 740 740 740 740 740 74	244 74 74 448 19.35 5.847 7514078 200.11 3.900 20.01 1.348 737 71 067 1057 1057 1057 1057 1057 1057 1057 105	246 75 76 78 78 78 78 76 76 76 76 76 76 76 76 76 76 76 76 76	2447 78 443 16.72 711 FBH077 959 8.90 321.0 321.0 3.19 15.61 1233 667 965 660 600 13.64 11.01 9.97 7.7	249 84 86 726 726 726 726 726 89 99 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8	244 82 447 19.02 78H079 828 4.82 348 6 3.16 3.16 3.16 3.16 3.16 3.16 16.11 5000 16.11 7.72 9.92 7.31 1 5000
	T OFFGAS T COMB EX T COMB EX T TONE EX INCEN 502 INCEN 502 TSORB(12) NATURAL GAS ANTR AIR GB FBH VEL FBH 02 TANTR OUT T PLENAM TSORBGAY THENT THENT THENT THENT THENT FBH PRES DEC OP PLENAM DP FBH NOX FBH NOX	TE - 3467 TE - 347 TE - 200 AT-002-6 AT-002-6 FY-64 FY-30 SY-30 SY-30 TE - 376 TE - 377 TE - 378 PDT - 376 PDT - 376 PDT - 376 PDT - 376 PDT - 376 PDT - 376 AT - 802-3	DEG F DEG F DEG F PERCENT PPM DEG F S/HR S/HR S/HR S/HR S/HR DEG F DEG F PPM PPM	248 81 445 19.74 314 758 418.1 761 46.88 791 467 771 467 771 500 17.36 12.64 11.83 10.50 0.000	284 78 437 19.67 344 78 430 344 430 344 430 18.74 450 786 450 780 18.74 780 18.74 780 780 18.74 780 780 780 780 780 780 780 780 780 780	244 74 449 19.35 5.847 75H078 200.1 1340 20.01 1340 737 1057 1057 1057 1057 1057 1057 1057 105	246 78 78 78 78 78 78 78 78 78 78 78 78 78	2447 78 4643 18.72 711 FBH077 5858 8.90 321.0 32	249 84 86 16.37 726 727 728 88 8 8 8 8 8 8 8 8 8 8 8 8 8 8	244 827 487 19.02 200 75075 825 4.82 348.6 349.6
	Т ОГРГААВ Т СОЛР ЕХ Т СОЛР ЕХ Т ТОЛС ЕХ INCIN 602 INCIN 602 TSOR8(112) NATURAL GAS ANTR AIR (MG FBH VEL FBH 02 TAHTR OUT T PLENUM TSOR8(49) TWENT THUM BEO DP FBH NOX FBH 02 FBH NOX FBH NOX FBH 802 ANTR AIR (M AA TR AIR (M	$\begin{array}{c} TE - 3467\\ TE - 347\\ TE - 200\\ AT - 602 - 6\\ AT - 602 - 6\\ AT - 602 - 6\\ TE - 373\\ TE - 373\\ TE - 376\\ TE - 3$	DEG F DEG F DEG F PERCENT DEG F PPM DEG F FYSEC DEG F DEG F SCFM SCFM	244 61 445 19.74 314 745 4.78 4.78 4.78 4.87 745 745 751 4.78 751 751 751 751 751 751 751 751 751 751	284 78 437 78 544 78 430 78 430 3841 13.00 18.74 93 840 18.74 850 850 94 850 740 850 95 850 740 850 740 850 740 850 740 850 740 850 740 850 740 850 740 850 740 850 740 850 740 850 740 850 740 850 740 750 850 740 750 850 740 750 740 750 740 750 740 750 740 750 740 750 760 750 760 750 760 750 760 760 760 760 760 760 760 760 760 76	2446 74 460 19.35 587 7 58H078 1082 2001 1344 737 1067 841 500 12.18 500 12.18 5.96 5.96 5.96 5.96 5.96 5.96 5.91 1.04 3.72 5.95 5.95 5.95 5.95 5.95 5.95 5.95 5.9	240 78 78 78 78 78 78 78 78 78 78 78 73 73 73 73 73 73 73 74 74 74 74 74 74 74 74 74 74 74 74 74	247 78 463 18.72 711 FBH077 986 8.90 321.0	249 844 454 16.37 726 949 949 317.2 3.20 3.20 3.20 3.20 3.20 3.20 3.20 3.	244 827 487 19.02 200 825 48.2 348.6 349.6
	T OFFGAS T COMP EX T COMP EX T COMP EX INCIN 602 INCIN 602 TSORB(12) NATURAL GAS ANTR AIR (MO FBH VEL FBH 02 TAHTR OUT TPLENUM TSORB(04) TOENT THEN OUT THEN OUT FBH PRES BEO DP FEH NOX FBH NOX FBH S02 AHTR AIR (M PEG H2 (M)	$\begin{array}{c} TE - 3467\\ TE - 3467\\ TE - 200\\ AT - 02 - 6\\ TE - 373\\ FY - 46\\ FY - 30\\ SY - 30\\ AT - 02 - 3\\ TE - 376\\ TE - 376\\ TE - 376\\ TE - 376\\ PD - 376\\ PD - 376\\ PD - 376\\ PD - 377\\ AT - 802 - 3\\ AT - 802 - 3\\ FY - 300\\ FY - 3006\\ FY - 3106\\ \end{array}$	DEG.F DEG.F DEG.F DEG.F DEG.F PPM PPM SOFM SOFM SOFM SOFM SOFM	244 61 445 76 76 746 746 746 746 746 741 741 741 751 751 751 751 751 751 751 751 751 75	284 78 437 78 544 78 430 78 430 3841 13.00 18.74 450 78 78 50 50 78 50 50 50 50 50 50 50 50 50 50 50 50 50	2446 74 460 5877 FBH078 1082 5.96 2001 1344 737 1067 541 500 12.18 500 12.18 5.96 5.97 1067 5.96 5.97 1067 5.97 5.97 5.97 5.97 5.97 5.97 5.97 5.9	240 78 78 78 78 78 78 78 78 78 78 73 73 73 73 73 73 73 73 73 74 74 74 74 74 74 74 74 74 74 74 74 74	2447 78 4613 18.72 7711 FBH077 9869 321.0	249 844 456 16.37 726 949 949 949 317.2 3.20 3.20 3.20 3.20 3.20 3.20 3.20 3.	244 82 487 787 828 828 828 828 828 828 828 828 8
	T OFFGAS T COMP EX T COMP EX T TONE EX INCEN 502 TSORB(12) NATURAL GAS ANTR AIR 60 FBN VEL FBN 02 TAITH OUT T PLENUM TOPENT THEN BED OF FBN NOX FBN NOX FBN NOX FBN NOX FBN NOX FBN S02 ANTR AIR (M PEG NGAS (M) REG NES (M)	$\begin{array}{c} TE - 3467\\ TE - 347\\ TE - 200\\ AT - 602 - 6\\ AT - 602 - 6\\ AT - 602 - 6\\ TE - 373\\ FY - 64\\ FY - 30\\ SY - 30\\ AT - 02 - 3\\ TE - 376\\ PD - 376\\ PD - 376\\ PD - 377\\ AT - 802 - 3\\ FY - 30\\ FY -$	DEG F DEG F DEG F PERCENT PPM DEG F S/HR S/HR F7/SEC PERCENT DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F SCFM SCFM	244 611 445 445 445 445 447 746 447 746 447 741 601 500 17.36 12.84 11.83 10.30 0.000 91.64 5.25 751 751 751 751 751 751 751 751 751 75	284 76 437 18.67 344 FBH072 774 4.30 18.74 4.50 18.74 4.50 18.74 4.50 18.74 4.50 18.74 4.50 13.46 12.79 8.73 0.50 0 78.06 78.06 78.06 78.06 78.06 78.05 78.05 78.05 78.05 78.05 78.05 78.05 78.05 78.05 78.05 78.05 78.05 78.05 74.0	2446 74 4466 847 755H078 1042 5.86 280.1 3.90 20.01 1.390 20.01 1.390 20.01 1.390 20.01 1.390 8.85 8.71 1.04 3.72 6.139 0.20 12.119 8.85 8.71 1.04 2.02 2.02 1.04 2.02 1.04 2.02 1.04 2.02 1.04 2.02 1.04 2.04 1.04 2.04 2.04 2.04 1.04 2.04 2.04 2.04 2.04 2.04 2.04 2.04 2	240 240 79 79 464 10.43 590 70 10.01 10.41 10.41 10.41 10.41 10.47 10.47 823 800 16.07 78 823 800 16.07 16.07 823 800 16.07 17.04 823 800 16.01 10.44 10.45	247 768 463 16.72 711 FBH077 589 331.0 3319 16.61 1235 665 860 860 13.64 11.01 9.97 18.43 0.00 070.37 9.0.39 9.0.28 FBC077	249 84 466 10.37 7220 FBH076 6.60 317.2 3.20 016.37 1237 23.20 016.37 1237 1237 1237 1237 1237 1237 1237 12	244 82 487 787 826 826 826 826 828 828 828 828 829 829 829 820 800 16.11 7.72 822 820 800 16.11 7.72 822 820 800 16.11 7.72 822 800 800 16.11 7.72 822 800 800 800 800 800 800 800 800 80
	T OFFGAS T COMP EX T COMP EX T COMP EX INCEN 502 INCEN 502 TSORB(12) NATURAL GAS ANTR AIR 60 FBH VEL FBH 02 TAITH OUT T PLENUM TO OUT T PLENUM TO OUT T HLENUM D FBH NOX FBH S02 ANTR AIR (M RE G AR VEL AIR VEL AIR VEL AIR VEL	$\begin{array}{c} TE - 3467\\ TE - 347\\ TE - 200\\ AT - 602 - 6\\ TE - 373\\ FY - 64\\ FY - 30\\ SY - 30\\ AT - 602 - 3\\ TE - 376\\ TE - 376\\ TE - 376\\ TE - 376\\ PD - 37$	DEG F DEG F DEG F PERCENT PPM DEG F S/HR S/HR F7/SEC PERCENT DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F S/GM S/GM S/GM	244 611 445 445 445 18,74 746 478 448,1 3,840 16,89 791 741 800 17,36 12,84 11,83 10,30 9,000 91,64 0,18 0,28 5,018 0,28 5,018 0,28 5,018 0,28 5,018 0,28 5,018 0,2010,201	284 70 437 18.67 344 FBH072 746 4.30 384.1 3.00 16.74 4.00 16.74 4.00 16.74 4.00 16.74 4.00 16.74 4.00 13.44 5.00 78.06 0.33 0.03 78.06 0.34 0.33 0.03 78.06 78.07 74.07	2446 74 4466 847 FBH078 1042 5.846 280.1 3.90 20.01 1.346 737 1057 841 1.047 8.87 1.057 8.91 1.047 8.87 1.057 8.91 1.047 8.92 8.92 9.050 0.220 0.52 0.52 0.52 0.52 0.52 0.52	240 240 79 78 464 58 78 70 1051 1051 1051 1051 1051 1051 1051 1	247 763 763 764 764 764 764 764 764 764 764 764 764	249 844 466 10.37 728 FBH076 580 317.2 3.20 17.2 3.20 17.2 3.20 17.2 3.20 17.2 3.20 17.2 3.20 17.2 3.20 17.2 3.20 13.20 13.20 5.25 5.20 5.25 5.20 5.25 5.20 5.25 5.20 5.25 5.20 5.25 5.25	244 82 487 787 826 826 826 826 828 828 828 828 828 828
FLUID BED MEATER FLE	T OFFGAS T COMP EX T COMP EX T COMP EX INCIN 502 INCIN 502 INCIN 502 TSORB(12) NATURAL GAS AHTR AIR (M) T PLENUM T PLENUM PEH VEL FEH 02 T PLENUM T PLENUM PEH NOX FEH 02 AHTR AIR (M) REG 042 (M) FEC AIR VEL AIR (M) T PLENUM T PLENUM T PLENUM T PLENUM T PLENUM T PLENUM T PLENUM T PLENUM	TE - 346 TE - 347 TE - 200 AT-02-6 AT-02-6 AT-02-6 FY-46 FY-30 SY-30 TE - 373 TE - 379 TE - 379 TE - 379 TE - 379 TE - 376 TE - 376 PDT - 376 PDT - 376 PDT - 376 PDT - 377 AT-NOX-3 AT-602-3 FY - 300 FY - 300	DEG F DEG F DEG F PERCENT PPM DEG F FINEC FINECENT FINECENT DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F SCFM SCFM SCFM SCFM SCFM SCFM SCFM DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F SCFM SCFM SCFM SCFM SCFM SCFM SCFM SCF	244 611 445 445 445 445 445 445 445 445 445 741 447 741 601 60 741 601 741 601 741 601 741 601 60 91 447 741 601 60 91 447 741 60 91 60 91 60 90 91 64 67 97 74 74 80 74 74 74 80 74 80 74 80 74 80 74 80 74 80 74 80 74 80 74 74 74 74 74 74 74 74 74 74 74 74 74	284 76 437 19.47 344 FBH072 744 430 3.00 16.74 450 740 850 13.44 12.79 8,73 0.33 0.33 0.33 0.34 0.34 0.34 0.32 0.34 0.32 0.32 0.33 0.33 0.33 0.33 0.34 0.34 0.34 0.34	2446 74 4466 5877 FBH078 5.86 220.11 3.00 20.01 13846 7377 1057 5411 5.00 12.18 9.85 0.71 1.047 5.01 1.047 5.00 12.18 9.85 0.72 0.22 0.00 12.19 1.047	240 240 78 78 644 16.43 580 78 73 30.3 3.50 16.07 16.07 73.30 500 16.07 76 8.31 10.47 823 500 16.97 72.30 72.30 0.22 0.00 0 72.30 72	247 78 463 18.72 711 FBH077 889 321.0 32.0 32.0 32.0 32.0 32.0 32.0 32.0 32	249 844 466 16.37 728 FBH076 589 589 17.2 3.800 10.31 247 584 500 10.41 13.90 10.41 13.90 0.25 844 560 10.41 13.90 0.25 85,00 10.41 13.97 72 72 72 72 72 72 72 72 72 72 72 72 72	244 82 487 79.002 78.007 825 825 4.82 3.16 3.19 9.82 822 731 16.77 16.77 9.82 822 731 16.77 16.77 16.77 9.82 9.98 9.98 9.98 9.98 9.98 9.98 9.98
FLUD BED MEATER FLE	T OFFGAS T COMP EX T COMP EX INCIN 502 INCIN 502 INCIN 502 INCIN 502 INCIN 502 INCIN 502 INCIN 502 INTURAL GAS AHTR AIR (M) T PLENUM T PLENUM OUT T PLENUM OUT T PLENUM OUT T PLENUM OUT T PLENUM OUT F BH NOX F BH DO D D D D D D D D D D D D D	TE - 346 TE - 347 TE - 200 AT - 02 - 6 AT - 02 - 6 AT - 02 - 6 FY - 46 FY - 46 FY - 30 SY - 30 TE - 376 TE - 376 TE - 376 TE - 376 TE - 376 PD T - 376 PD T - 376 PD T - 376 FY - 30 AT - 802 - 3 AT - 802 - 3 AT - 802 - 3 AT - 802 - 3 FY - 300 FY - 3106 FY - 346 TE - 343 FD T - 346	DEG F DEG F DEG F PERCENT PPM DEG F S/HR S/HR S/HR S/HR S/HR S/HR S/HR S/HR	244 611 445 445 445 446 18.74 447 748 448.1 3.860 16.89 791 447 741 500 17.34 19.53 10.20 0.00 0.00 0.00 0.00 51.64 0.16 550 0.25 550 10.20 11.20 11.20 12.44 0.16 11.20 1.	284 76 437 19.47 344 FBH072 744 4300 16.74 4300 740 740 740 740 740 750 740 750 740 750 740 750 740 740 750 740 750 740 750 740 750 740 740 740 740 740 740 740 740 740 74	2446 74 4466 5877 FBH078 FBH078 220.11 3.00 20.01 13944 7377 1057 500 12.18 9.86 9.86 9.86 9.73 7.1057 8.41 1.047 9.86 9.86 9.72 9.86 9.86 9.72 9.57 1006 9.57 11.006	240 240 78 78 78 78 78 78 78 75 73 73 73 73 73 74 74 74 74 74 74 74 74 74 74 74 74 74	247 78 463 18.72 771 FBH077 889 221.0 3.19 1235 865 860 500 13.64 8650 500 13.64 11.01 9.87 9.855 8650 500 13.64 9.70 3.300 70.37 7.0.37 7.0.49 9.0.28 8.50 9.0.29 13.69 14.59 14.59 14.59 14.59 14.59 14.59 14.59 14.59 14.59 14.59 14.59 14.59 14.59 14.59 14.59 14.59	249 844 466 16.37 728 FBH076 589 5.600 17.2 3.200 16.37 16.37 16.37 16.37 16.37 16.37 13.90 13.90 0.28 5.60 0.041 19.20 0.41 19.20 0.41 19.20 0.45 19.20 10	244 82 487 200 FBH079 825 48.6 3.18 3.18 3.18 3.18 3.18 3.18 3.18 3.18
FLUID BED MEATER FLE	T OFFGAS T COMPEX T COMPEX T COMPEX T COMPEX T COMPEX T COMPEX T COMPEX T COMPEX T T COMPEX T T COMPEX T T COMPEX T T COMPEX T CO	TE - 3467 TE - 347 TE - 200 AT - 002 - 6 AT - 002 - 6 AT - 002 - 6 FY - 66 FY - 66 FY - 30 SY - 30 AT - 02 - 3 TE - 376 TE - 376 TE - 376 TE - 376 TE - 377 TE - 376 PDT - 377 PDT - 377 PDT - 377 PDT - 376 PDT - 377 AT - N02 - 3 AT - N02 - 3 FY - 300 FY - 300 FY - 340 FY - 340 FY - 346 PDT - 345 PDT - 345	DEG F DEG F DEG F PERCENT PPM DEG F PPM DEG F FT/3EC FT/3EC DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F SCFM SCFM SCFM SCFM SCFM SCFM SCFM SCF	244 611 445 445 445 445 445 445 746 447 746 467 741 500 17.34 16.59 10.20 0.00 91.64 0.16 0.28 FBC071 3.31 205.15 807 1.35 1.3	284 76 437 19.47 344 FBH072 744 430 300 344.1 3.00 344.1 3.00 740 650 550 550 550 550 550 550 550 550 55	2446 74 4466 19.36 587 758H078 758H078 280.1 3.00 20.01 13944 7394 7394 7394 7394 7394 7394 7394	240 240 78 78 78 78 78 78 78 78 73 30.3 3.50 16.01 73 8.31 746 746 746 746 746 746 746 746 746 746	247 78 463 16.72 78 16.72 711 75 859 321.0 3.19 1233 657 856 850 850 850 850 850 850 850 9.3 845 850 9.3 845 1.0 1.0 1.0 1.0 1.0 1.0 1.0 1.0 1.0 1.0	249 844 456 16.37 728 FBH076 589 5.500 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 19.41 9.44 9.44 9.45 9.45 9.45 9.45 9.45 9.45	244 82 487 19.02 200 FBH079 825 48.6 349.6
FLUID BED HEATER FLE	T OFFGAS T COMP EX T SORB(12) T SO	TE - 346 TE - 347 TE - 200 AT-002-6 AT-002-6 FY-66 FY-30 SY-30 AT-02-3 TE - 372 TE - 372 TE - 376 TE - 376 TE - 376 PT - 376 PT - 376 PT - 376 FY - 30 FY - 30	DEG F DEG F DEG F PERCENT PPM PPM PPM FT/SEC DEG F PERCENT PF/SEC DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F H30 FT/SEC F	244 811 446 177 748 478 478 478 478 478 478 4	264 76 76 76 76 74 74 74 74 74 74 74 74 74 74 74 74 74	2446 74 4466 19.36 587 75BH078 75BH078 5860 20.01 13844 7384 7384 7384 7384 7384 7384 7384	240 240 78 78 78 78 78 78 78 78 78 78 73 70 73 70 70 70 70 70 70 70 70 70 70 70 70 70	247 78 443 18.72 711 FBH077 FBH077 FBH077 959 590 321.0 3.21.0 3.21.0 3.21.0 9.321.0 3.21.0 9.324 9.50 500 13.84 11.01 9.97 0.49 0.00 13.64 11.01 9.97 0.49 5.00 13.64 10.00 13.64 1.07 13.64 1.07 13.64 1.07 13.64 1.07 13.65 1.00 13.64 1.07 1.00 13.64 1.07 1.00 1.00 1.00 1.00 1.00 1.00 1.00	249 844 466 1877 728 FBH078 569 317.2 3.900 116.37 1237 648 5500 0.317.2 3.900 116.41 9.42 9.82 9.82 0.28 6.63 0.28 6.63 0.28 9.20 9.20 0.28 9.22 0.28 0.35 0.0 11.44 6.64 7 1.92 1.146 6.64 7 1.92 1.146 6.64 7 1.92 1.146 6.64 7 1.92 1.146 6.64 7 1.92 1.92 1.92 1.92 1.92 1.92 1.92 1.92	244 82 487 78075 78075 78075 826 3386 3386 3386 3386 3386 3386 7840 7840 7840 7840 7840 7840 7840 7840
FLUID BED HEATER FLE	T OFFGAS T COMP EX T COMP EX T COMP EX INCEN 502 INCEN 502 INCEN 502 INCEN 502 INCEN 502 INCEN 502 FBH 02 FBH 02 FBH 02 T PLENUM T PLENUM T PLENUM OUT FBH PRES BED 0P PLENUM OUT FBH NOX FBH NOX FBH NOX FBH NOX FBH NOX FBH NOX FBC AIR VEL AIR (M T PLENUM T P	TE - 3467 TE - 3467 TE - 200 AT-002-6 AT-002-6 AT-002-6 TE - 373 FY-66 FY-30 SY-30 AT-02-3 TE - 370 TE - 370 FY-30 AT-02-3 FY-30 AT-02-3 FY-30 AT-02-3 FY-30 AT-02-3 FY-30 FY-	DEG F DEG F DEG F PERCENT PPM PPM PPM PPM F7/SEC DEG F DEG F	244 811 446 314 7504021 748 4.78 4.78 4.78 4.78 4.78 748 748 748 748 748 748 748 7	284 76 76 75 74 74 74 74 74 74 74 74 74 74 74 74 74	246 76 468 847 76 847 76 847 78 76 840 1 340 2000 2000 2000 2000 2000 2000 2000	249 79 79 454 18.43 596 70 1051 1051 1051 1051 1051 1051 1051 1	247 768 768 769 769 769 760 70 321.0 32.0 32.0 32.0 32.0 32.0 32.0 32.0 32	249 844 466 1877 728 FBH078 640 317.2 3.20 317.2 3.20 317.2 3.20 317.2 3.20 317.2 3.20 317.2 3.20 317.2 3.20 317.2 3.20 317.2 3.20 3.20 3.20 3.20 3.20 3.20 3.20 3.	244 82 947 950 200 200 200 200 200 200 200 200 200 2
FLUID BED MEATER FLE	T OFFGAS T COMP EX T COMP EX T COMP EX INCEN 502 INCEN 502 INCEN 502 INCEN 502 T SORB(12) NATURAL GAS AMTR AR 60 FBH VEL FBH 202 TAHTR OUT T PLENUM T PLENUM T PLENUM T PLENUM OUT FBH 802 AR 60 FBC AR VEL AR 60 FEC PRES PLENUM T LOWER T LOWER	TE - 3447 TE - 347 TE - 200 AT-002-6 AT-002-6 FY-64 FY-30 SY-30 TE - 373 TE - 373 TE - 373 TE - 376 TE - 377 TE - 377 TE - 377 TE - 377 PDT-376 PDT-376 PDT-376 PDT-376 FY-3000 FY-3106 SY-340 FY-340 FY-340 FY-346 FY-346 FY-346 FT - 346 TE - 341 TE - 340 FT - 340 FT - 340 FT - 340	DEG F DEG F DEG F PEACENT DEG F PPM DEG F PPM F7/3EC DEG F DEG F D	244 611 445 10,74 445 10,74 445 10,74 4,78 4,	284 76 76 76 74 74 74 74 74 74 74 74 74 74 74 74 74	2446 74 4468 19.345 5847 75BH078 75BH078 75BH078 280.1 1.340 20.01 1.344 737 70 20.01 1.344 737 70 1.1344 737 70 1.134 8.85 8.87 9.85 8.97 1.04 1.37 2.61 3.00 179.7 7.1 1.60 1.21 8.85 8.87 1.39 0.02 1.21 8.85 8.85 8.85 8.85 8.85 8.85 8.85 8.8	249 249 79 79 454 16.43 596 79 79 16.43 70 16.43 73 3.50 76 72 3.50 76 72 6 72 6 72 6 72 6 72 8 76 72 8 76 72 8 76 76 76 76 76 76 76 76 76 76 76 76 76	247 78 78 78 78 78 78 78 78 78 78 78 78 78	249 844 466 1837 728 5600 317.2 3.200 317.2 3.200 18.37 1837 1837 1837 1837 1837 1837 1837 18	244 82 487 7897 828 828 482 348.6 348.6 18.77 982 731 7842 731 731 731 731 731 731 731 731 731 731
FLUID BED MEATER FLE	T OFFGAS T COMB EX T SORB(12) T SOR	TE - 346 TE - 347 TE - 200 AT-002-6 AT-002-6 TE - 373 FY-64 FY-30 SY-30 TE - 376 PT - 378 PT - 378 PDT - 376 PDT - 376 PDT - 376 PDT - 376 FY - 30 SY - 30 FY - 30 FY - 30 SY - 30 FY - 30 F	DEG F DEG F DEG F PEACENT DEG F PPM DEG F PPM SANR FT/SEC PEACENT DEG F DEG F PPM SCTM SCTM SCTM SCTM SCTM SCTM SCTM SCT	244 611 445 10.74 445 10.74 445 10.74 445 10.74 447 746 4.79 746 10.74 407 746 10.74 407 746 10.74 407 746 10.74 407 746 11.95 000 00.00 00.00 91.64 407 7.36 11.95 807 12.84 407 11.95 807 12.84 407 11.85 807 12.84 407 12.84 407 12.84 407 12.84 407 12.84 407 12.84 407 12.84 407 12.84 407 12.84 40.15 807 12.84 40.25 807 12.84 40.25 807 12.84 40.25 807 12.84 40.25 807 12.84 40.25 807 12.84 12.85 808 10.25 808 10.25 808 10.25 808 10.25 808 10.25 808 10.25 808 10.25 808 10.25 808 10.25 808 10.25 808 10.25	284 76 76 74 78 74 74 74 74 74 74 74 74 74 74 74 74 74	2446 74 4466 19.345 5847 755H078 755H078 1942 280.1 3.900 20.01 1944 737 757 1057 841 541 541 541 541 541 541 541 541 541 5	249 249 79 79 464 18.43 59 70 70 70 73 33.50 76 74 74 74 74 74 74 74 74 74 74 74 74 74	247 768 768 769 769 769 760 771 760 771 771 771 771 771 771 70 70 70 70 70 70 70 70 70 70 70 70 70	249 84 466 18.37 726 58H076 58H076 5840 317.2 3.200 18.37 1237 5840 500 13.50 14.50	244 82 487 789 789 789 789 789 780 780 780 780 780 780 780 780 780 780
FLUID BED MEATER FLE	T OFFGAS T COMB EX T SORB(12) T SOR	TE - 346 TE - 347 TE - 200 AT-002-6 AT-002-6 AT-002-6 TE - 373 FY-64 FY-30 SY-30 TE - 376 PDT-376 PDT-377 TE - 3778 PDT-377 FY-30 FY-	DEG F DEG F DEG F PERCENT DEG F PPM DEG F PPM FYSEC DEG F DEG F DE	244 611 445 10.74 445 10.74 445 10.74 445 10.74 447 746 478 10.74 478 10.74 497 741 497 11.45 10.30 17.36 12.44 11.45 10.30 0.00 91.64 11.45 12.44 11.45 12.44 11.45 12.44 11.45 12.45 1	284 76 76 437 78 437 74 430 74 430 74 430 74 430 74 430 74 430 74 74 430 74 74 430 74 74 74 430 74 74 74 74 74 74 74 74 74 74 74 74 74	2446 74 74 74 76 75 75 75 75 75 75 75 75 75 75 75 75 75	240 240 240 79 79 79 79 79 70 70 70 70 70 70 70 70 70 70 70 70 70	247 768 768 769 769 760 771 771 771 771 771 771 771 771 771 77	249 844 646 782 728 7840 728 7840 728 7840 728 7840 728 7840 728 7840 7840 7840 7840 7840 7840 7840 784	244 82 487 784078 784078 784078 828 4828 4828 4828 7848 600 16,11 7,72 9822 731 7642 731 731 731 731 731 731 731 731 731 731
	Т ОГРГААS Т СОЛРО ЕХ Т СОЛРО ССА Т СОЛРО ССА Т СОЛРО ССА Т С С С С С Т С С С С С Т С С С С С Т С С Т С С С Т С С С Т С С С С Т С С С С Т С С С Т С С С С С С Т С С С С С С Т С С С С С Т С С С С С Т С С С С С С С С С Т	TE - 3467 TE - 347 TE - 200 AT- 602-8 AT- 602-8 FY - 64 FY - 30 SY - 30 TE - 373 TE - 373 TE - 373 TE - 374 TE - 378 PD - 374 TE - 378 PD - 374 PD - 377 TE - 378 PD - 377 TE - 378 PD - 377 AT - NOX - 3 FY - 30 FY -	DEG.F DEG.F DEG.F DEG.F DEG.F PFM DEG.F SAR SAR SAR PACENT Trace DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F SCFM SCFM SCFM SCFM SCFM DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F PS40 PPM PPM	244 811 445 10.74 445 10.74 445 10.74 445 478 418.1 3.500 16.89 7.81 497 7.61 497 7.61 10.30 17.36 497 7.61 10.30 0.00 91.64 11.85 12.84 11.85 12.85	284 76 76 437 78 437 74 430 74 430 841 74 430 74 430 74 74 430 74 74 74 74 74 74 74 74 74 74 74 74 74	2446 74 74 74 76 75 75 75 75 75 75 75 75 75 75 75 75 75	240 240 79 79 79 79 79 79 70 70 70 70 70 70 70 70 70 70 70 70 70	247 768 4643 16.72 7711 FBH077 859 550 321.0 321.0 321.0 321.0 321.0 550 560 70 13.64 11233 657 650 70.37 18.43 0.00 70.37 70.37 70.37 18.43 0.00 70.37 71.0 71.0 71.0 72 3.00 70.37 7.0 9.28 9.28 9.28 9.28 9.29 9.23 9.28 9.29 9.23 9.29 9.20 9.20 9.20 9.20 9.20 9.20 9.20	249 844 646 76277 728 758H078 849 849 849 849 849 849 849 849 849 84	244 82 487 784078 784078 828 4825 318 4825 318 4825 318 4825 318 4825 318 4825 318 4825 318 4825 318 4825 318 4825 318 4825 318 50 50 50 50 50 50 50 50 50 50 50 50 50
	Т ОГРГААS Т СОЛРО ЕХ Т СОЛРО С Т СОЛРО С Т СОЛРО С Т С С С С Т С С С Т С С С С Т С С С Т С С С Т С С С С С Т С С С Т С С С С Т С С С Т С С С С С Т С С С С Т С С С С С Т С С С С С Т С С С С Т С С С С С Т	TE - 346 TE - 347 TE - 200 AT-02-6 AT-02-6 AT-02-6 FY-64 FY-30 SY-30 TE - 373 TE - 373 TE - 376 PD - 376 PD - 376 PD - 376 PD - 377 FY - 30 SY - 30 FY - 340 FY	DEG F DEG F DEG F PERCENT DEG F PPM PPM F773EC PERCENT DEG F DEG F	244 811 445 19,746 445 445 445 445 445 445 447 450 10,26 10,26 11,55 497 741 497 741 497 741 45,0 90 90 91,84 90 91,84 91,246 11,55 90,255 91,847 91,947 91,94	284 70 437 18.67 344 FBH072 774 4.30 18.74 4.30 18.74 4.50 18.74 450 500 13.44 12.79 8.00 13.44 12.79 8.00 13.44 12.79 8.00 78.06 0.32 0.33 0.00 78.06 9.73 0.33 0.00 78.06 9.73 0.33 0.00 78.06 9.73 9.74 9.740 8.800 7.806 9.740 7.4000 7.400 7.4000 7.400 7.400 7.4000 7.4000 7.4000 7.4000 7.4000 7.400	2446 74 74 74 76 75 75 75 75 75 75 75 75 75 75 75 75 75	246 246 246 79 79 79 79 79 79 70 70 70 70 70 70 70 70 74 823 800 16.01 746 746 746 746 746 746 746 746 746 746	247 768 4643 16.72 7711 FBH077 859 331.0 3319 16.81 17.85 16.81 17.85 16.81 17.85 16.81 17.85 16.81 17.85 16.81 17.85 16.81 17.85 16.81 17.85 16.81 17.85 16.81 17.85 16.81 17.85 16.81 17.85 16.81 17.85 16.81 17.85 16.85 17.85 16.85 17.95 17.85 17	249 844 846 846 847 728 FBH078 849 840 840 840 840 840 840 840 840	244 82 487 (19.22 208 7BH078 625 3.18 3.18 16.77 682 92 22 22 23 48.6 3.18 16.77 78 2 22 22 22 23 17 31 78 22 22 22 22 23 23 731 78 49 60 22 731 731 731 731 731 731 731 731 731 731
	Т ОГРГААS Т СОЛРВЕХ Т СОЛРВЕХ Т СОЛРВЕХ Т СОЛРВЕХ Т СОЛРВЕХ Т СОЛРВЕЗ Т СОЛРВЕЗ С СОЛВ АЛЯ Т С С СОЛВ АЛЯ Т С С С С С С С С С С С С С С С С С С С	TE - 3467 TE - 347 TE - 200 AT-02-6 AT-02-6 AT-02-6 AT-02-8 TE - 373 FY-64 FY-30 SY-30 TE - 376 PT - 376 PT - 376 PT - 376 PT - 377 TE - 376 PT - 340 FY - 340 FY - 340 FT - 340	DEG.F DEG.F DEG.F DEG.F DEG.F PPM PPM PPM DEG.F PEG.ENT DEG.F PEG.ENT DEG.F PEG.ENT DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F SCFM SCFM SCFM DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F DEG.F	244 811 445 19,74 445 19,74 445 445 445 478 478 478 478 478 478 497 741 497 741 497 741 497 741 497 741 497 745 497 745 497 745 497 745 497 745 497 745 497 745 497 745 497 745 497 745 497 745 745 745 745 745 745 745 74	284 70 437 18.67 344 FBH072 774 4.30 18.74 4.30 18.74 4.50 18.74 4.50 18.74 4.50 18.74 4.50 18.74 4.50 19.45	2446 2446 74 4466 847 75BH078 75BH078 75BH078 75BH078 737 1052 841 3.00 920.01 737 1057 841 1.04 737 737 1057 841 1.057 841 1.057 8.77 1.057 8.77 1.057 8.77 1.057 8.777 1.057 8.777 1.057 8.777 1.057 8.777 1.057 8.777 1.057 8.7777 8.7777 8.7777 8.7777 8.7777 8.7777 8.7777 8.7777 8.7777 8.7777 8.7777 8.7777 8.7777 8.7777 8.77777 8.77777 8.77777 8.777777 8.77777777	246 246 78 78 78 78 78 78 78 78 78 73 30,3 3,50 9 16,01 13,45 74 8 23 8 50 16,07 74 8 23 8 50 16,07 74 8 23 8 50 16,07 8 23 8 50 9 16,07 8 23 8 50 9 16,07 8 23 8 50 9 16,07 8 23 8 50 9 16,07 8 23 8 50 9 16,07 8 23 8 50 9 16,07 8 23 8 50 9 16,07 8 23 8 50 9 16,07 8 23 8 50 9 16,07 8 23 8 50 9 16,07 8 23 8 50 9 16,07 8 22,07 8 22,07 8 22,07 8 22,07 8 22,07 8 22,07 8 22,07 8 22,07 8 22,07 8 20,0 8 50 9 50 9 50 9 50 9 50 9 50 9 50 9 5	247 768 768 768 771 771 788 771 788 771 788 771 788 771 788 771 788 788	249 844 846 10.37 728 FBH078 FBH078 840 5.600 11.300 10.41 9.62 13.200 10.41 9.62 13.200 13.300 13.20	244 82 487 (19.2 208 7BH078 625 4.62 348.6 3.18 4.62 731 762 762 731 762 762 762 762 762 762 762 762 762 762
	T OFFGAS T COMP EX T T COMP EX T C COMP EX T C C C C C C C C C C C C C C C C C C C	TE - 346 TE - 347 TE - 200 AT-02-6 AT-02-6 AT-02-6 AT-02-6 TE - 373 FY - 44 FY - 44 FY - 30 SY - 30 AT-02-3 TE - 376 TE - 376 PDT-376 PDT-377 PT - 376 PDT-377 AT-N0x-3 FY - 30 FY -	DEG.F DEG.F DEG.F DEG.F DEG.F PPM PERCENT PPM DEG.F F175EC JOEG.F DEG.F DEG.F PSM DEG.F PSM DEG.F PSM DEG.F PSM DEG.F DEG.F	244 811 445 445 446 19,74 446 19,74 447 447 447 447 447 447 447	284 76 76 78 78 78 78 78 78 78 78 78 78 78 78 78	2446 2446 74 4466 847 75BH078 75BH078 75BH078 75BH078 790 20.01 13940 730 70 20.01 1396 737 1067 841 1 8.871 1.04 737 737 641.36 0.22 0.300 12.118 9.85 8.71 1.04 1.36 0.22 0.300 757 71 1.005 75 3.000 757 71 1.005 75 75 75 75 75 75 75 75 75 75 75 75 75	240 240 79 79 79 79 79 70 70 70 70 70 70 70 70 70 70 70 70 70	247 763 763 763 764 763 764 764 764 764 764 775 765 765 765 765 765 765 765 765 765	249 844 846 16.37 7220 FBH076 849 840 13.300 15.37 15.3	244 82 487 1902 2009 FBH078 825 4825 348.6 3.18 16.77 982 92 2348.6 3.18 16.77 982 92 2348.6 3.18 16.77 982 92 232 12.28 0.94 76.83 0.94 76.83 0.16 1.95 76.83 0.94 76.83 0.94 76.83 0.16 1.95 76.83 0.16 1.95 76.83 0.16 1.95 76.83 0.94 3.00 1.95 1.95 76 3.00 1.95 1.95 76 3.00 1.95 1.95 76 3.00 75 76 3.00 75 76 75 75 75 75 75 75 75 75 75 75 75 75 75
	T OFFGAS T COMP EX T COMP EX T COMP EX T THC EX INCEN 502 INCEN 502 INCEN 502 INCEN 502 INCEN 502 INCEN 502 FBH 02 FBH 02 T PH 02 FBH 02 FBH PH 0	TE - 3447 TE - 347 TE - 200 AT - 002 - 6 AT - 002 - 6 SY - 30 SY - 30 AT - 02 - 3 TE - 376 TE - 377 TE - 376 PDT - 377 PDT - 377 PT - 340 FY - 340 FY - 340 FY - 340 FT - 346 FT - 35	DEG.F DEG.F DEG.F DEG.F DEG.F PPM DFM PPM DEG.F PT/3EC FT/3EC PT/3EC DEG.F PERCENT DEG.F DEG.F	244 811 446 817 748 478 478 478 478 478 478 47	284 76 76 76 76 76 76 76 76 76 76 76 76 76	2446 2446 74 4466 847 7 FBH078 7 FBH078 7 841 3.00 20.01 1384 7 37 1057 841 3.00 7 3.00 7 2.118 8.85 8.71 1.047 3.72 6 1.34 4 3.72 1.057 8.91 1.056 8.91 1.057 8.91 1.0566 8.91 1.0566 8.91 1.0566 8.91 1.0566 8.91 1.0566 8.91 1.0566 8.91 1.0566 8.91 1.0566 1.0566 1.0566 1.0566 1.0566 1.0566 1.0566 1.0566 1.0566 1.0566 1.0566 1.056	240 240 79 79 79 79 79 79 70 70 70 70 70 70 70 70 70 70 70 70 70	247 247 76 463 16.72 771 78 5.90 121.0 31.9 5.90 13.54 5.90	249 844 844 984 989 989 989 989 989 989 9	244 82 487 19.02 750075 200 200 200 200 200 200 200 200 200 20
FLUID BED HEATER FLE	T OFFGAS T COMB EX T COMB EX T COMB EX T COMB EX T COMB EX T COMB EX T COMB AR T T COMB AR T T OC FGAS T T OFFGAS T	TE - 3467 TE - 347 TE - 200 AT-002-6 AT-002-6 AT-002-6 AT-002-6 AT-02-6 AT-02-6 AT-02-8 TE - 372 TE - 373 TE - 374 TE - 374 TE - 374 TE - 374 TE - 376 PT - 376 PT - 377 PT - 376 PT - 377 PT - 376 PT - 377 AT-M0X-3 AT-M0X-3 AT-M0X-3 AT-M0X-3 AT-M0X-3 AT-M0X-3 FY - 340 FY - 340 FY - 340 FY - 340 FY - 340 FY - 340 FT - 346 TE - 347 TE - 346 TE -	DEG F DEG F DEG F PERCENT PPM PPM PPM PPM PPM PPM PPM SCFM SCFM SCFM SCFM SCFM SCFM SCFM SCF	244 811 446 917 748 478 478 478 478 478 478 47	284 76 76 75 74 74 74 74 74 74 74 74 74 74 74 74 74	246 76 76 76 887 76 887 76 887 76 886 280.1 3.90 20.01 1.944 737 70 20.01 1.944 737 70 97 8.86 8.86 8.77 1.047 1.372 8.85 8.85 8.77 1.00 7.00 7.00 7.00 7.00 7.00 7.00 7	249 79 79 644 16.43 596 70 1661 1345 746 746 746 746 746 746 746 746 746 746	247 247 247 248 247 248 248 248 249 249 249 249 249 249 249 249	249 844 844 845 848 849 849 849 849 849 849 849 849 849	244 82 647 76075 77075 7
FLUID BED HEATER FLE	T OFFGAS T COMB EX T COMB AR T T OC REAL T SO RE(12) T SO RE(12) T SO RE(12) T SO RE(12) T SO RE(12) T SO RE(12) T SO RE(12) F SO AS T SO RE(12) T SO RE(12) F SO AS T SO RE(12) T SO RE(12) F SO AS T SO RE(12) T SO RE(12	TE - 3467 TE - 3467 TE - 200 AT-002-6 AT-002-6 AT-002-6 AT-002-8 TE - 373 FY-66 FY-30 SY-30 TE - 377 TE - 378 PT - 378 FY - 30 FY - 346 FY - 346 FT - 347 FT - 347 FT - 346 FT - 347 FT - 347 FT - 346 FT - 347 FT - 347 FT - 347 FT - 34	DEG F DEG F DEG F PERCENT PPM PPM PPM PPM PPM PPM PPM PPM PPM PP	244 811 446 917 748 478 418.1 314 758 4.73 4.73 4.73 4.73 4.73 741 500 701 1.64 1.65 701 1.65 1.65 701 1.65 701 1.65 705 705 705 705 705 705 705 70	284 76 76 76 74 74 74 74 74 74 74 74 74 74 74 74 74	244 74 74 74 74 75 75 75 75 75 75 75 75 75 75 75 75 75	249 79 79 4644 18.43 596 70 79 1051 1345 746 746 746 746 746 746 746 746 746 746	247 247 247 247 247 247 247 247	249 844 844 845 18.77 728 560 317.2 3.20 3.20 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.30 19.41 9.42 9.50 9.50 9.50 9.50 9.50 19.41 9.42 9.50 9.50 9.50 9.50 9.50 9.50 9.50 9.50	244 82 487 788 788 788 788 788 788 788 788 788
FLUID BED MEATER FLE	T OFFGAS T COMB EX T COMB EX T COMB EX T COMB EX T COMB EX T COMB EX T COMB AR T COMB AR T COMB AR T SORB(12) T SOR	TE - 3447 TE - 347 TE - 200 AT-002-6 AT-002-6 AT-002-6 TE - 373 FY-64 FY-30 SY-30 TE - 373 TE - 376 PDT-377 PDT-377 PDT-377 PDT-377 PDT-377 FY-30 SY-30 FY-3	DEG F DEG F DEG F PEACENT DEG F PPM PPM F775EC DEG F DEG F D	244 611 445 10.74 10.74 445 10.74 4.79 4.79 10.74 4.79 10.74 4.79 745 10.74 10.75 10	284 76 76 76 74 74 74 74 74 74 74 74 74 74 74 74 74	2446 2446 74 448 19.34 5497 750-078 750-078 200.01 1934 200.01 1934 200.01 1934 200.01 1934 200.01 1934 200.01 1934 200.01 1934 200.01 1934 200.01 1937 200.00 1937 200.01 19377 200.01 19377 200.01 1	249 249 79 79 79 79 79 79 79 79 79 79 79 79 79	247 247 247 247 248 247 248 249 2410 2210 2210 2210 2210 2210 2210 2210 2210 2210 2210 2210 2017 20	249 844 846 18.37 728 58H076 58H076 58H076 5840 317.2 3.300 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.37 18.30 19.42 19.42 19.42 19.42 19.42 19.42 19.42 19.44	244 82 487 1922 2016 2016 2016 2016 2016 2016 2016 20
FLUID BED MEATER FLE	T OFFGAS T COFFGAS T COMB EX T COMB EX T THC EX INCEN 502 INCEN 502 INCEN 502 INCEN 502 INCEN 502 TSORB(12) NATURAL GAS AMTR AIR 60 FBH VEL FBH 202 TAHTR OUT T PLENUM TO REGA T OLENUM OUT FBH PRES DED 0P PLENUM OUT FBH 802 AHTR AIR (M PEN 602 FBH 802 AHTR AIR (M PEN 602 FBH 802 AHTR AIR (M FBH 802 FBH 802 FBC AIR VEL AIR 60 T PLENUM T LOWER T LOWER T LOWER T LOWER T COPEN T COPEN T COPEN T COPEN T COPEN T COMB ART CO AIR HTR T MOTART T FUR RER T FUR ARER T FUR ARER T SCANS FGAS T HUM EXT T SCANS FGAS T ARS 72 T	TE - 3467 TE - 347 TE - 200 AT-002-6 AT-002-6 AT-002-6 TE - 373 FY-64 FY-30 SY-30 TE - 373 TE - 376 PT - 376 PT - 376 PT - 376 PT - 377 PT - 376 PT - 376 FY - 300 FY - 3000 FY - 300 FY - 30	DEG F DEG F DEG F PERCENT DEG F PPM DEG F PPM F775EC DEG F DEG F D	244 611 445 10,74 446 11,74 447 10,74 449 11,74 449 11,95 10,95 11,35 10,30 11,35 1,	284 76 76 76 74 78 74 78 74 74 74 74 74 74 74 74 75 76 76 76 76 76 76 76 76 76 76 76 76 76	2446 2446 74 448 19.34 5847 755H078 755H078 755H078 750 20.01 1944 2840 13.300 20.01 1944 737 737 737 737 737 737 737 1941 8.841 8.845 8.871 1.344 9.845 8.871 1.345 9.857 8.300 9.050 75078 750 75078 711.60 9.857 9.300 9.057 9.057 9.300 9.057 9.300 9.057 9.300 9.057 9.300 9.057 9.300 9.057 9.300 9.057 9.300 9.057 9.300 9.057 9.000 9.057 9.000 9.057 9.000 9.057 9.000 9.000 9.000 9.000 9.000 9.000 9.000 9.000 9.000 9.000 9.000 9.000 9.000 9.007 9.0000 9.0000 9.0000 9.0000 9.0000 9.0000 9.0000 9.0000 9.0000 9.0000 9.0000 9.0000 9.0000 9.0000 9.00000 9.00000 9.00000 9.000000 9.00000000	240 240 240 240 240 240 240 240 240 240	247 247 247 248 443 16.72 711 FBH077 859 550 221.0 32.0 32.0	249 844 646 78.77 728 780 780 780 780 780 780 780 780 780 78	244 82 487 789 208 208 208 208 208 208 208 208 208 208
	T OFFGAS T OFFGAS T COMB EX T TONC EX INCEN 502 INCEN 502 INCEN 502 TSORB(12) NATURAL GAS ANT RAIF GO FBH VEL FBH 02 TANTR OUT T PLENUM TO PASCAP DEC OP PLENUM OUT FBH PRES DEC OP PLENUM OUT FBH PRES DEC OP PLENUM OUT FBH PRES ART GAS (M) REG NGAS (M) FBC PRES ART OF DEC OF FBC PRES ART OF T LOWER DEC OF FBC PRES ART OF T LENUM T LOWER DEC OF FBC PRES ART OF T LENUM COMB ART T CO AR HTR T MOT AR T FUR REFT T FUR REFT T FUR REFT T SGMS 50 T ABS 22 T ABS 22 T	TE - 346 TE - 347 TE - 347 TE - 200 AT-002-6 AT-002-6 AT-02-6 FY-64 FY-30 SY-30 TE - 373 FY-64 FY-30 SY-30 TE - 376 PDT-376 PDT-377 PDT-377 PDT-377 FY-30 FY-300 FT-300	DEG F DEG F DEG F PERCENT DEG F PPM DEG F PPM F775EC DEG F DEG F D	244 811 445 10.74 314 FBH071 FBH	284 76 76 78 74 78 74 78 74 74 74 74 74 74 74 74 74 74 74 74 74	2446 2446 74 448 19.34 28.58 28.0.1 3.900 20.01 19.44 3.45 3.900 20.01 19.44 3.45 3.900 10.14 10.44 3.72 9.84 3.000 12.18 9.85 3.000 12.18 9.57 1.004 3.72 2.25 9.57 1.004 3.72 3.000 1.21.8 9.57 1.004 3.72 3.000 1.21.8 9.57 1.004 3.72 3.000 1.21.8 9.57 1.100 9.57 7.77 1.100 9.57 1.000 9.57 1.000 9.57 1.000 9.57 1.000 9.57 1.000 9.57 1.000 9.57 1.000 9.57 1.000 9.57 1.000 9.57 1.000 9.57 1.0000 9.57 1.0000 9.57 1.0000 9.57 1.0000 9.57 1.00000 9.57 1.000000000000000000000000000000000000	240 240 240 79 79 79 79 79 79 70 70 70 70 70 70 70 70 70 70 70 70 70	247 768 768 769 769 760 771 771 771 771 771 771 771 771 771 77	249 844 846 1837 728 7840 5840 317.2 3.900 18.37 1837 1837 1837 1837 1837 1837 1837 18	244 82 487 787 828 828 828 828 828 828 828 828 8
	T OFFGAS T OFFGAS T COMB EX T TONC EX INCEN 502 INCEN 502 INCEN 502 TSORB(12) NATURAL GAS ANTR AIR 60 FBH VEL FBH 02 TAHTR OUT T PLENUM TO PRESS DEC OF PLENUM OUT FBH PRES DEC OF PLENUM OUT FBH PRES DEC OF FBH NOX FBH NOX FBH 602 ARTR AIR (M FBH 802 FBH NOX FBH 802 ARTR AIR (M FBC PRES AIR PRES AIR PRES AIR PRES AIR FRES AIR OF NLET NOX(ADA OUTLET 502(ADA) NLET NOX(ADA) AIR (M COMB AIR T FUR RER T FUR RER T FUR RER T FUR RER T SCHS TOP T SCHS T SCHS TOP T SCHS T	TE - 346 TE - 347 TE - 200 AT-02-6 AT-02-6 AT-02-6 AT-02-7 FY-64 FY-30 SY-30 TE - 373 TE - 373 TE - 373 TE - 376 PDT-376 PDT-377 PDT-377 FY-30 FT-347 FY-30 FT-346 FT-347 FT-346 FT-346 FT-346 FT-347 FT-346 FT-346 FT-346 FT-347 FT-346 FT-347 FT-346 FT-347 FT-	DEG.F DEG.F DEG.F DEG.F PFM DEG.F DEG.F <td>244 811 445 10.74 314 445 314 445 314 445 314 445 478 445 13.840 16.89 781 12.84 11.85 12.84 11.85 12.84 11.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 11.7 11.7 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 11.7 11.7 12.85 12.85 12.85 12.85 12.85 12.85 11.7 11.7 12.85 12.85 12.85 12.85 11.7 11.7 11.7 11.7 12.85 12.85 12.85 12.85 11.7 11.7 11.7 12.85 12.85 12.85 11.7 11.7 11.7 12.85 12.85 12.85 12.85 11.7 11.7 11.7 11.7 12.85 12.85 12.85 12.85 11.7 11.7 11.7 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.7 11.7 11.7 11.7 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.7 12.85 12.7 12.85 12.85 12.7 12.85 12.85 12.7 12.85 13.7 13.7 13.7 13.7 14.85 17.7 17.7 18.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 17.7 19.85 17.7 17.7 19.85 17.7 17.7 19.85 17.7 17.7 19.85 17.7 17.7 19.85 17.7 17.7 19.85 17.7</td> <td>284 70 73 437 746 746 746 746 746 746 746 746 746 74</td> <td>2446 2446 74 448 19.34 5847 75BH078 75BH078 75BH078 75BH078 75BH078 75BH078 75BH078 75BH078 75BH078 75BH078 737 737 737 737 737 737 737 738 737 738 737 738 738</td> <td>240 240 79 79 79 79 79 79 79 79 70 70 70 70 70 70 70 70 70 70 70 70 70</td> <td>247 768 768 769 769 760 760 760 760 760 760 760 760 760 760</td> <td>249 844 846 782 728 7840 728 7840 728 7840 840 840 840 840 840 840 840 840 840</td> <td>244 82 487 19 02 206 7 BH078 828 4 822 348.6 3.18 9 600 16.11 7.72 9.82 731 600 16.11 7.72 9.82 731 600 16.11 7.72 9.82 12.28 0.94 7.85 0.94 7.85 0.94 7.85 0.94 7.85 10.94 7.85 7.85 7.75 7.85 7.75 7.75 7.75 7.75</td>	244 811 445 10.74 314 445 314 445 314 445 314 445 478 445 13.840 16.89 781 12.84 11.85 12.84 11.85 12.84 11.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 11.7 11.7 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 11.7 11.7 12.85 12.85 12.85 12.85 12.85 12.85 11.7 11.7 12.85 12.85 12.85 12.85 11.7 11.7 11.7 11.7 12.85 12.85 12.85 12.85 11.7 11.7 11.7 12.85 12.85 12.85 11.7 11.7 11.7 12.85 12.85 12.85 12.85 11.7 11.7 11.7 11.7 12.85 12.85 12.85 12.85 11.7 11.7 11.7 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.7 11.7 11.7 11.7 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.85 12.7 12.85 12.7 12.85 12.85 12.7 12.85 12.85 12.7 12.85 13.7 13.7 13.7 13.7 14.85 17.7 17.7 18.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 19.85 17.7 17.7 19.85 17.7 17.7 19.85 17.7 17.7 19.85 17.7 17.7 19.85 17.7 17.7 19.85 17.7 17.7 19.85 17.7	284 70 73 437 746 746 746 746 746 746 746 746 746 74	2446 2446 74 448 19.34 5847 75BH078 75BH078 75BH078 75BH078 75BH078 75BH078 75BH078 75BH078 75BH078 75BH078 737 737 737 737 737 737 737 738 737 738 737 738 738	240 240 79 79 79 79 79 79 79 79 70 70 70 70 70 70 70 70 70 70 70 70 70	247 768 768 769 769 760 760 760 760 760 760 760 760 760 760	249 844 846 782 728 7840 728 7840 728 7840 840 840 840 840 840 840 840 840 840	244 82 487 19 02 206 7 BH078 828 4 822 348.6 3.18 9 600 16.11 7.72 9.82 731 600 16.11 7.72 9.82 731 600 16.11 7.72 9.82 12.28 0.94 7.85 0.94 7.85 0.94 7.85 0.94 7.85 10.94 7.85 7.85 7.75 7.85 7.75 7.75 7.75 7.75
FLUID BED MEATER FLE	T OFFGAS T OFFGAS T COMB EX T COMB EX T TONC EX INCEN 502 INCEN 502 INCEN 502 TSORB(12) NATURAL GAS ANTR AIR 60 FBH VEL FBH 02 TAHTR OUT T PLENUM TSORB(41) TON FBH 02 TAHTR OUT T PLENUM T DORB(41) T DO	TE - 346 TE - 347 TE - 200 AT-02-6 AT-02-6 AT-02-6 AT-02-7 FY-64 FY-30 SY-30 TE - 373 FY-64 FY-30 SY-30 TE - 376 PDT-377 PDT-377 FY-30 FY-30 FY-300 FT-30 FT-300	DEG.F DEG.F DEG.F DEG.F DEG.F PFM DEG.F DEG.F <td>244 811 445 18.74 19.745 445 19.745 445 445 445 19.745 478 40.15 10.50 17.345 497 761 11.85 10.30 91.844 9.75 11.85 12.85 11.7 11.7 11.7 12.85</td> <td>284 70 746 73 746 746 746 746 746 746 746 740 740 740 740 740 740 740 740 740 740</td> <td>2446 2446 74 448 19.34 29.35 29.01 3.000 20.01 3.000 12.118 9.85 8.71 1.047 3.727 9.841 1.04 3.727 9.841 1.04 3.727 9.841 1.04 3.727 9.841 1.04 3.727 9.841 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 17.85 17.75 9.85 3.000 17.85 17.75 9.85 3.000 17.85 17.75 9.85 3.000 17.85 17.75 9.85 3.000 17.85 17.75 7.75 9.85 3.000 17.85 7.75 9.85 3.000 17.85 7.75 9.85 3.000 17.85 7.75 9.85 3.000 17.85 7.75 9.85 7.75 9.85 7.75 9.85 7.75 7.75 7.75 7.75 7.75 7.75 7.75 7</td> <td>240 240 79 79 79 79 79 79 79 79 70 70 70 70 70 70 70 70 70 70 70 70 70</td> <td>247 247 768 4643 16.72 771 589 580 321.0 32.0 32</td> <td>249 84 84 84 86 85 86 86 86 86 86 86 86 86 86 86 86 86 86</td> <td>244 82 487 19 02 208 7 BH078 828 4 822 348.6 3.18 92 92 92 92 92 92 92 92 92 92 92 92 92</td>	244 811 445 18.74 19.745 445 19.745 445 445 445 19.745 478 40.15 10.50 17.345 497 761 11.85 10.30 91.844 9.75 11.85 12.85 11.7 11.7 11.7 12.85	284 70 746 73 746 746 746 746 746 746 746 740 740 740 740 740 740 740 740 740 740	2446 2446 74 448 19.34 29.35 29.01 3.000 20.01 3.000 12.118 9.85 8.71 1.047 3.727 9.841 1.04 3.727 9.841 1.04 3.727 9.841 1.04 3.727 9.841 1.04 3.727 9.841 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 12.118 9.85 3.000 17.85 17.75 9.85 3.000 17.85 17.75 9.85 3.000 17.85 17.75 9.85 3.000 17.85 17.75 9.85 3.000 17.85 17.75 7.75 9.85 3.000 17.85 7.75 9.85 3.000 17.85 7.75 9.85 3.000 17.85 7.75 9.85 3.000 17.85 7.75 9.85 7.75 9.85 7.75 9.85 7.75 7.75 7.75 7.75 7.75 7.75 7.75 7	240 240 79 79 79 79 79 79 79 79 70 70 70 70 70 70 70 70 70 70 70 70 70	247 247 768 4643 16.72 771 589 580 321.0 32.0 32	249 84 84 84 86 85 86 86 86 86 86 86 86 86 86 86 86 86 86	244 82 487 19 02 208 7 BH078 828 4 822 348.6 3.18 92 92 92 92 92 92 92 92 92 92 92 92 92
	T OFFGAS T COMP EX T COMP EX T COMP EX T THC EX INCEN 502 INCEN 502 INCEN 502 INTEN 502 INTEN 502 INTEN 60 FBH VEL FBH 02 T PH 02 FBH PASS BED DP PLENUM DP FBH PASS BED DP FBH PASS FBH 602 FBC AIR VEL AIR 04 T PLENUM DP FBC NGAS (M) FBC AIR VEL AIR 04 T PLENUM DP FBC PASS T PLENUM DP	TE - 3407 TE - 3407 TE - 200 AT - 002 - 6 AT - 002 - 6 FY - 30 SY - 30 AT - 02 - 3 TE - 376 TE - 377 TE - 376 PT - 377 PT - 376 PT - 377 PT - 376 PT - 377 PT - 376 PT - 377 PT - 376 FY - 300 FY - 340 FY - 340 FT - 345 FT - 345 FT - 346 TE - 1 TE - 27 TE - 30 TE - 36 FT - 360 FT -	DEG F DEG F DEG F PERCENT DEG F PFM DEG F FT/SEC FT/SEC DEG F DEG F DEG F DEG	244 811 445 19,74 314 445 314 445 314 45 47 84 47 84 47 84 47 85 95 91 91,84 94,85 94,95 94	284 76 437 18.67 344 FBH072 746 4.30 18.74 4.30 18.74 4.50 18.74 4.50 18.74 4.50 18.74 4.50 19.740 8.800 13.44 12.79 8.00 7.00	2446 74 74 74 74 75 75 75 75 75 75 75 75 75 75 75 75 75	249 249 79 79 79 79 79 79 79 79 79 70 79 70 70 70 70 74 70 74 74 74 74 74 74 74 74 74 74 74 74 74	247 247 247 248 443 16.72 711 FBH077 559 321.0 32.0 32.0 32.0 3.0 3.0 3.0 3.0 3.0 3.0 3.0 3	249 844 846 18.37 728 728 728 728 728 729 729 729 729 729 729 729 729 729 729	244 82 487 (19.22 208 7BH078 828 4.62 348.6 348.

Table 10. Detailed Information for Test MBCUO-6

MbCuO-07 Test Conditions

	11:0	0 64:3	0 01:4	5 04:0	5							
Test Condition	11	ТЧ	15	16	1	T	T	1			T	_
Coal flow, lb/h	+=	TÝ	17	- ₹ -						-+		-
Natural Gas flow,lb/h		1										
ABSORBER (1 ft x 8 ft)	12/5	12/	7 12/1	8 12/								-
Absorber temp control	750	250	750	2 750	<u>;</u>						-+	-
TE18, F (gas inlet)	740	1740	1 746	747								
TE390,F (sorbent inlet)	1545	735	1760	730	<u></u>							-
Flue gas, acfm	105	56	108	1.10	·		-+					
, ib/hr	500	260	505	510						1		
Sorbent flow,#/m	0.35	0.30	0.2	5 0 70		_						\neg
Injet SO2.ppm	2300	1712/	2 202	0 705						_		
Outlet SO2.ppm	100	1 22			(4
SO2 removal off (exp), %	82	1 4 4	92	1 4 2	4	+	+					_
SO, removal eff (model), %	-1-1-2	1-1-1	172		+					<u> </u>		\neg
Inlet NOT nom	-	+	1 600	1 624				_			-	_
Outlet NOx pom	1202	1610	200	2 2 20								_
NOx removal. %	- 21	1005	1 200	1500							_	
SO2 flow ib/hr	-1-47					<u> </u>			_		<u> </u>	
NO flow lb/br	10.10	0.281	0.00	0 0.125		+	<u> </u>			_		
NH3 flore lb/b	10.10	1-		+-	-		<u> </u>	<u> </u>	_			
PEGENERATOR	10.116	1-	+	+ -	+	+	<u> </u>					
REGERERATOR	+			1	+	-						
Regenerator temp control	850	850	850	850	<u> </u>	<u></u>	+	1				
1 £381, F	834	867	840	828	<u> </u>							
1 E304, F	834	1872	835	1842								
12363, F	1811	856	855	925		+						
15384, F	842	1905	910	920		1						
1E363, F	935	935	937	940	1	1						
Ken.ume, min	120	90	90	60	<u> </u>							
	0.60	0.30	0.60	0.60								
	1=	<u> </u>	-	1-								
N2 LIOW, ID/R	<u> </u>	1.0	<u> </u>	-	1							
NG&LH2/(IOLAIS), Mol ratio		1		11	1			-				
$NG/S = 0.5$ $H_2/S = 2)$	2	2	2	2		1	1					1
SO &	110		+			+	-					4
<u> </u>	175	21	42	46			I	ļ	1			
	34	24	37	33		Į	 	Į				
		1	20	23	<u> </u>	<u> </u>	ļ					
EL UID RED HEATED	170	46	99	1102	ļ	<u> </u>	<u> </u>	<u> </u>	1	1		1
TE373 E (12*)	1000	480	000		<u> </u>	 				<u> </u>		1
TE374 E (24")	905	780	980	975		<u> </u>	ļ	<u> </u>	ļ	ļ		
SO2 # PPm	480	980	980	1970	ļ		 	 	<u> </u>	Ļ		1
WATER	┿╼┥		10	10		<u> </u>	<u> </u>		 	Į	<u> </u>	
Start time	101.111	02.24				<u> </u>	<u> </u>	<u> </u>	I	L	L	1
Start Bagmeter (Pt3)	221.2	52.37	201.02	02:39) .)) .			1
Stop time	10:00	520.0	02:20	161.3			<u>`</u> `	 	<u> </u>		<u> </u>	1
Stop Bagmeter (Ft3)	46.2	578.7	346.0	101:37				{	}	1		
Interval time (min)	1194	122	47	120								#
Interval bagmeter (Ft3)	84.9	59.7	40.5	49.6								
Collected H2O (g)	755.8	321.0	149.9	344.7							1	
Water, ib/min	0.00254	0.00500	1 4000	0.00225								
Drymeter flow, scfm	0.438	0.484	0.418	0.413								
SULFUR ABSORBED, Mol/hr	0.0302	DILA	0.0245	0.0303								
SULFUR REGENERATED.						-						
Mol/hr	0.03116	0.0162	6.0277	0.0300								
SULFUR BALANCE, %	+3.01	4.1	-61	-1.0								
				110								1

Table 11. Daily Hand Data Sheet for Test MBCUO-7

					ABSORI	BER				1	REC	SENERATO	R	
TEST No.		inlet cone	l top absort	2 Der	3	4	5 bo abs	6 ttom orber	outlet cone	8 3 6 9 3	R1 bottom port	R2	R3	R4 top port
MBCUO-01	(1)	0.84			1.4	3.4			1.2		1.2	1.0	NA	
MBCUO-01	(2)	1.1			2.0	1.4			0.69		1.3	1.9	1.9	
MBCUO-01	(4)										1.5			
MBCUO-01	(5)	1.1			4.2				1.25		1.4			
Samples	taken d	during 1	regener	ator	sorber	nt flow	v patt	ern s	tudy:				· · · · · · · · · · · · · · · · · · ·	
sorbent sorbent	from re from re	egenerat egenerat	or con	ie bot ie bot	tom (h tom (n	olack c netalli	color) ic cop	per c	olor)		1.7 0.8			
MBCUO-2	(2A)	0.86	0.86	0.86	0.89	0.89	0.86	0.92	1.4		0.98	1.12		1.6
MBCUO+2	(1)	0.87	0.91	0.89	0.88	0.88	0.88	0.86	1.32		0.88	1.15		
MBCUO-3	(1)	1.85	0.91	0.85	1.36	1.45	1.25	1.72	1.75		0.84	1.27	2.11	2.48
MBCUO-3	(2)	1.18	0.86			1.81	L .	1.88	2.40		0.91	2.08	2.06	2.6
MBCUO-3	(3)	1.68	0.88				2.14	1.30	1.56		1.3	1.32	1.78	2.4
MBCUO-3	(4)	1.13	0.89					3.31			1.29	1.76	2.27	2.31
MBCUO-3	(5)	1.01	1.39					4.35			1.01	1.69	2.26	3.19
MBCUO-3	(6)	1.02	1.2					4.6	2.72		0.94	1.32	2.6	NA
MBCUO-3	(7)	1.04		1.72	,t	3.66	3.60	4.9	2.54		1.08	1.7	1.92	?
MBCUO-4	(1)	0.9	1.02		1.01			1.06	1.9		0.74	1.15	2.44	
MBCUO-4	(2)	0.91	0.91		1.27			1.5	2.76		1.05	1.98	2.61	
MBCUO-4	(3)	1.15	0.99	1.05	1.13	1.25	1.6	2.14	2.83		2.43	2.63	2.97	
MBCUO-4	(4)	0.93	1.1	1.12	1.09	1.67	1.58	1.45	2.37		0.95	1.66		
MBCUO-4	(6)	0.87	0.84	0.93	1.06	1.42	2.76	1.66	2.67		0.60	0.53		
MBCUO-4	(7)	1.02	0.84	0.98	0.84	1.37	x	1.34	2.11		1.30			
MBCUO-4	(3)	1.84	1.09	1.16	1.14	1.17	1.19	2.10	2.56		1.47			
MBCUO-4	(9) H ₂	1.14	1.11	1.09	1.22	1.41	1.07	1.49	2.60		1.38			

SULFUR IN WT% IN SORBENT SAMPLES

Table 12. Sulfur Analytical Results

1.13 2.01 3.27 1.01 2.12 2.98 3.45 MBCUO-5 (1)
 1.20
 1.22
 1.22
 1.28
 1.36
 1.26
 2.36
 2.83

 1.07
 1.08
 1.08
 1.08
 1.66
 1.09
 1.32
 MBCUO-5 (2) MBCUO-5 (3) MBCUO-5 (4)
 MBCUO-5
 (5) H₂
 2.01
 2.00
 2.19
 4.17
 3.99
 3.33

 MBCUO-5
 (5A)H₂
 2.01
 2.00
 2.19
 4.17
 3.99
 3.33

 MBCUO-5
 (5B)H₂
 1.85
 1.90
 1.96
 1.93
 1.99
 2.00
 2.81
 3.48

 2.45
 1.68
 2.45
 1.68
 1.68
 1.93
 1.99
 1.93
 1.99
 1.45
 1.69 3.60 3.89 3.82 3.63 3.69 2.60 4.03 Х MBCUO-5 (1A) 2.32 3.37 MBCUO-5 (1B) 0.73 2.66 2.58 2.64 MBCUO-5 (9A) 1.35 3.21 2.55 2.61 $\frac{\text{regn temp=700F, residence time = 60 min}}{\text{MBCUO-6} (1) H_2 3.74 4.24 4.03 4.02 3.86 4.45 4.51 4.96}$ 5.04 (regn inlet hopper = 5.03% S) (regn outlet hopper = 4.41% S) MBCUO-6 (1) MBCUO-6 (1) (regn outlet hopper MBCUO-6 (1) (absorber outlet hopper = 5.08% S) $\frac{\text{regn temp=700F, residence time = 60 min}}{\text{MBCUO-6} (2) \text{ H}_2 4.23 4.72 4.77 5.02 4.85 4.38 5.5}$ 6.375 MBCUO-6 (2) (regn outlet hopper = 5.14% S) MBCUO-6 (2) (regn inlet hopper = 6.18% S) MBCUO-6 (2) (absorber outlet hopper = 6.1% S) MBCUO-6 (batch regn with H_2 after MBCUO-6-2, S=4.66%) (regn condensate after batch regn, MBCUO-6 S=3.5% condensate weight = 106 grams) regn temp=850F, residence time=120 min MBCUO-6 (9)NG 2.5 3.2 MBCUO-6 (9) (absorber inlet = 1.4% S) MBCUO-6 (9) (regn inlet = 3.1% S) MBCUO-6 (9) MBCUO-6 (9) (regn outlet hopper = 1.5% S) (absorber outlet hopper = 3% S) regn temp=850F, residence time=120 min 1.7 2.4 MBCUO-6 (10)NG MBCU0-6 (10) (absorber inlet = 1.4% S) (regn outlet hopper MBCUO-6 (10) = 1.2% S) MBCUO-6 (10) (absorber outlet hopper = 2.4% S) regn temp=850F, residence time=120 min 4.3 4.3 4.3 MBCUO-6 (11)H2 MBCUO-6 (11) (absorber inlet = 2% S= 2.6% S) MBCUO-6 (11) MBCUO-6 (11) (regn outlet hopper (absorber outlet hopper = 3.5% S) regn temp=850F, residence time=120 min 2.4 4.4 4.5 MBCU0-6 (13)H2 MBCUO-6 (13) (Absr inlet = 2.2% S) MBCUO-6 (13) MBCUO-6 (13) (regn outlet hopper = 1.9% S) (absorber outlet hopper = 3.9% S) regn temp=750F, residence time=120 min MBCUO-6 (14)H2 3.7 3.7 3.6 MBCUO-6 (14) (Absr inlet = 2.3% \$) (regn outlet hopper = 2.6% S) MBCUO-6 (14) (absorber outlethopper = 2.3% S) MBCUO-6 (14)

MBCUO-4

ABSORBER DIFFERENTIAL PRESSURE PROFILES											
Times Top/Mic	dP 1-4 "H,O			dP 1-2 "H ₂ O			dP 3-4 "H ₂ O				
7/18 12:20	12:15	12:10	top 3.2	mid 3.2	bot 3.2	top 0.1	mid 0.2	bot 0.2	top 1.0	mid 1.0	bot 1.8
7/19 06:30	06:40	06:50	4.0	3.9	4.0	0.1	0.1	0.2	2.3	1.0	1.6
7/20 03:35	03:30	03:26	4.2	4.3	4.3	0.2	0.2	0.2	1.7	1.2	1.4
7/22 01:37	01:36	01:33	5.2	5.3	5.2	0.2	0.2	0.2	1.4	1.4	1.6
7/23 12:55	12:33	12:23	6.0	6.0	6.0	0.2	0.2	0.2	2.1	1.9	1.6
7/24 20:49	21:00	21:05	4.4	4.5	4.4	0.4	0.4	0.4	0.6	0.9	1.7
7/25 10:00	10:05	10:20	4.8	4.8	4.8	0.1	0.2	0.3	0.6	0.8	1.3
7/26 14:15	14:10	14:40	4.0	4.0	4.1	0.1	0.2	0.2	0.7	1.3	1.8
7/27 11:36	11:10	11:00	3.6	3.4	3.4	0.2	0.2	0.2	1.8	1.2	1.5

MBCUO-5

TABLE IV. ABSORBER DIFFERENTIAL PRESSURE PROFILES											
Times Top/Middle/Bottom			dP 1-4 "H,O			dP 1-2 "H,0			dP 3-4 "H,0		
8/16 08:26	08:29	08:33	1.6	1.6	1.6	0.0	0.0	0.1	0.7	0.6	0.5
8/17 7:27	7:29	7:31	1.9	1.9	1.9	0.0	0.0	0.1	0.8	0.5	0.5
8/18 11:10	11:12	11:00	2.2	2.2	2.2	0.0	0.0	0.1	1.1	1.6	1.5
8/21 10:23	10:26	10:30	1.7	1.7	1.7	0.0	0.0	0.1	0.6	0.6	0.6
8/22 13:45	13:51	13:53	1.8	1.8	1.8	0.0	0.0	0.0	0.6	0.6	0.6
8/23 06:20	06:21	06:22	13.0	13.1	13.3	6.5	з.0	5.2	1.5	.9	.4
8/24 06:55	06:56	06:57	18.5	18.9	18.6	2.5	2.2	1.5	15.0	7.0	6.7

MBCUO-6

			ABSORE	ER DIF	FERENT	IAL P	RESSU	RE PR	OFILES		
Times Top/Middle/Bottom			dP 1-4 "H ₂ O			dP 1-2 "H ₂ O			dP 3-4 "H ₂ O		
10/19 05:18	05:13	05:08	1.6	1.6	1.6	0.5	0.0	ö.0	0.0	1.1	1.4
10/22 15:19	15:21	15:23	2.5	2.5	2.5	0.8	0.0	0.0	0.3	0.9	0.8
10/23 17:29	17:21	17:18	2.9	2.9	2.9	0.0	0.0	0.0	2.7	0.9	1.2
10/27 05:22	05:29	05:40	4.2	4.0	4.1	0.0	10.0	0.0	3.1	3.0	3.1

Table 13. Absorber Pressure Drop Measurements

Test	Sorbent	Sorbent attrited	<pre># of hopper cycles</pre>	Hours of Operation	Attrition lb/hr	Attrition lb/hopper cycle	Inventory cycles accumulative
MBCUO-1							26.5
MBCUO-2	SOX-3	46.8 lb	2533	80	0.585	0.018	34.9
MBCUO-3	SOX-3	142.5 lb	6740	208	0.686	0.021	62.8
MBCUO-4	SOX-3	144.4 lb	4834	150.4	0.96	0.03	86.5
Differe	nt sorbent	was used in t	the following t	est series.		• • • • • • • • • • • • • • • • • • • •	••••
MBCUO-5	Grace	145. lb	6153	191.4	0.76	0.024	27.8
MBCUO-6	Grace	73. lb	5210	130.	0.56	0.014	52.9

Table 14. Sorbent Attrition Information



Figure 1. Effect of Temperature on SO_2 Removal: Experimental and Calculated





Figure 3. Effect of Sorbent Flow on SO_2 Removal: Experimental and Calculated


Figure 4. Effect of Regenerator Inlet Gas CH₄/S Molar Ratio on Regenerator Offgas Composition and Exit Sorbent Sulfur Content



Figure 5. Effect of Regenerator Sorbent Residence Time on Regenerator Offgas Composition and Exit Sorbent Sulfur Content









PETC INTERIM REPORT II: January 1996 CRADA PC-95006

RESULTS OF LIFE-CYCLE TESTS UNDER COAL FIRING USING ABSORBER BAR SCREEN DESIGN

J.S. HOFFMAN, J.T. YEH, H.W. PENNLINE

Background

Favorable results of past investigations of the Moving-Bed Copper Oxide (MBCuO) process while burning coal were not obtained in the Life-Cycle Test System (LCTS). System performance in the absorber would degrade as ash and/or sorbent fines accumulated on the sorbent retention screens. Removal of SO_2 in the absorber typically decreased while pressure drop through the absorber increased. This degradation continued to occur despite changes made in process variables to enhance system performance (such as decreasing the spike level of SO_2 in the flue gas; increasing the sorbent circulation flow rate; decreasing the amount of flue gas passing through the absorber; increasing the pressure, frequency, and duration of back-pulsing the screens, etc.). Subsequent disassembly revealed that the absorber and bed was fouled with ash which was not purged from the vessel during LCTS operation.

The initial design of the retention screen incorporated a square wire mesh (316 SS, 35 mesh, 0.0176" square opening by 0.011" wire diameter) affixed by tack-welding to a perforated plate (316 SS, 0.125" thick, 1" diameter hole on a hexagonal pattern with 0.25" bar resulting in 1.25" center to center spacing). After consultation with the consortium partners, a new retention screen design using vertical bars fabricated by Hendrick Manufacturing Company was formulated. A schematic depicting the cross section of the bar screen is included in Figure 1. The retention screen consists of stainless steel vertical bars spaced slightly apart, resulting in vertical slots that retain particles of a certain diameter. The cross-sectional area of each bar is shaped like a "golf tee" so that any particle able to penetrate the minimum slot opening encounters a diverging nozzle arrangement and thus the particle is free to propagate through the rear of the screen. At the sorbent/screen interface, the bar measures 0.140" width and spaced 0.030" apart (i.e., the minimum slot opening). The bar is 0.375" thick with 0.0625" metal width at the screen exit. Of the total 0.375" metal thickness, 0.25" has the constant 0.0625" bar width; the last 0.125" thickness transitions from the 0.0625" metal width up to 0.140" metal width at the sorbent interface. From the perspective of a particle less than 0.030", the fragment slips through the minimum slot opening of 0.030", follows the slot that expands from 0.030" to 0.108" over 0.125" travel, and then follows a 0.25" travel-path over a constant maximum slot opening of 0.108".

A design change to the back-pulsor assembly was also incorporated. The original assembly consisted of eight chambers segmenting the cross-sectional area of the rear retention screen. Each chamber provided screen coverage of 6" bed width by 4' bed height. Two horizontal rows, each containing 4 chambers, provided total screen coverage of 2' bed width by 8' bed height. Each chamber contained one venturi nozzle to deliver the back-pulse. In an effort to minimize any flow disruption to the furnace, the chambers were sequenced to pulse such that only a quarter of the total bed area was back-pulsed at one time. An increase in back-pulsing capability was implemented by doubling the number of venturi in each chamber from one to two. Also, better sealing of the chamber to the rear screen was incorporated.

The purpose of the most recent test (MBCuO-07) was to characterize the effectiveness of the bar screens in handling ash and sorbent fines while burning coal in the LCTS. The LCTS was tested between December 4 and 9, 1995. Absorber bed dimensions were held constant at 8' height by 1' width by 5" bed depth, replicating nominal conditions identified during prior LCTS operation using natural gas fire. Due to depletion of the UOP sorbent inventory, Grace sorbent (0.0625" dia) was used for this testing. Four steady state test periods were attained (chronologically identified as conditions 1, 4, 5, and 6 respectively); a fifth period (condition 2) could not be sustained due to excessive pressure drop through the absorber and was abandoned. Condition 1 utilized natural gas fire; conditions 4-6 utilized a co-fire of coal (Illinois, Old Ben No. 24) with minimum natural gas support. Table 1 is a summary of test conditions and times.

RESULTS AND DISCUSSION

Tables 2 and 3 contain a summary of preliminary (hand-recorded daily) and formal (computer-averaged) results, respectively. Table 4 summarizes absorber differential pressure profiles obtained at various times during testing. For Table 4, the location of pressure taps are identified as follows: subscript "1-2" refers to pressure drop across the inlet screen, subscript "3-4" refers to pressure drop across the outlet screen, and subscript "1-4" refers to the total pressure drop collectively across the inlet screen, sorbent bed, and outlet screen. Several general observations and actions taken during the test are included in the following.

Table 5 lists ash removals from the LCTS. After firing with natural gas, sorbent particles/dust were removed from the inlet and outlet absorber ash pots. A weight of 17.1 pounds of mostly sorbent particles were discovered. The large amount of these particles and the reduced amount during later collections at these pots suggest that these were particles too large to fit through the previous screens, but small enough to fit through the bar screens. Thus, it was speculated that these particles had accumulated in the bed during previous testing with this sorbent. As test periods with coal firing were conducted, the transport hopper required a longer fill time due to the deposition of ash in the absorber. Several instances of complete loss of sorbent flow in the absorber were observed. The pulsing of the absorber was effective in breaking up these blockages.

Figures 2-5 depict key LCTS process parameters versus time for all test conditions studied. Parameters for both the furnace and the absorber are emphasized to elucidate screen performance in the absorber.

Condition #1 (110 SCFM, no coal firing, no pulsing) was chosen to repeat a baseline performance condition previously investigated in the prior test (MBCuO-06-9). (See Figure 2 for further details of condition #1.) The SO₂ removal for condition #1 (93%) is in excellent agreement with the SO₂ removal from MBCuO-06-9 (94%), indicating that substitution of the new screens apparently did not influence the sulfation chemistry in the absorber. The pressure drop through the absorber (including front and rear sorbent retention screens and the sorbent bed) remained relatively constant at 1.4" H₂O. (See PDT-19 in Figure 2.) The pressure drop for MBCuO-06-9 was 2.5" H₂O, indicating that screen replacement was effective in lowering the pressure drop through the absorber.

Condition #2 was identical to condition #1 except that the furnace was fired on coal. In condition #2, (110 SCFM, coal firing, no pulsing) the differential pressure rapidly built up across the absorber (see Figure 3). Full flue gas flow (110 SCFM) through the absorber resulted in excessive ash accumulation. The SO_2 removal efficiency decreased with increasing pressure drop. Because the design limitation of pressure drop in the absorber was approached (20" H₂O), condition #2 was not sustainable and was therefore terminated. Between condition #2 and #4, scrubbing of the absorber (circulating sorbent without flue gas flow through the absorber) was effective in reducing the differential pressure.

For condition #4, half of the flue gas was flowed through the absorber. In condition #4, (55 SCFM, coal firing, no pulsing), the differential pressure across the absorber remained relatively constant at approximately 2" H_2O . This result implies that the ash entering the absorber through the inlet screen is balanced by the ash leaving the absorber through the transport hopper and the rear screen. Since the absorber was operated at "half load" (i.e., half flue gas flow), a very high SO, removal (99%) was demonstrated.

Condition #5 was identical to condition #2, except that the absorber was back-pulsed at regularly timed intervals. During condition #5 (continuous operation of the sorbent pulsers at 30 second intervals between pulses, coal firing, 110 SCFM), the differential pressure across the absorber remained relatively constant at 3 "H₂O (see Figure 4). SO₂ removal was demonstrated at

3

approximately 93%, consistent with the SO_2 removal found in condition #1 (no coal). This result demonstrates the successful nature of the new screens: a repeatable SO_2 removal with sustainable low pressure drop (with continuous back-pulsing of the screen) was feasible under coal fire and total flue gas flow (110 SCFM) through the absorber.

To further investigate the effect of back-pulsing the absorber, condition #6 was identical to condition #5 except that the manner of pulsing was changed. Instead of a regularly timed pulse, the differential pressure was allowed to build up to a value (6" H₂O) and rapidly pulsed down until a lower threshold (3" H,O) was The pulsers would cease operation and the cycle of attained. pressure growth was allowed to repeat. This method was also effective in reducing the differential pressure across the absorber (see Figure 5). An extremely brief period of rapid pulsing (1-2 minutes with typically two cycles of all eight chambers being pulsed) resulted in a quick return to the initial pressure drop (3" H_2O) identified in condition #5. The SO₂ removal (93%) was not greatly influenced by the pulsing and was consistent with prior test conditions. However, it appears that a slight decrease in SO2 removal occurs as the bed pressure drop increases.

For both methods of pulsing the absorber, the SO_2 removal efficiency did not significantly differ from condition #1, where the flue gas contained no ash.

During conditions #5 and #6, no bypass flow was used around the absorber while burning coal to allow a quantification of the ash /sorbent dust distribution. Although no bypass of flow is desired, the pressure control valve does not provide complete closure and therefore a small amount of bypass flow can occur. Details of the ash removals are tabulated in Table 5. The results for these two test periods should be added together due to an apparent blockage in the fluid bed heater (FBH) baghouse during condition #5. When added together and ratioed, results for conditions #5 and #6 combined are as follows:

Furnace ashpot: 35.9% Absorber inlet ashpot: 7.4% Absorber outlet ashpot: 7.6% Flue gas baghouse: 9.6% FBH baghouse: 39.5%

Hence for the coal burned, one third of the ash remains in the furnace ash pit. The remaining two thirds of the ash is carried over to the absorber. Subtracting out the ash contribution remaining in the furnace ash pit, and normalizing the remaining ash amounts, the distribution of ash carried over from the furnace as fly ash (no distinction was made between fly ash and sorbent dust) is as follows:

4 ·

Absorber inlet ashpot: 11.6% Absorber outlet ashpot: 11.9% Flue gas baghouse: 15.0% FBH baghouse: 61.6%

Hence of the carried-over ash, 15% passes through the absorber and is deposited in the flue gas baghouse. The other 85% is captured by the absorber. Approximately two thirds of the fly ash is trapped in the sorbent bed, transported to the FBH, elutriated from the sorbent by the fluidizing gas, and lastly captured by the FBH baghouse.

Sorbent attrition was of the same order of magnitude as in previous tests. A total of 67.3 lbs of sorbent was lost to attrition in 6 days of testing. Although the bar screens passed larger sorbent particles, this appears to have little effect on the overall attrition rate of the sorbent. Details of the sorbent inventory, additions, removals, attrition, and sorbent transport data are found in Table 6.

TABLE 1. TEST CONDITION SUMMARY								
Test Condition	1	2	4	5	6			
Start Day	12/4	12/6	12/6	12/7	12/8			
Start Time	14:14	02:00	08:54	09:02	09:17			
Finish Day	12/5	12/6	12/7	12/8	12/8			
Finish Time	13:45	06:49	06:27	05:40	06:20			
Furnace Fuel	NG	Coal	Coal	Coal	Coal			
Abs.Flue Gas Flow (SCFM)	110	110	55	110	110			
Absorber Temp (°F)	750	750	750	750	750			
Absorber Inlet SO ₂ conc. (ppm)	2250	2070	2070	2070	2070			
Ammonia /NOx ?	Y	N	N	N	N			
Sorbent Flow (lb/min)	0.75	0.75	0.75	0.75	0.75			
Pulsing Type	None	None	None	Contin- uous	Inter- mittent			
Reducing Gas	N.G.	N.G.	N.G.	N.G.	N.G.			
Reg. Temp (°F)	850	850	850	850	850			
Residence Time (min.)	120	90	90	90	60			
Reducing Gas Flow (lb/hr)	0.6	0.6	0.3	0.6	0.6			
Reg. N ₂ Flow (lb/hr)	0	0	0	0	0			
Reg. Vent N_2 Flow (lb/hr)	0	0	0	0	0			
Reg N ₂ flow to I'Lock?	N	N	N	N	N			

Table 2

سيدار محاددته

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MbCuO-07 Test Conditions

سيسا وجور المواجب والافارين المراجب المراجب والمراجب والمراجب والمراجب والمراجب والمراجب والمراجب والمراجب والم					,						
Test Condition	1	4	15	6							
Coal flow, ib/h		Y	TY	17	T						
Natural Gas flow, lb/h		1	1	1	T			1		1	
ABSORBER (1 ft x 8 ft)	1215	1.217	1218	112/9	1	1	1	1	1	<u> </u>	
Absorber temp control	250	250	750	750			1	1	+		
TE18, F (ras inlet)	1745	1 Jug	746	747	+	+	+	1	+	+	
TE300 E (andhant inlat)		1 220	1 2 0	720	+	+	+	+	+	+	
	1/95	1/35	760	130		-		+	+		
Fiue gas, scus	107	50	108	110	1			1			
, 10/0r	1500	260	505	510	Į		- 	<u> </u>	+	ļ	4
Sorbeat flow,#/m	0.75	0.75	0.75	0.75	1					L	
iniet SO2, ppm	2300	2120	2070	2060	1	1					
Outlet SO2,ppm	155	23	155	140			1				
SO2 removal off (exp), %	93	99	92	93							
SO ₂ removal off (model), %			T		T	T		1			1
Iniet NOx,ppm	1505	610	580	530	1				1		1
Outlet NOx,ppm	51	605	580	500	1		1	<u> </u>	1	<u> </u>	+
NOx removal, %	1 90		-	-	1		1	1	1		1
SO2 flow.ib/hr	1.47	10.284	0.03	20125	+				+		
NO flow the	1010	10200	0.000	10.1.5			+	+			+
MUS Ame DA	10.10		+	+		+		<u> </u>			<u> </u>
DECEMENTOD	10.116	1				+		 			
REGENERATOR		L		-	ļ						
Regenerator temp control	1 850	850	850	850	L						
TE381, F	834	867	840	828							
T E382, F	834	872	835	842		I					
TE383, F	811	856	855	925							
TE384, F	842	905	910	920		T	Ι	1 - S			
TE385, F	935	935	937	940		T	1.			2	
Resi.time, min	120	90	90	60		1	1				
NG flow, lb/h	0.60	0.30	0.60	0.60	 	1	<u> </u>				
H2 flow, ib/h	-		-	-			1				
N2 flow, lb/h	1 _	1.0	~			<u>+</u>	<u> </u>				
NG&H2/(total S), Mol ratio			1		<u>-</u>	+	<u> </u>				
Equivalence Ratio (Phi=1 for	1 1	1	1,								
NG/S = 0.5, H2/S = 2)	2	2	2	2							
SQ., %	44	21	42	Wb							
CO. %	20	24	2.7	32		 			+		
CH %			20	22		 					
Totel %	49	114	~~~	23							
ELUD RED HEATER	70	4.6	44	102		 					
TE373 E (12*)	200	200	000	0.25				-			
TE374 E (12)	705	100		475							i
1 CU /7, F (44)	480	480	980	470							
304, # FFM	-		10	18							
WAIER											
Start time	06:46	02:39	01:02	02:39					. 1		
Start Bagmeter (FB)	501.5	520.0	306.4	964.5							
Stop time	10:00	04:41	02:39	04,34			I				
Stop Bagmeter (FU)	-1.0.2	579.7	346.9	1014.1							
Interval time (min)	194	122	97	120			Ī	I		ĺ	
Interval Dagmeter (FU)	84.9	54.7	40.5	44.6							
Collected H2U (g)	755.8	321.0	, ya ,a	394.7							
water, lb/min	5.00059	0.00580	0.00341	0.00725			T	T			
Drymeter flow, setm	0.438	0.489	0.418	9.413							
SULFUR ABSORBED, Mol/hr	20302	0.0169	0.0295	0.0303							
SULFUR REGENERATED.	0.3311	0.016.3	0.000								
Moi/hr		0.0102	0.0477	0.0500							1
SULFUR BALANCE. %	+3.07	-4.1	- 6.1	-1.0		i			1		
- A	2.15	6.075 i	0.15	0.15	······						
	0.0960	0.0421	0.0751	0.108			• •				
	. 7/ 0		- 49 4	18 0		-			···		
10 Mance	0.00		0.1.0		·						
÷	in nanel	A 41471	1. 00 × CI	- A33CI							

Table 3: Computer-Averaged LCTS Process Data for MBCuO-07.

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MBCU0-07	PARAMETER	144	<u>.</u>	1	2	,	•
COMPLETOR FLE		÷		COMBOS7	COLEORS	COLECC	COM7067
	COME AN	FY-1	7.64	411	+42.1	+421	482.1
	NATURAL GAS	PY-20	IMA	2.11	ور د	133	
	FEEDER WT	WCT-35	1.1-R	000 000	41 19	×.14 >>.10	36.50
	EXCESS AR	8Y-X	XXSA	20.07	25.26	28.30	27 02
	ALLE GAS AN	FY-15	JAR .	5.24.4	641.3	546.3	547.0
	FURNACE OR	AT-02-0	1 1120	1.70	-1.01	-0.54	- 0 56
	COLD AN P	PT-1	23/6	4.72	471	4.70	4 43
	HATURAL GAS P	PT-3	Para	4.17	4.60	4 46	94.02
	FLUE GAS P	PT-16	- +120	5.20	1.20	6.01	6.06
	THEOR AR	RY-X	THEONE	365.70	388.18	367.06	107 57
	PURMACE COL	AT-CO2-0	MENCENT	3.50	14.66	14.79	14.85
	MOTIVE ANY	57-1	FT/SEC	00.C	80.04	80,14	10.06
	FLUE GAS M	FY-16	3074	112.4	120.3	119.0	121.6
ABOORBER FLE				A8.5001	ALSONE	ABBOBS	
	PALET NOX	AT-NOI-1	PPM	606	618	547	6.26
	SALET OE	AT-02-1	PERCENT	4.30	2.01	3.55	143
	OUTLET NOX	AT-NOX-2	PPW	u	806	\$78	400
	NO SPACE	FT-101	JAR .	0.10	0.00	0.00	0.00
	302 34902	FT-108	140	1.40	0.20	0.06	0000
	SED OF	POT-19	H20	1.39	2.00	3.06	4.26
	ALLE GAS M	PT-17	-H20	400.7	201.2	7,70	611.3 7.77
	SCHEENCH	POT-21	H2O	3.66	1.23	0.81	40
	GAS OUTLET	TE-21	DEGF	584	541	677	678
	SORE IN	72-340	DEGF	742	736	749	746
	SOR REMOVAL	802	PEACENT	83.1	71.0	12.5	83.0
	FLUE GAS M	PY-17	SCFM	106.9	0.9	108.0	3.6
REGISTERATOR EN				REGON	350000	250000	NEQ 448.40
	QUICK REP OF	AT-01-44	PERCENT	0.13	0.42	0.01	0.01
	REGEN CHA	AT-SOE-4	PEACENT	44.10	1 28	19.24	+6.34 ZA.27
	REGEN COR	AT-COZ-4	PENCENT	36.82	23.74	37.36	33.22
	REGEN OS	AT-02-4	PERCENT	0.34	0.06	0.06	0.12
	NATURAL GAS	FY-300	148 148	0.00	0.30	0.00	0.00
	REGEN P	PT-300	HOO	11.21	10.00	16.00	4 12
	TSORE (2)	TE-301	DEG	6.7	2466	540	526
	T3088 (17)	TE-342	DEGF	536	872	541	547 925
	TSORS (47)	TE-304	DEGF	542	907	\$11	923
	TOFFGAS	TE-306	DEGF	250	260	362	251
	T COND EX	TE-387	DEG	77	83	63	54
	NCIN 02	AT-02-6	PENCENT	16.84	18.66	18.64	18.37
	INCAR BUZ	AT-002-6	PPNR		4/10	200	
FLUD NED HEATER FLE	TSOMMEN	77-173	DEG	FBHOEI	FBHORE	FBHORS	976
	NATURAL GAS	FY-66	Int	6.26	5.70	5 47	8.70
	FBH VEL	3Y-30	FTISEC	274.7	313.7	316.8	3.20
	FBH 02	AT-02-3	DEGF	5.00	1211	15.43	1211
	TPLENAN	TE-372	DEGF	544	668	570	467
<u></u>	TVENT	TE-376	DEGF	9452 3458	581	379	372
	THUM OUT	TE-378	DEGF	501	498	500	500
	BED OP	POT-176	+20	2 77	3 66	11.12	2.07
	FBH NOX	AT-NOI-3	PPM	13 46	7.72	943	944
	FBH 802	AT-502-3	PPM SCEM	0 86	0.00	14 96	6.94
	REG NGAS M	FY- 1008	SCFM	222	911	322	0.22
	REG N2 M	FY-3105	SCFM	3 00	223	0.00	
FLUID BED COOLER FLE	FBC AN VE	57-100	FTARA	FBCOBI	FBC082	FBCOBS F	BCBALM
		FY- 340	/ ++R		143.8	102.3	: 01.5
	TLOWER	TE-342	DEGI	970	320	240	200
	BED OP	507-368	-20	5 62	1394	1 77	2.76
	FBC PRES	PT-346	120		1 76	12	2.00
	THEATER	TE-364	OEGF	528	322	5431	×35 567
	T AIR	78-340	DEGF				
	AR DP	FT-300	~20	3 44	244	242	2.47
	OUTLET SOZIADA	302PE	PPM	-267	2144	- 2076	2088
	INLET NOXIAD J	NOTREF	PPM	100	528	546	
	NA M	FY-300	SCFM	+0.31	402	39 9	42.0
	IN ROPPER	35CTCLES	CTULE	547	122	544	250
TEMPERATURE FLE	COMB ANT	16-1	DEGF	EMPOR7	EMPoes	TEMPOREIT	EM70671
	CO AR HTRT	72-3	DEGF	530	5.26	5.26	550
	FUR REFAT	18-4	DEGF	3361	- 10	314	271
	FUAN EXT T	78-18	DEGF	141	46	378	373
	ABS FGAS T	E-18	CEGF		-31	50	.50
	SGHS TOP T	78-27	DEGF	.54	.64	-36	.54
		17 - 20	CEGF	.67	347	164	-54
	ABS 21 T	TIC -M	DEGF	*\$11	*50	*841	211
	3GH3 BOTT 	TIC - M	DEG	-50	'50 '50	-50	- 50
	3GH8 BOTT -85 21 T -85 22 T -85 22 T -85 23 T -88 24 T	TIC - 46 TIC - 46 TIC - 41 TIC - 41	DEGF DEGF DEGF DEGF	*\$0 *\$0 *10	'50 '50 '50 '50	-50 -51 -50 -50	2 22 2 22 2 22
	3 GH & BOTT ABS 21 T 485 22 T ABS 23 T ABS 24 T ABS 25 T CW SUP T	TIC-66 TIC-66 TIC-66 TIC-66 TIC-66 TIC-66 TIC-66 TIC-67 TE-42	DEGF DEGF DEGF DEGF DEGF	50 50 50 51 51 50	*50 *50 *50 *50	50 51 50 50 50	2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2
	3 GH 8 60 T T - 48 27 T - 48 22 T - 48 22 T - 48 24 T - 48 24 T - 68 24 T - 78 24	TIC-06 TIC-06 TIC-01 TIC-01 TIC-01 TIC-97 TE-42 TE-43 TE-44	DEGF DEGF DEGF DEGF DEGF DEGF DEGF	51 50 10 31 50 30 44	50 50 750 750 750	50 51 50 50 50 50 6 41	50 50 50 50 50 50 50 50 50 50 50 50 50 5

TABLE 4. ABSORBER DIFFERENTIAL PRESSURE PROFILES											
Times Top/Mic	ldle/Bot	tom	dP 1-4 "H ₂ O			dP 1-2 "H ₂ O			dP 3-4 "H ₂ O		
12/5 09:46	09:11	07:48	1.4	1.4	1.4	0	0	0	0.6	0.8	0.8
12/6 06:02	06:04	06:06	9.9	10.0	10.3	0	0	0	0.5	0.8	1.0
12/6 06:42	06:40	06:38	15.2	15.3	15.2	0	13	0	0.3	0.4	0.5
12/7 02:40	02:42	02:42	1.8	1.7	1.7	0	0	0.5	1.0	0.6	0.3
12/7 08:29	08:31	08:33	2.9	2.9	2.9	0	0.5	1.0	1.3	0.9	0.4
12/8 01:53	01:52	01:51	3.0	3.2	3.1	0	0	0.5	1.5	0.8	0.8
12/8 N/A	11:11	11:09	N/A	5.0	5.0	N/A	N/A	2.0	N/A	1.1	1.4
12/8 13:08	13:06	13:04	5.6	5.2	5.6	2.0	2.0	0.5	1.7	0.7	2.0
12/9 23:14	23:13	23:12	4.1	4.0	4.1	0	0	0.5	3.0	1.5	1.2
12/9 03:13	03:10	03:09	4.6	4.5	4.6	0	0	0.5	1.1	2.5	2.4
12/9 04:14	04:15	04:16	3.8	3.8	4.0	0	0	0.8	1.8	1.2	1.6
Note: 12/8 11:09 differential pressure profile interrupted by fire alarm in B84 highbay.											

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TABLE 5. SORBENT ASH COLLECTIONS										
	Date	Furnace Pot	Absorber In Pot	Absorber Out Pot	Furnace Baghouse	FBH Baghouse	FBC Cyclone	TOTAL Ash	Coal Burnt	Ash/Coal
Weight (lbs.)	5-Dec		3.70	13.40				17.1		
% of ash			21.64%	78.36%				*		
Weight (lbs.)	7-Dec	39.20	3.00	6.00	25.70	36.20		110.1	899.8	12.24%
% of ash		35.60%	2.72%	5.45%	23.34%	32.88%				
Weight (lbs.)	8-Dec	19.80	3.00	4.60	4.80	0.60		32.8	478.7	6.85%
% of ash		60.37%	9.15%	14.02%	14.63%	1.83%				
Weight (lbs.)	9-Dec	13.10	3.80	2.40	4.00	35.60		58.9	526.6	11.18%
% of ash		22.24%	6.45%	4.07%	6.79%	60.44%				
Weight (lbs.)	11-Dec	1.2	1.4	1.1	0.8	9	4	17.5		
% of ash		6.86%	8.00%	6.29%	4.57%	51.43%	11.43%			
TOTAL	7-11	73.3	11.2	14.1	35.3	81.4	4	219.3	1905.1	11.51%
% of ash	Dec	33.42%	5.11%	6.43%	16.10%	37.12%	0.91%			
Total Sorbent	Attrition	67.3								
Attrition corr	ected for	50.2		2.64%						

TABLE 6. Sorbent I	TABLE 6. Sorbent Inventories, Cycles, and Calculated Attrition - MBCUO-07									
		Sorbe	ent Inve	ntory						
Date	4-Dec	4-Dec	5-Dec	5-Dec	6-Dec	7-Dec	7-Dec	8-Dec	9-Dec	TOTAL
Time	4:14	23:25	13:45	21:44	6:49	6:27	17:10	5:40	6:20	
Sorbent bulk density (lb/ft^3)	29.8	29.8	29.8	29.8	29.8	29.8	29.8	29.8	29.8	
Reg. residence time (min.)	120	120	120	90	90	90	90	90	60	
Sorbent Flow (lb/min)	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	0.75	
Reg. inventory (1bs.)	105	105	105	83	83	83	83	83	60	
FBC inventory (lbs.)	37	37	37	37	37	37	37	37	37	
FBH inventory (lbs.)	58	58	58	58	58	58	58	58	58	
Absorber inventory (lbs.)	146	146	146	146	146	146	146	146	146	
Total Sorbent Inventory (lbs.)	347	347	347	324	324	324	324	324	302	
Change in sorbent inv. (lbs.)	0	0	0	23	0	0	0	0	23	45
Sorbent Additions										
Sorbent Added (lbs.)	0	19.8	0	0	0	0	9.2	0	0	29
		Sorb	ent Rem	ovals						
Test Condition Ending			1		2	4		5	6	
Number of 8 oz samples	0	0	12	0	0	12	0	2	2	
Sample Weight (lbs.)	0.00	0.00	2.87	0.00	0.00	2.87	0.00	0.48	0.48	6.70
Attrition										
Difference due to attrition (lbs.)		19.80	-2.87	22.50	0.00	-2.87	9.20	-0.48	22.02	67.30
Sorbent Transport System Data										
Cumulative Transport Cycles	0	335	610	647	762	1332	1466	1680	2085	<u> </u>
Cycles since last change	0	335	275	37	115	570	134	214	405	
Sorbent Weight/hopper (lbs.)			1.58		1.58	1.58		1.58	1.58	
Number of sorbent changes/test cond	lition		2.78		0.74	2.78		1.70	2.12	8.00
Elapsed time since last change	0	19:11	14:19	7:59	9:04	23:38	10:43	12:30	0:40	



Figure 1: Cross Section of Hendrick Bar Screen.



Figure 2: LCTS process variables versus time for test condition #1.



Figure 3: LCTS process variables versus time for test conditions #2 & #4 combined.



Figure 4: LCTS process variables versus time for test condition #5.



Figure 5. LCTS process variables voreus time for test condition #6

PETC INTERIM REPORT III: August 1996 CRADA PC-95006

RESULTS OF ALCOA SORBENT TESTING IN THE LCTS DURING JANUARY TO APRIL 1996

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I. BACKGROUND

Rather than the 1/16-in-diameter sorbent pellets that were used in past tests, the use of larger sized sorbent pellets as a way to reduce pressure drop across the moving-bed absorber was proposed by members of the Moving-Bed Copper Oxide Process (MBCUO) CRADA consortium. Sorbents with different diameters were recommended for use in the LCTS. The relationship between sorbent size and reaction rate for SO₂ removal was also correlated by Tecogen. PETC responded by conducting an engineering evaluation on the operability of the larger sized sorbent in the existing LCTS, followed by testing with the sorbent.

The sorbent was provided by the Aluminum Company of America (ALCOA) under a separate agreement (CRADA PC-93007) with DOE that fulfilled an obligation of ALCOA. Although the two CRADAs with DOE are autonomous agreements, communication between the two industrialside CRADA parties has developed to the point that ALCOA provided sorbent for a larger-scale development effort of this flue gas cleanup technology.

In this interim report, the results from several process parametric test series (MBCUO-8 through MBCUO-10) with the ALCOA sorbent in the LCTS are discussed. The effects of various absorber and regenerator parameters on sorbent performance (e.g., SO_2 removal) were investigated. Flue gas was produced by burning natural gas or coal. Sorbent spheres of 1/8-in diameter were used as compared to 1/16-in sized sorbent of a previous study [1]. Also referenced are modifications to the absorber to improve the operability of the LCTS when fly ash is present during coal combustion. The experimental results from these modifications are discussed.

II. EXPERIMENTAL

The process has been investigated using the LCTS, which has been described previously [2]. The LCTS has the capability of operating in a continuous integrated mode, specifically related to the absorption and regeneration steps. The sorbent performance in the moving-bed configuration has been characterized by using flue gas that can be produced by combusting natural gas or by combusting pulverized coal (34 lb/hr of an Illinois Old Ben Mine No. 24) with some natural gas support, resulting in a nominal flue gas flow rate of 110 scfm. The flue gas is spiked with SO_2 and NO supplied from cylinders to adjust these concentrations to those of the desired absorber inlet test levels. Ammonia is injected into the flue gas upstream of the absorber to facilitate the catalytic reduction of nitrogen oxides to nitrogen and water vapor in the absorber. The sorbent process stream in the LCTS involves a closed-loop cycle of sorbent transported through four major vessels: the moving-bed absorber, a fluidized-bed sorbent heater, the regenerator, and a fluidized-bed air cooler. Sorbent hoppers located between the

vessels isolate the activities occurring in each vessel and provide for metered transport of the sorbent around the closed-loop cycle.

Modifications to the LCTS were required to effectively transport, heat, and cool the larger and denser ALCOA sorbent. There were two concerns related to circulating the larger-sized sorbent. First, the fluidization gas velocities in the fluidized-bed sorbent heater and the fluidized-bed sorbent cooler needed to be doubled-totripled to fluidize the 1/8-in-diameter sorbent spheres. The available capacity of each respective blower for the fluidized beds was not able to provide the required flow. Second, it was uncertain whether the solid transport piping lines and hoppers could handle the large diameter spheres, especially when the sorbent bulk density was 54 lb/ft³ as compared to the past sorbent with density about 35 lb/ft³.

After fluidization engineering calculations, it was concluded that the existing blowers could not handle the 1/8-in-diameter particles. A solution to the first concern was to insert a liner/sleeve into each fluidized-bed vessel to reduce the cross sectional area. However, by reducing the volumes in the heater and cooler (thus reducing the sorbent residence times in these vessels), a potential existed for poorer heat transfer with the larger 1/8-in spheres. From actual temperature data during the testing, this potential problem did not appear during the MBCUO-8 to MBCUO-10 test series, when the sorbent rates were between 0.75 lb/min to 1.5 lb/min. With respect to the second concern, a batch of raw ALCOA alumina (substrate) pellets was actually tested in the transport lines and hoppers to gain operational and handling experience. With modification (enlargement) of the restricting flow orifices, the 1/8-in spheres were successfully transported.

Previous modifications to the absorber were made to facilitate operation while burning coal. In the original absorber design, sorbent performance in the absorber would degrade as fly ash accumulated within the bed and/or on the sorbent retention screens. Removal of SO_2 in the absorber typically decreased while pressure drop through the absorber increased and effective absorber cross-sectional area decreased. Two modifications were made to the absorber to negate this problem: a new design of the sorbent retention screens and an increase in the pulsing capability of the absorber.

The initial design of the sorbent retention screen (an inlet and outlet screen envelop the moving-bed of sorbent in the absorber) incorporated a square, stainless steel wire mesh (35 mesh --0.0176-in square opening by 0.011-in wire diameter) affixed by tack-welding to a stainless steel perforated plate (0.125-in thick, 1-in diameter holes on a hexagonal pattern with 1.25-in center-tocenter spacing). However, due to the aforementioned ash plugging problem, a new retention screen design using vertical bars fabricated by Hendrick Manufacturing Company was conceived. The

new retention screen consists of stainless steel vertical bars spaced slightly apart, resulting in vertical slots that retain particles of a certain diameter. The cross-sectional area of each bar is shaped like a truncated "golf tee" so that any particle able to penetrate the minimum slot opening encounters a diverging nozzle arrangement, and thus the particle is free to migrate to the opposite side of the screen. At the sorbent/screen interface, the bar measures 0.140-in width, and the bars are spaced 0.030-in apart (i.e., the minimum slot opening) so that particles less than 0.030 inches slip through the minimum slot opening. This modification was made before MBCUO-7 and is described in detail elsewhere [3].

A design change to the back-pulser assembly was also incorporated. The original assembly consisted of eight chambers segmenting the cross-sectional area of the rear retention screen. Each chamber provided screen coverage of 6-in bed width by 4-ft bed height. Two horizontal rows, each containing 4 chambers, provided total screen coverage of 2-ft bed width by 8-ft bed height. Each chamber contained one venturi nozzle to deliver the back-pulse. In an effort to minimize any flow disruption to the furnace, the chambers were sequenced to pulse such that only a quarter of the total bed area was back-pulsed at one time. An increase in back-pulsing capability was implemented before MBCUO-6 by doubling the number of venturi in each chamber from one to two. Also, better sealing of the chamber to the rear screen was incorporated.

III. CHARACTERIZATION OF ALCOA SORBENT A. Physical Description

ALCOA alumina is the base substrate of the copper oxide sorbent. The copper oxide sorbent was prepared by ALCOA by exposing the substrate to a copper sulfate solution via an incipient wetness technique. The copper sulfate/alumina spheres were then dried in air. The fresh sorbent used in the testing and as received by PETC contains approximately 6.6% copper by weight. The bulk density of the virgin sorbent was about 54 lb/ft³.

B. Activation of ALCOA Sorbent

1. Sulfur and Copper Analyses -- Fresh Sorbent

Four drums of fresh sorbent were originally shipped to PETC in January 1996. Each drum was sampled and analyzed for copper and sulfur content. Results are given below.

		Cu% by wt	S% by wt
Drum	#1	6.7	3.4
Drum	#2	6.6	3.4
Drum	#3	6.5	3.4
Drum	#4	6.6	3.3

The above data indicate that the copper and sulfur weight percentages are in agreement with copper sulfate molecules impregnated on alumina substrate. The average sulfur content is very close to the theoretical 3.33 wt% assuming a 6.6 wt% copper loading. The fresh ALCOA sorbent was also analyzed at PETC for free water and water of hydration. Fresh sorbent was initially heated in a furnace at 120°C for 1 hr to determine free water; the weight loss was 0.4%. The sorbent was heated for an additional hour at 400°C and the total weight loss of the sorbent was recorded at 4.8%. From an original copper loading of 6.87% as reported by ALCOA, water of hydration loss can range from 1.95% (assuming a monohydrate) to 9.74% (assuming a pentahydrate). It would appear that the water of hydration for the large batch of sorbent falls between the monohydrate and pentahydrate. If the sulfate was in the form of a monohydrate and using the PETC 6.6 wt% number, the calculated Cu as CuO (after total regeneration of the copper sulfate and oxidation of the copper) would be 7.35 wt%; if in the form of a pentahydrate, the calculated Cu as CuO (after total regeneration of the copper sulfate and oxidation of the copper) would be 8.02 wt%.

2. Sulfur Analysis of Regenerated Sorbent

From previous small-scale work with alumina impregnated with copper sulfate, the initial regeneration (activation) rate of the fresh sorbent was lower compared to subsequent regenerations. With this information, the first activation of the sorbent was conducted by circulating the entire sorbent inventory in the LCTS over a period of time. Subsequent activations of the sorbent were conducted in batches in the LCTS regenerator.

The first batch of fresh ALCOA 1/8-in diameter sorbent was activated with natural gas at a regeneration temperature of 850° F. The entire LCTS was loaded with fresh sorbent and the sorbent was circulated at normal process conditions but without SO₂ in the flue gas. Flue gas was produced by burning natural gas. The first activated sorbent sample was taken on 11:50 AM, 1/19/96, after 24 hours at activation process conditions, and the sulfur content was 1.41%. The second activated sorbent sample was taken on 12:00 noon, 1/20/96, after an additional 24 hours at activation conditions, and the sulfur content was 6.7%.

Subsequent batch activations occurred at various times during the span of MBCUO-8 through MBCUO-10. Results are shown in Table 1. The batch regenerated sorbent did have a residual sulfur content. It can be speculated that either the fresh sorbent is not being regenerated entirely, or some of the alumina substrate is reacting with the sulfate from the copper sulfate during activation, thus sequestering the sulfur.

Sulfur and copper contents in the ALCOA regenerated samples, that were taken at various steady-state conditions during MBCUO-8 through MBCUO-10, revealed several details. (See Table 2.) The sulfur content of the activated or regenerated sorbent was never less than 1.0% possibly indicating that 1) the copper was not

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regenerated entirely or 2) some of the residual sulfur is sequestered in the alumina substrate. Also, the copper content of the spent sorbent was always near 6.6%, signifying that the spent sorbent would have the same copper loading as the fresh sorbent. Possible rehydration of water on the sorbent could occur, although a better explanation is not available at this time.

C. XPS Analysis

Samples of sorbent were sent to a PETC laboratory for surface studies. The technique, X-ray photoelectron spectroscopy, was used in the past to determine if the impregnation step was uniform across the pellet; to determine if the process (dusting?) has changed the uniformity across the pellet; to determine the oxidation states of the elements and ions present; and to determine if fly ash constituents are present on the sorbent. This data was informative in relation to the uniformity of the impregnation step and a determination of changes with time on stream for the sorbent.

Table 3 is a listing of the results of a fresh sorbent, a fresh activated sorbent from a circulating activation at the beginning of MBCUO-8, and samples taken after the absorber in MBCUO-9. The outside surface of the pellet was analyzed; the pellet was then cleaved and the core analyzed. Atomic ratios (intensities) are reported. For the fresh sorbent, the Cu 2p spectra showed that Cu was in the 2+ oxidation state. The Cu was very well dispersed on the surface of the fresh sorbent as evidenced by the high value of the Cu 2p/Al 2s intensity ratio. The majority of Cu on the fresh sorbent was located on the outside surface of the spheres as opposed to the inner core.

The outside surface of the newly activated sample appears to have a mixture of all Cu oxidation states (2+, 1+, and 0). There is virtually no Cu 2+ in the core of these spheres. As evidenced by the much lower Cu 2p/Al 2s intensity ratios, especially on the outside of the spheres, the copper has either been sintered or removed as compared to the fresh sorbent. It must be remembered that this sorbent was activated for about 48-hr by regeneration of the circulating sorbent in the LCTS. (See Section IV. A. for details during this operational phase.)

The amount of copper dispersed on the MB9-7 sample was poorer than for the fresh sorbent. Cu was in the 2+ oxidation state. For the spent sorbents, typically little difference was evident between the inner core and outer shell copper loadings.

Sulfur is present as a sulfate in all of the sorbents. The majority of sulfur tends to remain at the outer surface of the spent samples.

There did not appear to be any traces of fly ash in the survey spectra of the outside surfaces of any of the samples. Silicon is expected to be the best indicator of ash deposition on the surface of the spheres. The limit of detection was about 2 wt% for the survey scans.

IV. OPERATIONS OF THE LCTS -- CHRONOLOGY

Three parametric test series -- MBCUO-8, MBCUO-9, and MBCUO-10 -were conducted during this reporting period. A discussion of the operations follows.

A. MBCUO-8

Fresh 1/8-in diameter ALCOA sorbent was tested for the first time during the MBCUO-8 test series. The fresh sorbent was first loaded into the LCTS; the combustors and reactor electric heaters were fired up on the early hours of 1/16/96. It required some initial learning to move this hard-to-fluidize sorbent around the lifecycle loop. Once this was accomplished, another objective was to activate the fresh ALCOA sorbent, which was impregnated with copper sulfate. The sorbent was activated with natural gas at a regeneration temperature of 850°F. Natural gas flow rate was maintained at about 0.6 lbs/hr throughout the activation procedure. While the sorbent was circulating around the life-cycle system, the entire sorbent inventory in the LCTS was slowly being regenerated. The regenerator off-gas SO_2 and CH_4 concentrations were monitored for regeneration progress. The first sorbent sample was withdrawn on 11:50 AM, 1/19/96, and was sent for rush analysis for sulfur content (1.41% by weight). A second sorbent sample was withdrawn on 12:00 noon, 1/20/96, and the sulfur content was 1.16%. At this time, test condition #1 was started. Due to cold weather, the cylinder of liquid SO₂ located in the unheated cylinder room was unable to deliver enough SO_2 to spike the flue gas to 2250 ppm SO_2 . Therefore, the test condition was change to 1500 ppm SO_2 in the flue gas. This test condition was labeled #5 (see Table 4). After test condition #5, test condition #1 was performed. Test condition #1 was followed by test condition #3, that employed coal firing. During coal firing, the absorber pressure drop increased from less than an inch water to about 5-in water. Test condition #1A was a revisit to test condition #1 by returning to natural gas firing at the end of test condition #3.

The reduced data for MBCUO-8 are shown in Table 5. Specifics of the testing follow.

<u>MBCUO-8-5</u>: 1/20-21/1996 Natural gas firing

Test parameters are shown in Table 4. There was no matching test condition when using UOP or Grace sorbents. Pressure drop change across the absorber during this period remained under 1-in water. At 1529 ppm SO_2 inlet and 0.75 lb/min sorbent flow rate, the SO_2 removal was 95.5%.

<u>MBCUO-8-1</u>: 1/22-23/1996 Natural gas firing

During this test period, the SO_2 spike was increased from 1529 ppm to 2246 ppm and the SO_2 removal decreased to 86.8%. Absorber pressure drop remained below 1-in water. Bed pressure drop and SO_2 removal history during this test condition are shown in Figure 1. NO_x removal was tested during this period, and 95.7% NO_x removal was

obtained at a comparable NH_3 flow rate as when other sorbents were used. This test condition is comparable to test MBCUO-4-4 when UOP sorbent (6.4% Cu) was used. The SO₂ removal in MBCUO-4-4 was 84%. The disadvantage of larger particle size effect seems to have been compensated by larger sorbent inventory (sorbent residence time) in the absorber. The sorbent inventory ratio (sorbent bulk density ratio) is 54/35 = 1.5 and is in favor of the higher bulk density particle.

MBCUO-8-3: 1/24-25/1996 Coal firing

Flue gas was produced by burning the Illinois Old Ben Mine No. 24 coal during this period. The objective was to observe the effect of larger sorbent size on fly ash retention and on absorber pressure drop. Figure 1 shows the effect fly ash has on the absorber bed pressure drop and the subsequent effect on SO_2 removal. Figure 1 also shows that the pressure drop and SO_2 removal efficiency are very sensitive to back-pulsing, with the response almost instantaneous. Under coal-firing, the SO_2 removal has dropped to 77.1% at 5-in water pressure drop. However, NO_x removal did not seem to be affected.

<u>MBCUO-8-1A</u>: 1/25-26/1996 Natural gas firing

Condition #1 was revisited by halting coal firing and returning to full natural gas firing to produce the flue gas. Figure 1 shows the effect of removing fly ash from the flue gas on SO_2 removal and pressure drop. Fly ash was continuously removed from the LCTS through the fluidized-bed heater during the sorbent circulation, causing the pressure drop across the absorber to decreased to below 1-in water. However, it should be noted that the exponential decrease in the beginning of Test Condition #1A occurred with no back pulsing. After a single quick pulse, pressure drop went below 1-in water and remained there, although additional pulses from time to time were required. SO_2 removal efficiency gradually steadied to 85.7%.

B. MBCUO-9

MBCUO-9 was the second test series for the 1/8-in diameter ALCOA sorbent. Natural gas firing and coal firing were both used to produce flue gas at separate test conditions. Absorption process parameters studied were sorbent flow rate and SO₂ spike level. Sorbent residence time in the regenerator was fixed at 3 hours, because sorbent regeneration appeared unsatisfactory during MBCUO-8 with 2 hours sorbent residence time. Figure 2 shows the pressure drop and sulfur dioxide removal efficiencies with time for selected periods in MBCUO-9.

Specifics of this test follow. Reduced data are shown in Table 6. <u>MBCUO-9-1</u>: 2/22-23/96 Natural gas firing The SO₂ removal was 84.8% at this baseline condition. Pressure drop across the absorber was in the range of 0.8 to 1-in water. <u>MBCUO-9-2</u>: 2/23-24/96 Natural gas firing Sorbent flow rate was increased from 0.75 lb/min to 1 lb/min, resulting in increased SO₂ removal (from 84.8% to 92.6%) with a corresponding decrease in sorbent utilization (from 59% to 49.2%). <u>MBCUO-9-8</u>: 2/25-26/96 Coal firing

At 1 lb/min sorbent feed rate and at constant back pulsing, 92.2% SO_2 removal efficiency was reached. Pressure drop across the absorber bed and across the outlet screen were both below 1-in water with constant back pulsing.

MBCUO-9-5: 2/26-27/96 Coal firing

Sorbent feed rate was increased from 1 lb/min in MBCUO-9-8 to 1.5 lb/min. At the same time natural gas flow rate to the regenerator was increased from 0.6 lb/hr to 0.8 lb/hr. SO_2 removal increased from 92.2% to 97.8%. Pressure drop of less than 1-in water was maintained across the absorber and across the outlet screen with constant back pulsing.

<u>MBCUO-9-9</u>: 2/27-28/96 Coal firing

After the SO_2 spike level was increased from 2050 ppm to 3000 ppm, the SO_2 removal decreased from 98.7% to 93.2%.

MBCU0-9-10: 2/28-29/96 Coal firing

In this test condition, sorbent feed rate was reduced to 0.75 lb/min, producing a SO₂ removal of 72.8% as compared to the previous 93.2%.

<u>MBCUO-9-7</u>: 2/29-3/1/96 Natural gas firing

The objective of this test condition was to return to the baseline (MBCUO-9-1) by terminating coal firing. SO_2 removal of 86.6% was achieved, which was comparable to the baseline removal of 84.8%.

C. MBCUO-10

This test series concentrated on a study of sorbent regeneration parameters. Parameters studied included sorbent residence time in the regenerator, natural gas regenerant flow rate, and regeneration Sorbent flow rate was maintained at 0.75 lb/min temperature. throughout this test series. A batch of 322 lbs of fresh ALCOA sorbent was regenerated prior to the formal beginning of this test series. The regenerated sorbent was used as make-up required by attrition. Test Condition #1, MBCUO-10-1, was a repeat of baseline conditions MBCUO-9-1 and MBCUO-9-7. This was followed by Condition #3 in which the regenerant to sulfur equivalence ratio was decreased from about 2 to 1.37. In Condition #4, the regeneration time was reduced from 3 hours to 2 hours. In Condition #5, the temperature of the regenerator was reduced to $800^{\circ}F$ but with increased sorbent regeneration time and regenerant to sulfur molar ratio. In condition #7, regeneration time was reduced to 1 hour with reduced regenerant to sulfur ratio but at a higher (850°F) regeneration temperature. This was followed by coal firing in Conditions #8A and #8C at the baseline condition parameters. Figure 3 shows the pressure drop and sulfur dioxide removal efficiencies with time for selected periods in MBCUO-10.

Specifics of this test follow. Reduced data are in Table 7. <u>MBCUO-10-1</u>: 3/21-22/1996 Natural gas firing At this baseline condition, sulfur dioxide removal was 86.4% and agreed very well with other baseline periods (MBCUO-9-1 and MBCUO-9-7 with 84.8% and 86.6% SO₂ removal efficiencies, respectively). Absorber pressure drop remained low at less than 1-in water. <u>MBCUO-10-3</u>: 3/22-23/1996 Natural gas firing

The regenerant to sulfur equivalence ratio was reduced from 2 to 1.37 while other test parameters remained unchanged. SO_2 removal efficiency dropped from 86.6% to 84.8%. Excess methane concentration in the regenerator off-gas dropped from 14% in MBCUO-10-1 to 6% in MBCUO-10-3.

<u>MBCUO-10-4</u>: 3/23-24/1996 Natural gas firing

Sorbent regeneration time was reduced from 3 hours to 2 hours for this condition. Other test parameters remained constant. SO_2 removal efficiency increased to 87.1% from 84.8%. This result was contrary to our expectation that shorter sorbent residence time in the regenerator should produce a poorer regenerated sorbent, and this in turn should produce a poorer effective sorbent in the absorber.

<u>MBCUO-10-5</u>: 3/24-25/1996 Natural gas firing

The regenerator temperature was decreased to $800^{\circ}F$ but at increased natural gas to sulfur equivalence ratio (from 1.27 to 2) and regeneration time (from 2 hours to 3 hours). SO₂ removal was 83% compared with 87.1% removal in MBCUO-10-4.

<u>MBCUO-10-7</u>: 3/26-27/1996 Natural gas firing

The regeneration temperature was $850^{\circ}F$ at a 1 hour sorbent residence time and a natural gas to sulfur equivalence ratio of 1.37. The SO₂ removal was 82% compared to 87.1% SO₂ removal at 2 hr regenerator residence time.

<u>MBCUO-10-8A</u>: 3/27/1996 Coal firing

The baseline condition, MBCUO-10-1, was repeated but this time with coal firing as compared with natural gas firing. The average SO₂ removal of 86.5% was obtained with constant back pulsing versus 86.4% during MBCUO-10-1, which was with natural gas firing. Pressure drop across the absorber under continuous back pulsing was about 1-in water.

<u>MBCUO-10-8B</u>: 3/27-28/1996 Natural gas firing

To establish the upper limit of sulfur that can be retained on the sorbent, a slot of time was allocated to try to fully sulfate the sorbent in the absorber. If the sulfur on the sorbent exceeds the theoretical amount that can be retained in the form of copper sulfate, then it may be speculated that the excess sulfur could be in the form of aluminum sulfate. During this period, the sorbent circulation in the LCTS was stopped. Flue gas from natural gas firing was spiked with 2250 ppm SO₂. After 6 hours of sulfation the sorbent was still not saturated. The flue gas at the absorber exit contained about 90% of the inlet SO₂ concentration.

<u>MBCUO-10-8C</u>: 3/28-29/1996 Coal firing

The objective of this period was to return to the baseline condition. Constant back pulsing was employed on the absorber. After 10 hours of operation the SO₂ removal was 84.5%.

V. DISCUSSION OF CHEMISTRY RESULTS FROM LCTS OPERATION

A summary of sorbent performance and operational performance of the LCTS is presented in Table 4 for the absorption and regeneration parametric studies. A similar study was conducted with a 1/16-in

diameter sorbent using spiked flue gas from natural gas combustion [1]. However, in the present study, some testing periods were conducted to confirm an adequate performance with the larger sorbent and to validate the design of the modified absorber while burning coal. The absorber bed had dimensions of 8-ft height, 1-ft width, and 5-in depth throughout the testing. Periodically during the parametric testing, a baseline condition was repeated to assure that the activity of the sorbent, as well as the operational response of the LCTS, was maintained. The parameters and calculated quantities in the tables represent the average of the data or calculation over a designated steady-state period. Nitric oxide was injected after certain test period conditions attained steady-state, followed by ammonia injection to reach a desired level of NO_x removal. During coal combustion, spiking with NO was not necessary. (For a more detailed discussion of the data reduction procedure, please see references [1] and [2].)

A. Effect of Coal-Firing versus Natural Gas-Firing

From Figure 1, when the system is operated during coal firing without pack pulsing, the pressure drop in the absorber increases and a corresponding decrease in SO_2 removal occurs. Most likely, as the fly ash accumulates in the bed, a decrease in the effective cross-sectional area proceeds.

For steady-state conditions, the SO_2 removal was not significantly impacted when flue gas produced from coal firing was substituted for that produced from natural gas firing. This is apparent if periods MBCUO-9-2 and MBCUO-9-8 are compared or periods MBCUO-10-1, MBCUO-10-8A and MBCUO-10-8C are compared. (See Table 4.) Note that the SO_2 inlet concentration is reported on a dry basis, and to maintain an equal flux of SO_2 between both fuel burning cases, an adjustment was made for a change in moisture content in the flue gas due to fuel substitution. Typically during coal combustion, an increase in absorber pressure drop was experienced due to fly ash accumulation in the bed and/or on the screens, but either continuous pulsing or a pulse after a certain pressure drop was obtained (similar to a baghouse operation) reduced the pressure drop. Data in these cases were averaged at steady state at the low pressure drop during a continuous pulsing operational mode.

B. Absorption Study

During the absorption study in Tests MBCUO-8 and MBCUO-9, the regeneration parameters were typically held at $850^{\circ}F$, a residence time of 180 min, and a natural gas-to-sulfur molar ratio of at least 1. The effects of inlet SO_2 concentration and sorbent flow on the pollutant removal efficiencies in the absorber were systematically investigated. A temperature scan was not conducted since past investigations with copper oxide indicated the optimum temperature of absorption is near $750^{\circ}F$.

The last three periods in MBCUO-8 were not used in the following comparisons since it was felt that the temperature of regeneration

was substandard and thus the regeneration of the sorbent was in question. Residual sulfur content on the sorbent appears to confirm this assumption (see Tables 2 and 4). Inexperience in operations with the 1/8-in diameter sorbent led to poor fluidization, if any, in the fluidized-bed heater and thus the low temperatures within the regenerator.

Absorber model predictions were also compared to the actual SO2 removals at a set of conditions. In general, the 1/8-in diameter sorbent spheres appeared to exhibit more resistance to regeneration compared with the 1/16-in diameter sorbent used in tests prior to MBCUO-8. Tables 2 and 4 show that residual sulfur in regenerated sorbent ranges from about 1.3% to 2% at the regenerator conditions The residual sulfur is about 0.8% higher than when the tested. 1/16-in diameter sorbent was used under similar test conditions. In addition, Dr. Sheila Hedges of PETC reported that the rate constant of a similarly impregnated copper oxide/alumina 1/8-in diameter sorbent is 60% of that obtained from a 1/16-in diameter sorbent [4]. Thus, the absorber model of Young and Yeh [5] has been modified by (1) assuming that 0.8% of sulfur is not regenerable in the 1/8-in diameter sorbent, and (2) the sorbent rate constant is 60% of the 1/16-in diameter sorbent due to pore (Please caution that the 1/16-in diameter diffusional effects. sorbent rate was previously obtained using a UOP sorbent and some differences may exist with the present sorbent.) The resultant model predictions of the absorber performance are listed in Table 4, and the modified model reasonably predicted the absorber performances.

The impact of the inlet flue gas SO_2 concentration was investigated. Essentially, as the SO_2 concentration increases, the effective Cu/S feed ratio decreases, thus causing a decrease in SO_2 removal efficiency. Results can be seen in Table 4 when periods MBCUO-8-5, MBCUO-9-1, and MBCUO-9-10 are compared at the lower sorbent flow rate of 0.75 lb/min, and when periods MBCUO-9-5 and MBCUO-9-9 are compared at the sorbent flow rate of 1.5 lb/min. The concentration levels of SO_2 were nominally 1500, 2250, and 3250 ppm on a dry basis and simulate the concentrations in flue gas when a mid- to high-sulfur coal is combusted. A comparison of these experimental results and the model predictions for a 0.75 lb/min sorbent flow rate is seen in Figure 4.

The effect of changing the sorbent flow on the SO_2 removal efficiency was also investigated. Effects of varying the sorbent flow can be seen at two different inlet gas SO_2 concentration conditions. The first is at a nominal 2250 ppm inlet concentration for periods MBCUO-9-1, MBCUO-9-2, and MBCUO-9-5; SO_2 removals increased with increasing sorbent flow. The second is at a nominal 3000 ppm inlet SO_2 concentration for periods MBCUO-9-9 and MBCUO-9-10. The trend is the same indicating that a higher sorbent flow of regenerated sorbent will enhance the SO_2 removal efficiency of the absorber. Figure 5 depicts actual experimental data versus model

predictions.

Several additional items should also be noted with respect to these absorption tests. A return to the baseline conditions after a duration of time (periods MBCUO-9-1 and MBCUO-9-7) indicated that no decrease in sorbent activity occurred during the testing. Also, the reactivity of the sorbent was not impacted when flue gas produced by coal combustion was substituted for that produced by natural gas combustion (periods MBCUO-9-2 and MBCUO-9-8). The revised sulfation model predicted the SO_2 removals quite well as seen in Table 4. Also, NO_x removals were around the designed levels of 90% and 95% as seen in Table 4.

C. Regeneration Study

A regeneration study (MBCUO-10), summarized in Table 7, investigated the effects of temperature, residence time, and natural gas-to-sulfur molar ratio on regeneration. Constant nominal absorption conditions of 110 scfm of flue gas, 750°F, 0.75 lb/min sorbent flow, and 2250 ppm inlet SO₂ concentration were maintained. The effect of temperature can be seen in periods MBCUO-10-1 and MBCUO-10-5 where a $50F^\circ$ drop in temperature decreases the effectiveness of regeneration, as depicted in the larger concentration of methane in the off-gas and a decrease in absorber SO₂ removal. The impact of sorbent residence time was studied at constant natural gas-to-sulfur ratio and temperature in periods MBCUO-10-3, MBCUO-10-4, and MBCUO-10-7. Although the results appear similar at residence times of 180 min and 120 min, the effectiveness of regeneration diminishes below a residence time of 120 min as determined by an increase in regenerator outlet CH_4 concentration, a decrease in SO_2 removal in the absorber, and an increase in residual sulfur on the sorbent. The influence of natural gas-to-sulfur molar ratios can be determined by comparing periods MBCUO-10-1 and MBCUO-10-3, where the larger ratio condition resulted in the outlet gas diluted with methane. At these two particular ratios, the impact on the overall capacity of the sorbent for SO₂ removal was minimal.

D. Sulfur Balances

Gas phase sulfur balances for the periods in MBCUO-8, MBCUO-9, and MBCUO-10 are shown in Table 8. Steady-state SO_2 removal in mol/hr from the absorber is compared with the steady state regenerator SO_2 off-gas in mol/hr. These gas phase sulfur balances are reasonably good with about 75% of the data within a 10% error range.

Table 8 also compares the solid phase sulfur balance with that from the gas phase balance in the absorbers for the steady-state periods from the three tests. While the error was high for 4 out of 9 test periods in MBCUO-8 and MBCUO-9, the sulfur balances were excellent in MBCUO-10 (less than +/- 10% in error).

VI. ABSORBER PARTICULATE REMOVAL RESULTS

A. Effect of Retention Screen Design and Sorbent Size

Findings of the absorber modification changes with two different sorbent sizes are listed in Table 9. For all the test periods reported in this table, flue gas flow was obtained from natural gas

firing of the combustor. The total pressure drop across the 5-in thick bed was the largest with the old retention screen design (2.5-in of water) as compared to the new design (1.4-in of water). The screen substitution did not impact the SO₂ removal but did successfully lower the pressure drop across the absorber. Α benefit in going to the larger-sized sorbent is realized by observing the decrease in pressure drop from 1.4 to 1.0-in of water. It is also noteworthy that the sorbent reactivity of the smaller sorbent -- as depicted by the SO, removal -- was greater than the larger material. If the assumption is made that the copper reactivity is similar for both sorbents, then these results could indicate that pore diffusional resistance is greater for the larger sorbent. Also, it must be mentioned that the difference in SO₂ removals between the larger and smaller sorbents is not too Although one contribution to the difference may be large. diffusional limitations, it must be realized that because the ALCOA sorbent has a larger bulk density, the residence time within the reactor volume is greater for the ALCOA sorbent. The greater sorbent residence time would enhance SO₂ removal.

B. Coal-Firing and Pressure Drop Effects

Figure 1 shows a comparison between two tests at the same operating conditions but with a different sorbent size (MBCUO-7: 1/16-in sorbent versus MBCUO-8: 1/8-in sorbent). Under natural gas firing, the smaller sorbent has the better SO_2 removal capability. Under coal-firing, two methods of pulsing were conducted: a dead-band pulsing that typically let the bed pressure drop grow to about 6-in water before pulsing to obtain a maximum of 3-in water; and a continuous pulsing of the bed every 30-sec. Steady-state conditions under coal burning were typically obtained during the latter type of pulsing. As can be seen in the dead-band pulsing, as the pressure drop across the bed increases, the SO_2 removal efficiency decreases with time. Pulsing returns the pressure drop to the initial condition obtained under natural gas firing. From the bottom of Figure 1 it should be noted that once coal is shut off and natural gas firing then initiated, the pressure drop will decrease because fly ash that was in the bed is transported out of the bed due to the sorbent flow.

Similar pressure drop and sulfur dioxide removal relationships with time are seen in MBCUO-9 and MBCUO-10 (see Figures 2 and 3, respectively). Under coal firing, continuous pulsing keeps the pressure drop across the bed at the same level as if natural gas were burned. Dead-band pulsing was successful in returning the pressure drop to the initial condition obtained under natural gas firing. In MBCUO-9, it is interesting to note that dead-band pulsing at two different sorbent flows (1.0 and 1.5 lb/min) indicated that as the sorbent flow increased, the frequency of the pulsing decreased. About 2.5 hours per pulse was needed at 1.0 lb/min versus 4 hours per pulse at 1.5 lb/min. This effect -- ash removal as a function of ash loading and sorbent flow rate -- is more dramatic in the most recent testing in MBCUO-11 and MBCUO-12.

An assessment of the absorber (with the bar screen design) to remove ash in coal-combusted flue gas was also investigated during MBCUO-9 parametric testing using 1/8-in ALCOA sorbent. A baseline test condition utilizing natural gas firing was initially established, followed by four test conditions with coal firing, concluding with a return to the baseline condition with natural gas (see Figure 2). Several methods of back-pulsing the bar screens Differential pressure profiles across the were investigated. absorber (see Table 10) were obtained to aid in identifying the mechanism of ash accumulation within the absorber. The total pressure drop across the absorber (including the front bar screen, sorbent bed, and rear bar screen) was obtained. (Locations of pressure taps can be found in reference [1].) Pressure drop across the rear screen at three different bed heights was measured. Under coal firing, pressure drop would typically grow in the absence of back-pulsing and the SO2 removal would degrade, indicating that some blinding of the bed due to ash/sorbent was occurring. Once the system was briefly pulsed, the SO₂ removal would quickly spike upward and the pressure drop would decrease. If continuous pulsing was enacted, the pressure drop would remain low and constant with time.

Inspection of data in Table 10 reveals several observations. First, a baseline condition with no ash present results in an overall pressure drop of 0.8 to 1-in water across the absorber. The rear screen accounts for the majority of the pressure drop and is relatively uniform from top to bottom in the absorber. Second, once ash is introduced and no pulsing is enacted, the pressure drop across the rear screen grows non-uniformly. Typically during this "pre-pulse" stage, the rear screen pressure drop is lowest at the bottom and highest at the top. Interpretation of this gradient is difficult because two phenomena can simultaneously occur. High pressure drop could imply high velocity gas through the bed, and it could imply reduced cross-sectional area due to blinding. Without independent velocity measurement, a definitive cause cannot be concluded. Third, the system quickly responds to pulsing (a "postpulse" stage) with pressure drop returning to about 1-in water. Continuous pulsing (30 second interval between pulsing consecutive chambers) is denoted as "profile" stage, representing the steady state condition under which the absorber is eventually sampled for gas and sorbent composition. At the conclusion of the coal tests, a return to the natural gas baseline condition resulted in similar pressure drop and SO₂ removals encountered at the beginning of the test (MBCUO-9-1).

C. Solids Recoveries and Particle Size Distributions Bulk solid (dust) balances for various selected periods during the testing are shown in Table 11. Table 12 lists overall solid balances for the entire tests. From this tabulated information, most of the solids appeared in the baghouse from the fluid-bed heater. However, it must be remembered that these balances considered total solids collected and did not distinguish between ash and sorbent fines.

However, ash balances that did consider the sorbent fines present have been calculated for periods in MBCUO-8, MBCUO-9, and MBCUO-10, and are shown in Tables 13, 14, and 15, respectively. Table 16 shows selected periods for sorbent/ash distribution. During coal burning, ash/sorbent fines will accumulate in various vessels: the bottom ash pit to the furnace; the ash hopper on the inlet to the absorber; the ash hopper on the outlet to the absorber; the flue gas baghouse on the exit of the absorber; the baghouse on the heating gas outlet to the fluidized-bed heater; and the cyclone on the fluidized-bed cooler outlet. These vessels were periodically drained, and the collected material was weighed and sampled. Samples were then analyzed for copper content with the intent of distinguishing between coal ash and attrited sorbent.

From the data in the tables, material recoveries were poor, especially from tests MBCUO-9 and MBCUO-10. Inspection of the baghouses after MBCUO-10 revealed that the filter bags in the baghouse on the outlet line from the fluidized-bed heater had holes, possibly explaining the poor solids recoveries. If the assumption can be made for the MBCUO-8-3 period balance that the filters were not damaged, it then appears that the absorber removed roughly 50% of the fly ash and the remaining 50% flows through the absorber and is collected in the flue gas baghouse. New filter bags have replaced the damaged fluidized-bed heater bags prior to test MBCUO-11, which used a 12-in depth absorber. Also, the flue gas baghouse passed an inspection of its bags.

For the MBCUO-10 test period, particle size distributions were found with a Micro-Trac Analyzer for solids obtained from the various hoppers. From this photo-electric technique, an average diameter of the particles can be determined based on the number of particles present. The assumption is that the particles are present as spheres, and the diameter is calculated as a ratio of the volume to outer surface area. The maximum sphere diameter is 300 micron. Results from the hoppers are as follows: the absorber flue gas baghouse -- 7.6 micron; the fluidized-bed heater baghouse -- 54 micron; the fluidized-bed cooler cyclone -- 38 micron; and the absorber inlet ash hopper -- 24 micron. This technique was not able to be performed on the absorber outlet ash hopper since particles greater than 300 micron were present. After seiving and on a weight basis, 89.4 wt % of the particles were between 250 to 1000 micron diameter. These larger diameter particles were most likely sorbent particles that were pushed through the screens in the absorber and then fell to the bottom of the absorber vessel exit. The high copper loading in Table 15 would tend to confirm this. It should also be noted that the samples from the fluidizedbed heater baghouse also had high copper content indicating that some of the attrited sorbent ends up in this vessel.

VII. SORBENT ATTRITION A. Overall Attrition Rates

During testing, sorbent was typically added on an as-needed basis by observing the pressure drops in the fluidized-bed heater and coolers. Sorbent make-up, that had been activated by reducing it in a batchwise regeneration, was added to the fluidized-bed cooler. In this manner, the total amount of sorbent that was added during a test could be determined, and this is directly related to the attrition. Table 17 summarizes the sorbent attrition information
for the three tests. After MBCUO-10, the absorber was drained and samples were taken and later sieved. The average particle size distribution for the sorbent was as follows:

Size Range, in	Wt% of Total
0.0930 <x< td=""><td>79.1</td></x<>	79.1
0.0469 <x<0.0930< td=""><td>17.5</td></x<0.0930<>	17.5
0.0394 <x<0.0459< td=""><td>1.72</td></x<0.0459<>	1.72
0.0278 <x<0.0394< td=""><td>0.96</td></x<0.0394<>	0.96
x<0.0278	0.65

Mass distribution of dust collections among flue gas baghouse, fluid-bed heater baghouse, fluid-bed cooler cyclone, absorber inlet and outlet pots, and furnace pots can be found in Tables 13, 14, and 15. An attempt was made to compare the sorbent make-up added during the test to the sorbent -- as found by copper analysis -- in these solids collection vessels. The sorbent recoveries in MBCUO-8 and MBCUO-10 were poor, possibly fortifying the finding of baghouse leakage on the fluidized-bed heater outlet.

B. Calculated Attrition Rates

1. Transport System

In the transport system, the sorbent flows from the bottom of the absorber into a transport hopper. Through a sequence of valve actions, the hopper with sorbent present is pressurized with air and then suddenly depressurized to pneumatically transport the sorbent about 35-ft vertically through a 3/4-in external diameter tube to the fluidized-bed heater. Earlier cold investigations of the system revealed that the transport of the sorbent causes part of the overall attrition.

Cold attrition transport studies were conducted with fresh ALCOA sorbent (from the as received drum), used ALCOA sorbent (from the absorber after MBCUO-10), and the substrate. The initial nominal size of the materials used was 1/8-in diameter. The following procedure was used for this testing:

1. Approximately 10-lb of sorbent was sieved through a 0.093-in sieve. The sieve size is about 75% of the 1/8-in nominal diameter of the sorbent sphere. Only the material remaining on the screen was used for the test.

2. The bulk density of sieved sorbent was determined using a 1000ml graduated cylinder.

3. A baghouse bag was weighed and attached to the outlet of the transport pipe.

4. The transport pressure was set to 12 psig at the regulator. A later test increased this pressure to 15 psig.

5. Four thousand ml of sieved sorbent was weighed and poured into the transport hopper inlet pipe.

6. Two shots of sorbent were sent through the transport system.

7. The sorbent was emptied from the bag and sieved through a No. 25 sieve (0.0278-in opening). The sieve size is near the 0.030-in opening in the absorber retention screen. Fines and sorbent were weighed. The sorbent was returned to the hopper inlet pipe.

8. Steps 6-7 were repeated for a total of 10 transport cycles.

9. After the tenth cycle, the remaining sorbent in the inlet pipe was sent.

10. The sorbent was collected and sieved. The fines, bag, and sorbent were weighed.

Table 18 lists the results of the attrition transport testing that was conducted at room temperature. Several conclusions and observations can be made. First, prior to the testing, the amount of smaller-than-normal sorbent in the used sorbent is much greater than in the substrate batch or in the fresh sorbent batch. Visually, a large portion of the used sorbent that passed through the 0.093 mesh looked to be spheres smaller that the fresh sorbent. Second, the total sorbent fines < 0.0278-in was greatest for the used sorbent. Third, the amount of fines as a function of transport cycle appeared to increase with cycle for the used sorbent as compared to the substrate or new sorbent. And fourth, as has been seen in past attrition transport testing, the rate of attrition was higher at the increase transport pressure.

2. Fluidized-Bed Vessels

With the increased size and density of the 1/8-in ALCOA sorbent as compared to the earlier 1/16-in sorbents, a higher minimum fluidization velocity was needed in the heating vessel and the cooling vessel. It was intuitive that sorbent attrition would be greater at the higher velocity. Two test were conducted to quantitatively identify the attrition rates in these vessels. The first was a cold test of the used 1/8-in ALCOA sorbent that was removed form the absorber following MBCUO-10. The second was a hot test using sorbent also from after MBCUO-10. Both tests were conducted in the fluidized-bed cooler (FBC).

Cold Test

The following procedure was used in the cold testing:

1. The FBC was drained via the drain valve. The FBC blower was started to agitate the remainder of sorbent in the FBC. The FBC was drained again. The process was repeated until no sorbent was removed after an agitation cycle.

2. The FBC blower was run at full flow (7.2 ft/s gas bed velocity) for five minutes to clear the vent line.

3. The sorbent dust was drained from the FBC cyclone, located on the vent line.

4. Used sorbent was sieved to give 40-lb retained on 0.093-in mesh. This sorbent was weighed and added to the FBC.

5. The FBC blower was operated at full flow (7.1 ft/s bed velocity). Twice during the test a motor overload caused the gas velocity to either terminate or flow at a reduced velocity (4.2 ft/s).

6. The remaining sorbent in the FBC was drained (as per step 1) and weighed on the balance. The sorbent was sieved through 0.0278in and 0.093-in sieves and the splits weighed.

7. The dust from the FBC cyclone was removed and weighed.

Hot Test

The procedure used for the hot test was identical to the previous cold FBC attrition test (above), with the following exceptions:

1. The FBC was operated at 8.3 ft/s gas bed velocity and at a sorbent bed temperature of 1000° F. These conditions simulate those of the actual operation in either the fluidized-bed cooler or the fluidized-bed heater.

2. The attrition test lasted a total of 39 hours at the above flow rate and temperature.

3. After running at the above conditions, the FBC was operated at minimum flow (4.2 ft/s) while the sorbent cooled (for approximately 3.5 hours).

Table 19 lists the results of both the cold and hot attrition testing in the fluidized-bed cooler. From the cold FBC results, first, in 36.3 hours of operation at 7.1 ft/s, the inventory of whole sorbent particles was reduced to 51.2% of the initial value. The sorbent lost over the test was 30.4% of the initial charge. Translated to actual operation, the apparent attrition via the FBC is 0.33 lb/hr. Second, 93.7% of the sorbent loaded into the system was recovered. Assuming the difference was lost through the FBC cyclone, the cyclone efficiency was 79.4%. Third, the bed differential pressure was reduced from 18.7-in H₂O to 13.8-in H₂O This reduction in differential pressure (26.2%) correlates nicely with the loss of sorbent weight in the FBC (30.4%).

Similar results were found after the hot test in the FBC, although the attrition was not as great as during the cold test. First, in 39 hours of operation, the inventory of full sorbent particles was reduced to 66.6% of the initial value. The sorbent lost over the test was 18.1% of the initial charge. Translated to actual operation, the apparent attrition via the FBC is 0.185 lb/hr. Second, 91.5% of the sorbent loaded into the system was recovered. A moisture analysis of the sorbent will be required to determine the cyclone efficiency, as drying was sure to have taken place in this test. Third, the bed differential pressure was reduced from 18.3-in H₂O to 15.3-in H₂O. This reduction in differential pressure (16.4%) correlates nicely with the loss of sorbent weight in the FBC (18.1%).

C. Comparison of Attrition Rates

An attempt was made to combine the attrition rate in the transport system with that in the fluidized-bed vessels and compare this number with the actual rate for each test found in Table 17. The attrition contribution from the transport system was derived from the last column from Table 18, 5.58-gm/cycle. From the fluidizedbed cooler or the fluidized-bed heater, the contribution was determined from the hot test: 0.185-lb/hr each or 0.37-lb/hr for both vessels. From Table 17 and by using the cycles and hours per test, the transport system contributions for MBCUO-8, MBCUO-9, and MBCUO-10 were 0.10, 0.15, and 0.12 lb/hr, respectively. Adding the fluidized-bed vessels donation to the transport system gives the following for MBCUO-8, MBCUO-9, and MBCUO-10: 0.47, 0.52, and 0.49-1b/hr. respectively. Comparison with the attrition values in Table 17 reveal that the calculated rate for MBCUO-8 was higher than the actual but in the latter two tests, the calculated was lower than the actual. For MBCUO-8, little or no fluidization occurred in the fluidized-bed heater due to inadequate gas velocity through the bed (see Table 5). Thus the attrition due to this vessel was low. For MBCUO-9 and MBCUO-10 the calculated rates are lower than the actual. Explanations for this could be a) an underestimation in the rate calculated for the fluidized vessels; b) as the sorbent ages, it gets smaller and may escape through the absorber sorbent retention screens; and c) a rate underestimation in the transport tests since the tests blew the sorbent into a bag, whereas during actual LCTS operation, the sorbent probably impacts in the fluidized-bed heater vessel. In any event, the contribution of the fluidized vessels is a significant one relating to the attrition rate and was found to be larger than the contribution from the transport system.

VIII. MISCELLANEOUS

Copper oxide/alumina sorbent is known to remove SO_2 from flue gas, and thermodynamically it is purported to more readily remove SO_3 from the flue gas. However, measurements have not been conducted in the past to determine this.

An attempt to measure any SO_3 removal capability of the sorbent was conducted during MBCUO-10. EPA Method 8 for determination of SO_3 in flue gas was used as a basis. In this method, isopropanol was used as the impinger solution. The solution was analyzed using an ion chromatograph.

Samples were obtained immediately before and after the absorber. A probe was not inserted into the flue gas but rather a slip stream was sampled. Results indicated that while under coal burning, the combustor produced about 5.6 ppm SO₃ and the flue gas exiting the reactor contained 0.64 ppm on a dry basis, yielding a removal of about 90%. It must be **cautioned** that only one sample was obtained at each sampling location. However, the trend was that SO₃ was removed across the reactor of sorbent.

IX. SUMMARY

A parametric study of the Moving-Bed Copper Oxide Process was conducted with 1/8-in sorbent in the LCTS. The effects of various parameters on the absorption and regeneration steps of this flue gas cleanup technique were systematically investigated. High removals of SO₂ were obtained at most conditions. A decrease in the inlet SO₂ concentration or an increase in the sorbent flow rate enhanced the SO₂ removal capabilities of the absorber.

Regarding regeneration, a high temperature or a large residence time has a major influence on the regeneration of the sorbent. A new absorber design facilitates the use of particulate-laden flue gas in the current bed configuration.

X. REFERENCES

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Table 1. Batch Activation During Testing Era

Test No.	Date	Amount	of Sorbent lbs	Sorbent	Sulfur Wt%	Content
MBCUO-8	1/15/96	55 (entire	0 inventory circ	ulated d	1.2 uring ac	tivation)
MBCUO-9	2/20/96	65 (batch	1 activation)		1.8	
MBCUO-10	3/18/96	32 (batch	3 activation)		1.75	

Table 2. Analysis of Sorbent Samples

St, Cut, Cit In Solden Samples (ALCOA S	SOKPENT)	
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МВ8	S%/Cu%	MB9	S%/Cu%/Cl	MB10	5%/Cu%
-5-P2 (reg top port) NG 1/21/96	3.3	-1-P2 (reg top port) NG, 2/23/96	3.65	-3-Reg-out-hop NG, 3/23/98	1.5
-5-Reg-out-hopper	1.65	-1-P1 (reg bottom port)	2.35	-3-Trans-hop	3.36
-5-Trans-hopper	3.27	-1-Reg-out-hop	1.76/6.7	-4-Reg-out-hop NG, 3/24/94	1.37
-5-ASV391	2.23	-1-Trans-hop	3.75/6.2	-4-Trans-hop	3.34
-5-ASV397	2.03	-1-ASV397	4.01	-4-ASV391	1.5
-1-Reg-out-hop NG, 1/23/96	2.01	-1-ASV391	2.24	-4-ASV397	3.05
-1-Trans-hop	3.67	-2-P2 NG, 2/24/96	3.85	-4-Reg-top-port	2.84
-1-ASV391	2	-2-P1	3.33	-5-Reg-out-hop NG, 3/25/96	1.55
-1-ASV397	3.95	-2-Reg-out-hop	1.51/6.6	-5-Trans-hop	3.5
-1-P2 (Reg top port)	2.9	-2-Trans-hop	3.13/6.6	-5-ASV392	1.81
-3-Reg-out-hop Coal, 1/25/96	1.68	-2-P3 (reg bottom port)	2.72	-5-ASV397	3.21
-3-Trans-hop	3.24	-8-P1 Coal, 2/26/96	3.33	-5-Reg-bottom-port	2.17
-1A-Reg-out-hop NG, 1/26/96	2.06/6.5	-8-P2	3.15	-7-Reg-out-hop NG, 3/27/96	1.8
-1A-Trans-hop	3.97/6	-8-P3 (reg top port)	3.19	-7-Trans-hop	3.51
		-8-Reg-out-hop	1.36	-88-ASV391 Coal, 3/28/96	1.3
		-8-Trans-hop	3.07	-8B-ASV392 (batch sulfation in 8B)	4
		-5-Reg-out-hop Coal, 2/27/96	1.5/7.2	-8B-ASV393	4.3
· ·		-5-Trans-hop	3.16/6.5	-88-ASV394	4.3
		-9-Reg-out-hop Coal, 2/28/96	1.45	-8B-ASV395	4.5
		-9-Trans-hop	3.98	-8B-ASV396	4.1
		-10-Reg-out-hop Coal, 2/29/96	1.33	-8B-ASV397	4
		-10-Trans-hop	3.14		
		-7-Reg-out-hop NG, 3/1/96	1.8		
		-7-Trans-hop	3.5/6.2/LT 0.1%		

SAMPLE	INNE	R CORE	OUTER SHELL			
	I Cu 2p/I Al 2s	I S 2p/I Al 2s	I Cu 2p/I Al 2s	I S 2p/I Al 2s		
Fresh Sorbent #1	1.07	0.19	37.5	2.93		
Newly Activated - 1/20/96	0.68	0.02	1.08	0.08		
MB9-7-Transport - 3/1/96 Natural Gas Firing	1.36	0.16	1.40	0.43		
MB9-8-Transport - 2/26/96 Coal Firing	1.39	0.13	1.19	0.52		
MB9-10-Transport - 2/29/96 Coal Firing	1.52	0.07	0.81	0.33		

Table 3. XPS Results

1/8" bead 5" bed	fuel	F.G. scfm	sorbent feed #/min	absorber temp °F	SO2 inlet ppm	SO2 removal eff% experiment	SO2 removal eff% model	NO _x inlet ppm	NO _x removal eff%	Regener resid. time, min	Regener temp ⁰F	NG #/hr	NG/S mol ratio	Total sulfur in regenerated sorbent,%	Absorber pressure drop, in WC	Back pulsing
8-5	NG	107.5	0.75	747	1529	95.5	94.6	na	na	120	850	0.4	1.15	1.65	0.85	
8-1	NG	109.4	0.75	750	2246	86.8	79.4	499	95.7	120	850	0.6	1.15	2.01	1	
8-3	Coal	109.6	0.75	747	2087	77.1	86.9	512	95.4	120	850	0.6	1.16	1.68	5.06	no
8-1A	NG	109.3	0.75	787	2273	85.7	77.1	na	na	120	850	0.6	1.15	2.06	0.91	
9-1	NG	108.7	0.75	747	2259	84.8	85.1	na	na	180	850	0.6	1.15	1.76	0.85	
9-2	NG	108.8	1	747	2291	92.6	94.5	528	93.7	180	850	0.6	1.14	1.51	0.92	
9-8	coal	108.4	1	766	2048	92.2	95.9	574	93.9	180	850	0.6	1.14	1.36	0.9	constant
9-5	coal	111.3	1.5	747	2042	97.6	97.3	516	94	180	854	0.8	1.33	1.5	0.75	constant
9-9	coal	107.6	1.5	762	2985	93.2	95.8	588	87.9	180	850	0.8	0.92	1.45	1.05	constant
9-10	coal	110	0.75	791	3004	72.6	78.3	524	94.3	180	850	0.8	0.92	1.33	1.36	constant
9-7	NG	100	· 0.75	747	2430	86.6	86.5	496	88.5	180	850	0.6	0.93	1.8	0.93	
10-1	NG	108.8	0.75	747	2246	86.4	85	na	na	180	850	0.6	1.16	na	1.07	
10-3	NG	109	0.75	747	2255	84.8	89.6	па	na	180	850	0.41	0.68	1.5	1.25	
10-4	NG	108.9	0.75	741	2240	87.1	91.9	па	na	120	850	0.41	0.68	1.37	1.63	
10-5	NG	108.8	0.75	739	2283	83.1	88.2	na	na	180	800	0.6	1.15	1.55	1.50	
10-7	NG	108.8	0.75	734	2242	82.0	84.5	na	na	60	850	0.41	0.68	1.8	1.81	
10-8A	coal	108.9	0.75	747	2051	86.5	na	635	96.7	180	850	0.6	1.14	NA	1.51	constant
10-8C	coal	108.9	0.75	738	2077	84.5	na	na	na	180	850	0.6	1.16	NA	1.79	constant

Table 4. Data Summary of Tests MBCUO-8, MBCUO-9, and MBCUO-10

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PROTECTED CRADA INFORMATION

Table 5

	PARAMETER	TAG	E/U	1	2		4
COMBUSTOR FLE				COMB075	COMB076	COMB077	COMB078
	COMB AR	FY-1 FY-3	#/HR #/HR	475.7	475.8	22.10	908.2
	NATURAL GAS	FY-20	#/HR	23.55	23.53	4.17	23.36
	FEEDERWT	WKT-26	#/HR L68	0.00	0.00	39.04	38.04
	EXCESS AR	BY-X	%XSA	20.04	20.16 \$18580	22.27 602686	24.20 617811
	FLUE GAS (M)	FY-16	#/HR	634.0	630.8	547.6	<u>641.1</u>
	FURNACE 02	AT-02-0 PT-6	H20	-0.97	-1.00	-1.01	-1.02
	COMB AIR P	PT-1 PT-1	PSIG	4.89	4.77	4.70 96.06	94.68
	NATURAL GAS P	PT-20	PSIG	4.16	4.15	4.67	4.14
	COOL H20 P	PT-25	PSIG	154.29	154.52	163.70	154.25
	THEOR AIR	BY-X AT-CO2-0	#THEOAIR PERCENT	396.29	395.97	395.65	393.13
	FURNACE CO	AT-CO-0	PPM	11.50	11.61	138.43	25.78
	FLUE GAS (V)	51-3 FY-18	SCFM	114.7	118.6	117.4	116.0
				ABSO89	A88090	ABS091	AB8092
ABSONDENTILE	INLET SO2	AT-802-1	PPM	1529	2246	2087	2273
	INLET NOX	AT-NOR-1 AT-02-1	PERCENT	4.30	4.35	3.43	4.69
	OUTLET SO2	AT-802-2	PPM PPM	67	293	473	320
	OUTLET 02	AT-02-2	PERCENT	4.49	4.60	3.64	4.83
	802 SPIKE	FT-102	#/HA #/HA	0.90	1.53	0.10	1.56
	NH3 SPIKE	PDT-18	#/HR H2O	0.000	0.123	0.139	0.000
	FLUE GAS (M)	FY-17	#/HR	501.7	510.4	511,3 7 55	509.8
	SCREEN DP	PDT-21	H20	0.64	0.77	4.67	0.69
	GAS INLET	TE-18 TE-21	DEGF	747	750	747 680	787
	SORB IN	TE-390	DEGF	695	722	682	698
	SO2 REMOVAL	SO2REF	PERCENT	96.6	86.8	77.1	85.7
	NOX REMOVAL	NOXREF FY-17	SCFM	6.0 107.8	95.7	95.4	4.0
				REGORE	REGORD	RE GO91	RE GOS2
REGENERATOR FILE	QUICK REP OS	AT-02-44	PERCENT	0.11	0.01	0.00	0.00
	REGEN 802	AT-802-4 AT-CH4-4	PERCENT	40.82	17.73	19.98	21.23
	REGEN CO2	AT-002-4	PERCENT	48.20	36.30	33.69	37.38
	REGEN 02	AT-02-48	PERCENT	0.47	0.11	0.01	0.00
	NATURAL GAS	FY-300 FY-310	#/HR #/HR	0.40	0.00	0.00	0.00
	REGEN P	PT-380	H20 INCHE8	2.00	11.66	1.14	4.76
	TSORB (27)	TE-381	DEGF	852	816	822	791
	TSORB (17) TSORB (32)	TE-383	DEGF	965	919	963	963
	TSORB (47)	TE-384	DEGF	945	902	947	964
	TOFFGAS	TE-386	DEGF	244	247	248	252
	T INC EX	TE-387 TE-200	DEGF	607	580	589	634
	INCIN 02	AT-02-6	PERCENT	18.84	18.61	18.77	18.65
				ERMORE	EBHORA	FBH091	F8H092
FLUID BED HEATERFILE	TSOR8(12)	TE-373	DEGF	1030	1079	1080	1061
	NATURAL GAS	FY-58 FY-30	#/HR #/HR	4.74	4.78	4.81	284.1
	FBH VEL	SY-30	FT/SEC	6.00	6.00	6.00 16.01	6.00
······	TAHTR OUT	TE-370	DEGF	1080	1113	1108	1101
	TSORB(24)	TE-372 TE-374	DEGF	992	992	980	986
	TVENT	TE-376	DEGF	778	826	822	837
	FBH PRES	PT-376	H2O	14.26			
	BED DP PLENUM DP	PDT-376 PDT-377	H20	44.4-	14.60	20.00	19.65
	FBH NOX		1120	18.28 10.48	14.60 12.73 12.73	20.00 13.06 14.46	19.65 13.04 15.39
		AT-802-1	PPM	18.28 10.48 14.30	14.60 12.73 12.73 13.16 0.00	20.00 13.06 14.46 15.03	19.65 13.04 15.39 16.05 19.34
	AHTR AIR (V)	AT-802-3 FY-30	PPM PPM SCFM	18.28 10.48 14.30 0.00 64.5	14.60 12.73 12.73 13.15 0.00 61.8	20.00 13.06 14.46 15.03 1.45 62.6	19.65 13.04 15.39 16.05 19.34 62.2
	AHTR AIR (V) REGINGAS (V) REGINS (V)	AT-NOX-3 AT-802-3 FY-30 FY-3008 FY-3108	PPM PPM SCFM SCFM SCFM	18.28 10.48 14.30 0.00 64.5 0.15 0.00	14.60 12.73 12.73 13.16 0.00 61.8 0.22 0.00	20.00 13.06 14.46 15.03 1.45 62.6 0.22 0.00	19.65 13.04 15.39 16.05 19.34 62.2 0.22 0.00
	AHTR AIR (V) REG NGAS (V) REG N2 (V)	AT-NOX-3 AT-802-8 FY-30 FY-3008 FY-3108	PPM PPM SCFM SCFM SCFM	18.28 10.48 14.30 0.00 64.6 0.15 0.00 FBC089	14.60 12.73 12.73 13.18 0.00 61.8 0.22 0.00 FBC090	20.00 13.06 14.46 15.03 1.45 62.6 0.22 0.00 FBC091	19.65 13.04 15.39 15.05 19.34 62.2 0.22 0.00 FBC092
FLUID BED COOLER FILE	AHTR AIR (M) REG NGAS (M) REG N2 (M) FBC AIR VEL	AT-NOX-3 AT-802-3 FY-30 FY-3008 FY-3108	PPM PPM SCFM SCFM SCFM SCFM	18.28 10.48 14.30 0.00 64.6 0.18 0.00 FBC089 7.00	14.60 12.73 12.73 13.15 0.00 61.8 0.22 0.00 FBC090 6.98	20.00 13.06 14.46 15.03 1.46 62.6 0.22 0.000 FBC091 7.02	19.66 13.04 15.39 18.05 19.34 82.2 0.22 0.00 FBC092 6.97 214.4
FLUID BED COOLER FILE	AHTR AIR (V) REG NGAS (V) REG N2 (V) FBC AIR VEL AIR (M) T PLENUM	AT-NOX-33 AT-802-3 FY-30 FY-300 FY-3108 SY-360 FY-360 TE-362	PPM PPM SCFM SCFM SCFM FT/SEC #/HR DEG F	18.28 10.46 14.30 0.00 64.5 0.15 0.00 FBC089 7.00 218.6 1000	14.60 12.73 12.73 13.16 0.00 61.8 0.22 0.00 FBC090 6.94 213.8 1026	20.00 13.06 14.46 15.03 1.48 62.6 0.22 0.00 FBC091 7.02 219.2 1022	19.65 13.04 15.39 16.05 19.34 82.2 0.00 FBC092 6.97 214.4 1025
FLUID BED COOLER FILE	AHTR AIR (Y) REG NGAS (Y) REG NGAS (Y) FBC AIR VEL AIR (M) T PLENUM T LOWER BED DP	AT-NOX-3 AT-802-8 FY-30 FY-300 FY-3008 FY-3108 SY-360 FY-360 FY-360 TE-363 FY-365	PPM PPM SCFM SCFM SCFM SCFM FT/SEC #/HR DEG F DEG F H20	18.28 10.48 14.30 0.00 64.5 0.18 0.00 FBC089 7.00 215.8 1006 945 18.62	14.60 12.73 12.73 13.15 0.00 61.8 0.22 0.00 FBC090 6.94 213.6 1025 9.966	20.00 13.06 14.46 15.03 1.46 62.6 0.22 0.00 FBC091 7.02 219.2 1024 1025 1026 10.8	19.65 13.04 15.39 16.06 19.34 62.2 0.22 0.22 0.00 FBC092 6.97 214.4 1025 967
FLUID BED COOLER FILE	AHTR AIR (V) REG NGAS (V) REG NGAS (V) FBC AIR VEL AIR (M) T PLENUM BED DP PLENUM DP PLENUM DP FEO DES	AT-N02-3 AT-802-3 FY-30 FY-3008 FY-3108 FY-3108 FY-3108 FY-360 FY-360 TE-362 TE-363 F0T-365 P0T-365	PPM SCFM SCFM SCFM SCFM FT/SEC #/HR DEG F DEG F H20 H20	18.28 10.48 14.30 0.00 64.5 0.15 0.00 7.00 219.8 1006 946 18.62 18.62 18.62 2.00	14.60 12.73 12.73 13.15 0.00 61.8 0.22 0.00 FBC090 6.94 213.6 1028 9.96 1028 9.96 19.69 0.23 213.6 19.69 0.23	20.00 13.06 14.46 18.03 1.48 62.0 20.22 0.00 FBC091 7.02 219.2 5 102 5 102 5 102 5 102 5 102 5 102 5 102 5 102 5 102 5 102 5 102 5 102 5 102 5 102 5 102 5 102 5 10 102 5 10 10 10 10 10 10 10 10 10 10 10 10 10	19.65 13.04 15.39 16.05 19.34 62.2 0.000 FBC092 16.05 19.34 62.2 0.000 FBC092 1.025 96.07 1.16.6 96.09 1.214.4 1.025 96.00 1.4.16 6.30 2.02
FLUID BED COOLER FILE	ANTR AIR (M) REG NGAS (M) REG NG (M) FBC AIR VEL AIR (M) T PLENUM T LOWER BED DP PLENUM DP FBC PRES T UPPER	AT-N02-3 AT-802-3 FY-300 FY-3003 FY-3108 FY-3108 FY-380 FY-380 TE-383 P0T-385 P0T-385 P0T-385 P0T-385	PPM PPM SCFM SCFM SCFM SCFM FT/SEC #/HR DEG F H20 H20 H20 DEG F	18.28 10.48 14.30 0.00 64.5 0.18 0.00 7.00 218.8 1006 946 18.82 6.22 6.22 6.25 2.00	14.60 12.73 12.73 13.16 0.00 61.8 0.02 0.00 FBC090	20.00 13.00 14.46 16.03 1.46 62.0 0.02 0.00 FBC001 7.02 219.2 1.022 955 0.16.05 1.6.05	19.65 13.04 15.39 16.05 19.34 62.2 0.00 FBC092 6.97 14.16 6.30 967 14.16 6.30 2.02
FLUID BED COOLER FILE	ANTR AIR (M) REG NGAS (M) REG NG (M) FBC AIR VEL AIR (M) T PLENUM T LOWER BED OP PLENUM OP FBC PRES T UPPER T HEATER T AIR	AT-802-3 FY-300 FY-3003 FY-3003 FY-3108 FY-3108 FY-380 TE-383 PDT-385 PDT-385 PDT-385 PDT-385 TE-381 TE-381 TE-381 TE-381	PPM PPM SCFM SCFM SCFM FT/SEC #/HR DEG F DEG F H20 H20 H20 DEG F DEG F DEG F	18.28 10.48 14.30 0.00 64.6 0.18 0.00 FBC089 7.00 218.8 1006 945 18.82 6.22 2.00 945 18.82 6.25 2.00 945 18.82 6.25 2.00 955 6.27 8 10,48	14.60 12.73 12.73 13.16 0.00 61.8 0.22 213.6 1025 213.6 1025 13.6 1025 213.6 1025 213.6 2000 2000 2000 2000 2000 2000 2000 20	20.00 20.00 13.06 14.46 15.02 1.65 20.00 FBC091 FBC091 7.02 219.9 1028 16.16 2.06 5533 5533 76	19.65 13.04 15.39 16.05 19.34 82.2 0.00 FBC092 1.025 967 14.16 6.39 14.16 6.30 1.14.16 6.30 1.14.16 76
FLUID BED COOLER FILE	AHTRIAR M REG NGAS (M) REG NGAS (M) FBC AIR VEL AIR (M) T LOWER BED DP FBC PRES T UPPER T HEATER T HEATER AIR DP	AT-N02-3 AT-802-3 FY-30 FY-3008 FY-310 FY-3108 FY-310 FY-	PPM PPM SCFM SCFM SCFM SCFM SCFM SCFM PT/SEC #/HR DEGF H20 H20 H20 DEGF DEGF DEGF DEGF DEGF H20 H20 H20 DEGF H20	16.29 10.45 14.30 0.00 64.6.4 14.50 0.00 FBC089 7.00 218.6 218.6 218.6 218.6 218.6 218.6 218.6 218.6 218.6 218.6 218.6 218.6 218.6 218.6 219.6 200 219.6 200 200 200 200 200 200 200 200 200 20	14.60 12.73 12.73 13.16 0.000 61.8 0.022 0.020 FBC090 FBC090 FBC090 FBC090 FBC090 6.58 1022 9.65 1022 9.65 5.56 5.56 5.56 5.56 5.56 5.56 5.56	20.00 13.060 14.46 16.03 1.460 62.0 0.000 FBC091 7.02 10.25 10	19.65 13.04 15.39 16.39 18.05 19.34 82.2 0.22 0.00 FBC082 10.34 10.25 10.41 10.25 967 14.16 1.025 970 3600 76 0.220 0.500
FLUID BED COOLER FILE	AHTRAIR M REG NGAS (M) REG NGAS (M) FBC AIR VEL AIR (M) T LOWER BED OP FBC PIRES T UPPER T HEATER AIR PRES AIR OP FNET \$02(ADA)	AT-N02-3 AT-802-3 FY-30 FY-3008 FY-3108 FY-3	PPM PPM SCFM SCFM SCFM SCFM BCFM PT/SEC #/HR DEGF H20 H20 DEGF PPM DPM	16.28 10.48 10.48 14.30 0.00 64.8.4 0.00 77.00 218.8 1000 949 1000 949 1000 949 1000 949 1000 949 1000 949 10.00 949 10.00 949 10.00 949 10.00 940 10.00 100 1	14.60 12.73 12.73 12.73 13.16 0.000 61.8 0.022 0.000 FBC090 FBC090 FBC090 FBC090 FBC090 0.000 FBC090 0.000 5.58 5.36 5.36 5.36 5.36 5.36 5.36 5.36 5.36	20.00 13.060 14.46 16.03 1.460 4.62.0 0.000 FBC091 FBC091 7.02 10.28 9.6666 9.6666 9.6666 9.6	18.65 13.04 13.04 15.39 15.05 15.06 19.04 19.04 19.04 0.22 0.02 19.04 0.22 0.02 1025 0.02 0.02 0.01 0.01 0.02 0.05 0.05 0.05 10.05 10.05 0.05 10.05
FLUID BED COOLER FILE	AHTRIAR M REG NGAS (M) REG NGAS (M) FBC AIR VEL AIR (M) T LOWER BED DP FBC PRES T UPPER T HEATER AIR OP NLET 802 (ADJ) OUTLET 802 (ADJ) INLET 802 (ADJ) INLET 802 (ADJ)	AT-N02-3 AT-802-3 FY-300 FY-3008 FY-3108 FY-3800 FY-3800 FY-3800 FY-3800 FY-380 FY-380 FY-380 FY-380 FY-380 FY-380 FY-380 FY-380 FY-380 FY-380 FT-380	PPM PPM SCFM SCFM </td <td>16.28 10.48 10.48 14.30 0.00 64.6.8 0.00 216.8 7.00 218.8 1000 945 6.22 0.00 945 6.23 0.00 945 1000 1000 1000 1000 1000 1000 1000 10</td> <td>14.60 12.73 12.73 13.15 0.00 61.8 0.02 20 0.02 213.6 1022 966 966 966 966 966 966 966 966 966 9</td> <td>20.000 20.000 13.000 14.45 16.000 219.9</td> <td>18.65 13.04 13.04 15.39 16.05 19.34 19.34 19.34 19.34 19.34 19.34 19.34 19.34 19.34 19.34 1025 1026 970 14.16 1026 970 176 300 2.08 970 34469 34469 10344</td>	16.28 10.48 10.48 14.30 0.00 64.6.8 0.00 216.8 7.00 218.8 1000 945 6.22 0.00 945 6.23 0.00 945 1000 1000 1000 1000 1000 1000 1000 10	14.60 12.73 12.73 13.15 0.00 61.8 0.02 20 0.02 213.6 1022 966 966 966 966 966 966 966 966 966 9	20.000 20.000 13.000 14.45 16.000 219.9	18.65 13.04 13.04 15.39 16.05 19.34 19.34 19.34 19.34 19.34 19.34 19.34 19.34 19.34 19.34 1025 1026 970 14.16 1026 970 176 300 2.08 970 34469 34469 10344
FLUID BED COOLER FILE	AHTRAIR M REG NGAS (M) REG NGAS (M) REG NGAS (M) FBC AIR VEL AIR (M) T LOWER BED DP FBC PRES T UPPER T HEATER AIR OPER AIR OPER NLET SO 2(ADJ) OUTLET NO 2(ADJ) AIR (M)	AT-902-3 AT-902-3 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FT-304 FT-304 FT-304 FT-306 FT-306 FT-306 FT-306 FT-306 FT-306 FT-307 FT-30	PPM PPM SCFM DEGF H20 H20 DEGF DEGF PSIG PAM PPM PPM PPM PPM PPM	16.28 10.4% 14.30 0.00 0.00 0.00 0.00 0.00 0.00 0.00	14.60 12.73 12.73 13.15 0.00 61.8 0.02 0.02 0.02 0.02 0.02 0.02 0.02 0.	20.000 20.000 13.000 14.45 16.000 21.0.0 FBC091 7.000 219.9 1022 5.000 1022 5.000 1022 5.000 1022 5.000 1022 5.000 1020 5.000 1020 5.000 1020 10	18.65 13.04 13.04 15.39 16.05 19.34 19.34 19.34 19.34 19.34 19.34 19.34 19.34 0.22 0.00 FBC092 114.16 1025 967 114.16 1025 967 124.4 1035 967 176 9.059 12409 12409 12409 12409 12409 13449 469.201
FLUID BED COOLER FILE	AHTRAIR (M) REG NGAS (M) REG NGAS (M) REG NGAS (M) FBC AIR VEL AIR (M) T LOWER BED DP FBC PIRES T UPPER T HEATER AIR OP NLET 802(ADJ) OUTLET NOX(ADJ) AIR (M) TR HOPPER	AT-902-3 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FT-340	PPM PPM SCFM SCFM SCFM FT/SEC F1/SEC FAIN DEGF H20 H20 H20 H20 H20 H20 H20 H20 H20 H20	16.28 10.4% 14.30 000 64.5 0.18 0.00 000 000 7.00 18.68 18.68 18.68 18.68 19.6% 10.06 0.00 0.00 0.00 1	14.60 12.73 12.73 13.16 0.000 61.8.4 0.02 0.000 FBC000 FBC000 6.98 9.60 9.60 9.60 9.60 9.60 9.60 9.60 9.60	20.00 13.000 14.46 14.60 14.60 15.000 5.000 FBC091 FBC	18.66 13.04 13.04 15.39 16.05 19.34 19.34 19.34 19.34 19.34 19.34 19.34 19.34 19.34 19.34 19.34 1035 967 114.16 1035 967 114.16 1035 967 970 176 9.330 176 9.4499 2032
FLUID BED COOLER FILE	ANTR AIR (M) REG NGAS (M) REG NGAS (M) REG NGAS (M) FBC AIR VEL. AIR (M) T LOWER BED DP PLENUM DP FBC PRES T UPPER T HEATER AIR OP NLET NOX(ADJ) OUTLET NOX(ADJ) AIR (M) TR HOPPER	AT-902-3 FY-302 FY-302 FY-306 FY-306 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-300 FY-307 FY-300 S02REF H02XEF FY-300 S02REF	PPM PPM SCFM SCFM SCFM SCFM SCFM SCFM DEGF H20 H20 H20 H20 H20 H20 H20 H20 H20 H20	16.28 10.44 10.44 10.44 10.44 14.30 000 000 14.5 10.00	14.60 12.73 12.73 13.16 0.000 FBC000 FBC000 6.80 213.6 1022 96 96 96 96 96 96 96 96 96 96 96 96 96	20.00 20.00 13.00 14.46 14.46 14.60 14	18.65 13.04 13.04 15.39 16.65 19.44 62.2 0.00 FBC002 6.97 214.4 10.22 10.22 10.22 10.22 10.22 10.23 10.24 10.25 10.21 10.21 10.21 10.21 10.21 10.21 10.22 10.22 10.23 10.24 10.25
FLUID BED COOLER FILE	ANTR AIR (M) REG NGAS (M) REG NGAS (M) REG NGAS (M) FBC AIR VEL. AIR (M) T LOWER BED DP PLENUM DP FBC PRES T UPPER T HEATER T AIR AIR OP NLET NOX(ADJ) OUTLET NOX(ADJ) OUTLET NOX(ADJ) OUTLET NOX(ADJ) AIR (M) TR HOPPER COMB AIR T CO AIR HTR T	AT-902-3 FY-302 FY-302 FY-306 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-320	PPM PPM SCFM SCFM SCFM SCFM SCFM SCFM PFM DEGF H20 H20 H20 H20 H20 H20 H20 H20 H20 H20	16.28 10.44 10.44 14.30 6.00 6.00 7.00 7.00 7.00 7.00 7.00 7.0	14.60 12.73 12.73 13.16 0.000 6.00 6.00 6.00 213.8 980 980 980 980 980 980 980 980 980 98	20.000 20.000 13.000 14.46 14.60 14.60 14.60 14.60 14.60 14.60 14.60 14.60 14.60 1022 10	18.66 13.04 13.04 13.04 15.39 16.05 19.04 19.24 10.02 0.00 PBC002 6.97 214.4 1022 10.05 1025 1022 1026 1025 6.97 214.4 1025 1025 967 14.16 2.04 2.052 970 14.15 2.058 0.59 348 2012 2032 17 740076 7 72047076
FLUID BED COOLER FILE	ANTR AIR (M) REG NGAS (M) REG NGAS (M) REG NGAS (M) FBC AIR VEL. AIR (M) T LOWER BED DP PLENUM DP PLENUM DP PLENUM DP FBC PRES T UPPER T HEATER AIR DP RLET SO2(ADJ) OUTLET NOX(ADJ) OUTLET NOX(ADJ) AIR (M) TR HOPPER COMB AIR T CO AIR HTR T MOT AIR T MOT AIR T	AT-902-3 FY-300 FY-300 FY-300 FY-3106	PPM PPM SCFM SCFM SCFM SCFM SCFM SCFM DEGF H20 H20 H20 H20 H20 H20 H20 H20 H20 H20	16.28 10.44 10.44 10.44 14.30 0.00 0.00 0.00 7.00 7.00 7.00 18.62	14.60 12.73 12.73 13.16 0.00 61.8 0.22 0.00 FBC080 8.84 213.6 1022 966 966 966 966 966 966 966 966 966 9	20.000 20.000 13.000 14.46 14.46 14.46 14.46 14.46 14.46 14.46 14.46 14.46 14.46 14.46 14.46 14.46 14.46 10.22	18.65 13.04 13.04 15.39 19.05 19.05 0.22 0.00 FBC002 10.05
FLUID BED COOLER FILE	AHTRI AIR M REG NGAS (M) REG NGAS (M) REG NG (M) FBC AIR VEL AIR M T LOWER BED OP FBC PIRES T UPPER T AIR NET SO2(AD) INLET NOX(AD) OUTLET SO2(AD) INLET NOX(AD) OUTLET NOX	AT-902-3 FY-300 FY-300 FY-300 FY-300 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-340 FT-340 FT-340 FT-340 FT-340 FT-340 FT-340 S02REF FY-340 S02REF FY-340 S02REF FY-340 S02REF FY-340 FT-360 FT-367 FT-360 FT-367 FT-360 FT-367 FT-360 FT-367 FT-360 FT-367 FT-360 FT-367 FT-360 FT-360 FT-367 FT-360 FT-360 FT-367 FT-367 FT-360 FT-367 FT-360 FT-367 FT-360 FT-367 FT-360 FT-367 FT-367 FT-360 FT-367 FT-37 FT-367 FT-37 FT-367 FT-37 FT	PPM PPM SCFM SCFM SCFM SCFM SCFM SCFM DEGF H20 H20 H20 H20 H20 H20 H20 H20 H20 H20	16.28 10.44 14.30 66.6 0.00 7.00 7.00 7.00 10.00 9.44 18.62 10.00 9.44 18.62 10.00 9.44 18.62 10.00 9.44 18.62 10.00 9.44 10.00 9.44 10.00 9.45 10.00 10.0	14.60 12.73 12.73 13.16 0.00 61.8 0.02 0.02 0.00 FBC090 FBC090 8.89 213.8 1022 9.60 9.60 9.60 9.60 9.60 9.60 9.60 9.60	20.001 20.001 13.000 14.46	18.65 19.64 13.04 19.64 18.05 19.64 19.04 62.2 0.22 0.22 0.02 0.22 0.22 0.22 0.22 0.22 0.22 0.22 0.22 0.22 0.22 0.22 0.34 1065 1005 14.16 1005 14.16 1005 14.16 1005 201 1034 201 1035 2032 10407 103 2012 103 1035 2012 1035 2012 1035 2012 1035 2012 1035 2012 1035 2012 1035 2012 1035 2012 1035 2012 104076 1044 2013 2012
FLUID BED COOLER FILE	AHTRIAR M REG NGAS (M) REG NGAS (M) REG NGAS (M) REG NGAS (M) FBC AIR VEL AIR MI T LOWER BED OP FBC PRES T UPPER T AIR PLENUM OP FBC PRES T UPPER T AIR AIR PRES AIR OP REET SO2(ADA) OUTLET SO2(ADA) OUTLET NOX(ADA) OUTLET NOX(ADA) AIR (M) TR HOPPER COMB AIR T CO AIR HTR T MOT AIR T FURNERT T OT FGAS T TOT FGAS T	AT-902-3 AT-902-3 FY-300 FY-300 FY-300 FY-300 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-3106 FY-340 FY-340 FT-343 FT-34	PPM PPM SCFM SCFM SCFM FT/SEC I/HE DEGF H20 H20 H20 H20 H20 H20 H20 H20 H20 H20	16.28 10.4% 14.30 6.6 6.6 7.00 7.00 7.00 7.00 7.00 7.00	14.60 12.73 12.73 13.16 0.00 0.02 0.02 0.02 0.02 0.02 0.02 0.0	20.00 20.00	18.65 13.04 13.04 13.04 15.39 14.06 19.04 10.05 0.22 0.022 0.022 0.022 0.022 0.22 0.022 0.022 0.22 0.021 14.16 102.28 970 13.04 0.59 1.059 2.040 3.46 2.059 2.040 3.46 2.059 2.040 3.46 3.46 2.059 3.46 3.46 3.46 3.46 3.46 3.46 3.46 3.46 3.46 3.46 3.46 3.46 3.46 3.46 3.46
FLUID BED COOLER FILE	AHTRI AIR M REG NGAS (M) REG NGAS (M) REG NB (M) FBC AIR VEL AIR (M) T LOWER BED DP FBC PRES T UPPER T AIR PLENUM DP FBC PRES T UPPER T AIR AIR PRES AIR OP INLET NOXADJ OUTLET SO2(ADJ) OUTLET NOXADJ AIR (M) TR HOPPER T AIR COMB AIR T COMB AIR T FURN REF A T TO T FGAS T HUM EXIT T NOT FGAS TO T	AT-902-3 AT-902-3 FY-300 FY-300 FY-300 FY-300 FY-3105 FY-310	PPM PPM SCFM SCFM SCFM FT/SEC J/HR DEGF H20 H20 H20 H20 H20 H20 H20 H20 H20 H20	16.28 10.4% 14.30 0.000 64.6 0.00 7.00 7.00 7.00 7.00 7.00 7.00 7.	14.60 12.73 12.73 12.73 13.16 0.00 0.02 0.02 0.02 13.6 19.6 0.00 0.02 0.00 0.02 0.00 0.02 0.000 0.000 0.000 0.000 0.000000	20.00 20.00	18.65 13.04 13.04 13.04 15.39 15.06 19.04 19.04 0.22 0.22 0.22 0.22 0.22 0.22 0.22 0.22 0.22 0.23 1035 1036 1036 1037 1031 1031 1032 1033 1033 1033 1033 1034 1035 1035 10364 1039 1039 1039 1039 1039 1039 1039 1039 1039 1043 1039 1043 1039 10443 10364 10443 10
FLUID BED COOLER FILE	AHTRIAR M REG NGAS (M) REG NGAS (M) REG NR (M) FBC AIR VEL AIR (M) T LOWER BED DP FBC PIRES T UPPER T AIR PLENUM DP FBC PIRES T UPPER T AIR NET 502 (ADA) OUTLET NOX(ADA) OUTLET NOX(ADA) AIR OP RLET NOX(ADA) OUTLET NOX(ADA) AIR OP RLET NOX(ADA) COMB AIR T CO AIR HTR T FURN REFR T HOM FART T TOT FGAS T HUM EXIT T BGHS FOP T BGHS FOP T	AT-902-3 AT-902-3 FY-300 FY-300 FY-300 FY-300 FY-3108 FY-310 FY	PPM PPM SCFM SCFM SCFM SCFM FT/SEC FT	16.28 10.4% 14.30 0.00 0.00 0.00 0.00 0.00 0.00 0.00	14.60 12.73 12.73 13.16 0.02 61.8 0.02 6.95 213.8 1022 9.65 1022 1022 1022 102 102 102 102 102 102	20.00 20.00	18.65 13.04 13.04 13.04 13.04 15.29 15.20 2.22 0.022 0.022 0.022 0.022 0.022 0.022 0.022 0.021 0.022 0.022 0.021 0.022 0.022 0.021 0.011 0.101 0.101 0.101 0.101 0.101 0.101 0.101 0.101 0.101 0.101 0.101 0.101 0.101 0.101 0.102 0.101 0.101 0.101 0.101 0.101 0.102 0.102 0.102 0.101 0.101 0.101
FLUID BED COOLER FILE	AHTRIAR M REG NGAS (M) REG NGAS (M) REG NGAS (M) REG NGAS (M) FBC AIR VEL AIR VEL AIR VEL AIR VEL AIR VEL BED DP FBC PRES T UPPER T AIR PLENUM DP FBC PRES T UPPER T AIR NET SO2(ADA) OUTLET SO2(ADA) AIR (M) TR HOPPER T AIR NALET SO2(ADA) AIR (M) TR HOPPER COMB AIR T CO AIR HTR T FURN REFR T HUM EXIT T TOT FGAS T BGHS 80 T T BGHS 80 T T ABS ZI T ABS ZI T	AT-902-3 AT-902-3 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FZ-34	PPM PPM SCFM SCFM SCFM SCFM SCFM SCFM PFM DEGF H20 H20 H20 H20 H20 H20 H20 H20 H20 H20	16.28 10.4% 14.30 0.000 64.6 0.15 7.00 18.62 10.00 18.62 18.62 10.00 19.62 18.62 10.00 19.62 19.62 19.62 10.00 19.62 19.65 19.	14.60 12.73 12.73 13.16 0.02 61.8 0.02 6.95 10.02 10.0	20.00 20.00	18.65 13.04 13.04 13.04 13.04 13.04 13.04 14.05 0.22 0.02 0.02 78 214.4 102.27 214.4 102.28 970 101.01 2.022 10.02 970 102.29 0.09 103.10 2.022 102.29 0.09 103.11 2.03 103.11 103.20 103.11 103.20 104.11 103.20 105.00 0.50 105.00 5.00 103.344 103.34 103.344 103.34 103.344 103.34 103.344 103.34 103.344 103.34 103.344 103.34 103.344 103.34 103.344 103.34 103.344 103.34 103.344 103.34 104.144 103.34 <t< td=""></t<>
FLUID BED COOLER FILE	AHTRIAR M REG NGAS (M) REG NGAS (M) REG NGAS (M) FBC AIR VEL AIR (M) T LOWER BED DP FBC PIRES T UPPER T AIR PLENUM DP FBC PIRES T UPPER T AIR NET SO2(ADJ) OUTLET SO2(ADJ) OUTLET SO2(ADJ) AIR (M) TR HOPPER C AIR HTR T FUR REFR T COMB AIR T COMB AIR T FUR REFR T HUM EXIT T TOT FGAS T HUM EXIT T ABS 70 PT BGHS 80 PT ABS 21 T ABS 22 T ABS 23 T ABS 23 T	AT-902-3 AT-902-3 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FY-300 FZ-343 FZ-344 FZ-345 FZ-34	PPM PPM SCFM SCFM SCFM SCFM SCFM FT/SEC F1/S	16.28 10.4% 14.30 0.00 64.6 0.00 7.00 18.62 18.62 10.00 10.00 18.62 18.62 18.62 18.62 18.62 18.62 18.62 19.64 18.62 19.65 19.55 19.5	14.60 12.73 12.73 13.16 0.000 FBC00 FBC00	20.00 20.00 21.00 20.00	18.65 13.04 13.04 13.04 13.04 13.04 14.05 19.04 19.24 0.22 0.00 FBC002 6.97 214.4 1022 10.01 14.16 214.4 1026 1022 14.16 2032 970 3 2.04 3 2.05 3 2.05 10.59 2.05 10.59 2.05 10.202 2.032 110.10 4.09 110.10 5.400 110.10 9.765 110.10 1.010 110.10 1.010 110.10 1.010 110.10 1.010 110.10 1.010 110.10 1.010 110.10 1.010 110.10 1.010 110.10 1.010 110.10 1.010 110.10 1.010
FLUID BED COOLER FILE	AHTRIAR M REG NGAS (M) REG NGAS (M) REG NGAS (M) FBC AIR VEL AIR M T LOWER BED DP FBC PIRES T UPPER T HEATER AIR OP RET VER AIR OP NLET 802(AD) OUTLET 802(AD) AIR OP RLET 802(AD) AIR OP	AT-902-3 AT-902-3 FY-302 FY FY-302 FY	PPM PPM SCFM SCFM SCFM SCFM SCFM SCFM PFT/SEC F7/SE	16.28 10.49 10.49 14.30 000 64.5 0.00 000 000 FBC089 FBC089 945 18.52 1006 945 18.52 17.00 18.52 18.52 18.52 1006 945 18.52 18.55	14.60 12.73 12.73 13.16 0.000 FBC00 FBC00	20.00 20.00 13.00 14.46 14.46 14.46 14.46 15.02 0.00 FBC	18.65 13.04 13.04 13.04 13.04 19.05 19.04 19.04 19.04 0.22 0.000 FBC002 214.4 1022 1023 103.04 1023 103.04 103.04 103.04 103.05 103.05 103.05 103.05 103.05 104.05 103.05 104.05
FLUID BED COOLER FILE	AHTRIAIR (M) REG NGAS (M) REG NGAS (M) REG NGAS (M) REG NGAS (M) FBC AIR VEL AIR QM T LOWER BED DP FBC PIRES T UPPER T HEATER AIR OP FBC PIRES AIR OP RLET SO2(AD.4) OUTLET NOX(AD.4) OUTLET NOX(AD.4) AIR (M) TR HOPPER COMB AIR T FURN REFR T FURN REFR T HUM EXIT T FURN REFR T ABS FGAS T ABS ZA T ABS ZA T ABS ZA T ABS ZA T COM FUR EXIT	AT-902-3 FY-302 FY-30 FY-302 F	PPM PPM SCFM SCFM SCFM SCFM SCFM SCFM PFTSEC F7/SEC	16.28 10.4% 14.30 000 64.5 0.18 10.0% 7.00 7.00 7.00 7.00 7.00 7.00 7.00	14.60 12.73 12.73 12.73 13.16 0.000 6.000 FBC000 FBC000 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 9.85 10.62 10.62 10.65 10.62 10.65 10.62 10.65 10.62 10.65 10.75 10.7	20.00 20.00	18.65 13.04 13.04 13.04 15.39 19.05 19.04 19.04 19.04 0.22 0.000 FBC002 1022 1023 1024 1025 1026 1027 114.16 1023 1031 1031 1032 1033 2033 1041 1031 1031 1033 1033 1041 1033 1041 1033 1041 1041 1041 1041 1041 1041 1041 1041 1041 1041 1041 1041 1041 1041 1041

Table 6

MBCUO-09	PARAMETER	TAG	E/U	1	2	3	4	5	6	7
COMBUSTOR FILE				COMB061	COMB082	COMBOBS	COMBOSS	COMBOSS	COMB087	COMBOSS
	COMB AIR MOTIVE AIR	FY-1 FY-3	#/HR #/HR	486.2	466.3	473.9	474.0	469.4	469.7	482.6
	NATURAL GAS	FY-20	#/HR	24.18	24.18	4.17	4.17	4.17	4.17	22.51
	FEEDERWT	WT-25	LBS	0.00	0.00	39.12	39.40	38.95	38.95	38.64
	EXCESS AIR HEAT INPUT	BY-X BTU	%XSA BTU/HR	19.98	19.98	21.16 620531	22.03 817218	21.61 614334	803143	\$83072
	FLUE GAS (M)	FY-16	\$/HR	535.5 1.74	535.3 3.87	<u>546.0</u> 3.24	<u>558,1</u> 3,36	642.9 4.19	<u>561.9</u> 3.98	496.2
	FURNACE P	PT-6	H20	-1.01	-1.00	-0.97	-1.01	-1.05	-1.02	-1.01
	MOTIVE AIR P	PT-3	PSIG	96.16	96.34	97.62	\$6.00	99.54	95.11	95.07
	FLUE GAS P	PT-20	PSKG -H20	4.86	4.68	8.42	<u> </u>	5.45	8.45	4.89
	COOL H20 P	PT-25	PSIG	155.18	155.42	154.34	165.26	154.65	153.82	154.33
	FURNACE CO2	AT-C02-0	PERCENT	9.77	9.92	14.37	6.93	14.60	15.37	10.41
	FURNACE CO MOTIVE AIR V	AT-CO-0 SY-3	PPM FT/SEC	0.00	9.75	80.24	79.88	361.00	80.06	0.00
	FLUE GAS (V)	FY-16	SCFM	114.8	114.8	117.0	119.6	116.4	118.3	106.8
ABSORBER FLE		17. 000. 1	0.014	A55096	ABS099	AB8100	AB8102	AB8103	AB\$104	A65105
	INLET NOX	AT-802-1 AT-NOX-1	PPM	200	528	574	516	888	524	496
	INLET 02 OUTLET 802	AT-02-1 AT-802-2	PERCENT	3.78	3.98	3.18	3.53	3.58	3.65	4.00
	OUTLET NOX	AT-NOX-2	PPM	167	32	2,99	4.27	71	30	4.05
	NO SPIKE	FT-101	#/HR	0.00	0.08	0.00	0.00	0.02	0.00	0.09
	NH3 SPIKE	FT-102	#/MA #/MA	0.000	0.124	0.07	0.138	0.146	0.146	0.106
	BED DP FLUE GAS MO	PDT-19	H20 #/HR	0.85	0.92	0.90	0.75	1.06	1.36 613.3	0.93
	INLET P	PT-17	-H20	7.48	7.39	7.60	7.53	7.46	7.94	6.43
	GAS INLET	TE-18	DEGF	747	747	766	747	762	791	747
	GAS OUTLET SORB IN	TE-21 TE-390	DEGF	688 717	690 721	729	703	716	705	763
	SORB OUT	TE-391 SO2REF	DEG F PERCENT	678 84.8	696 92.8	726	740	766 93.2	633 72.8	586 86.6
	NOX REMOVAL	NOXREF	PERCENT	1.5	93.7	93.9	94.0	87.9	94.3	88.6 100.0
				100.7		DEAres	000000	DEALAS	DE OTOT	DE OLO
REGENERATOR FILE	QUICK REP 02	AT-02-44	PERCENT	HE G096	HE G099 0.00	0.28	0.03	0.75	0.04	0.01
	REGEN 802 REGEN CH4	AT-802-4 AT-CH4-4	PERCENT	39.83	43.04	39.52 6.86	32.35	41.59 5.89	40.25 22.18	42.27
	REGEN CO2	AT-CO2-4	PERCENT	44.08	42.96	44.23	43.16	41.47	34.61	38.35
	REGEN 02	AT-02-48	PERCENT	0.26	0.02	0.31	0.37	0.14	0.03	0.02
	NITRO GEN	FY-300	#/MR	0,80	0.60	0.60	0.00	0.00	0.00	0.00
	REGEN P SORBLEVEL	PT-380 LT-380	H2O	1.56 24.70	1.31	0.30	2.40	0.24 50.02	2.66	3.26
	TSORB (2)	TE-381 TE-382	DEGF	642 839	871 860	850 849	851	826	852	858
	TSORB (32)	TE-383	DEGF	867	825	849	836	839	843	846
	TGAS(EXT)	TE-386	DEGF	998	857	865	366	890	1010	1010
	T OFFGAS	TE-386	DEGF	262	247	242	264	256	262	245
	TCONDEX	TE-367	DEGF	34	33	34	35	34	33	34
	T CONDEX T INCEX	TE-387 TE-200 AT-02-6	DEG F DEG F PERCENT	34 555 18,96	33 566 19.16	571 18.67	35 507 18.92	34 539 19.16	33 893 18.88	34 614 18.78
	T CONDEX T INC EX INCIN 02 INCIN 802	TE-387 TE-200 AT-02-8 AT-802-8	DEG F DEG F PERCENT PPM	34 665 18.96 731	33 566 19.16 720	34 571 18.87 554	35 507 18.92 804	34 539 19.15 815	33 593 18.88 686	34 614 18.75 495
FLUIO BED HEATER FILE	T COND EX TINC EX INCIN 02 INCIN 802	TE-367 TE-200 AT-02-8 AT-802-8	DEG F DEG F PERCENT PPM	34 665 18.96 731 FBH098	33 566 19.16 720 FBH099	54 671 18.67 554 FBH100	35 607 18.92 604 FBH102	34 539 19.15 818 FBH103	33 593 18.88 586 FBH104	34 614 18.75 495 FBH105
FLUID BED HEATER FILE	T CONDEX TINC EX INCIN 02 INCIN 802 TSORB(12) NATURAL GAS	TE-367 TE-200 AT-02-8 AT-802-8 TE-373 FY-68	DEGF DEGF PERCENT PPM DEGF	34 555 18.96 731 FBH098 1200 6.07	33 566 19.16 720 FBH099 870 6.16	34 671 18.67 554 FBH100 870 6.10	36 507 18.92 604 FBH102 895 6.31	34 539 19.15 815 FBH103 595 6.34	33 593 18.88 586 FBH104 894 6.20	34 614 18.75 495 FBH105 870 6.07
FLUID BED HEATER FLE	T CONDEX TINC EX INCIN 02 INCIN 802 TSORB(12) NATURAL GAS AHTR AIR (M) F BH VEL	TE-387 TE-200 AT-02-5 AT-802-5 TE-373 FY-88 FY-30 3Y-30	DEGF DEGF PERCENT PPM DEGF \$/MR \$/MR FT/SEC	34 665 18.96 731 FBH098 1200 6.07 325.1 7.50	33 566 19.16 720 FBH099 870 6.16 449.3 8.21	34 571 18.67 554 FBH100 6.10 6.10 448.6 8.20	345 507 18.92 604 FBH102 8395 6.31 436.1 8.20	34 539 19.15 818 FBH103 695 6.34 435.5 8.20	33 593 18.86 586 FBH104 894 6.20 442.3 8.20	34 614 18.75 495 FBH105 870 6.07 449.1 8.20
FLUID BED MEATER FLE	T CONDEX T INC EX INCIN 02 INCIN 02 INCIN 902 TSORB(12) NATURAL GAS AHTR AIR (M) FBH 02 TAHTR OUT	TE-387 TE-200 AT-02-8 AT-802-8 TE-373 FY-56 FY-30 3Y-30 AT-02-3 TE-370	DEGF PERCENT PPM DEGF \$/MR \$/MR \$/MR \$/MR \$/MR \$/MR \$/MR \$/MR	34 666 18.96 731 FBH096 1200 8.07 325.1 7.50 16.19 1222	33, 566 19.16 720 FBH099 870 6.16 449.3 8.21 17.09 886	34 571 18.87 554 FBH100 6.10 448.6 8.20 16.88 907	35 607 18.92 604 FBH102 895 6.31 436.1 8.20 16.42 929	34 639 19.16 816 FBH103 696 6.34 435.5 8.20 16.53 961	33 593 18.86 686 FBH104 8.94 6.20 442.3 8.20 0 442.3 16.67 943	34 614 16.75 495 58H105 870 6.07 449.1 6.20 16.78 901
FLUID BED HEATER FLE	T COND EX T INCE X INCIN 02 INCIN 302 TSORB(12) NATURAL GAB ANTR AIR (M) FBN VEL FBN 02 TANTR OUT TPLENUM TSORBUS	TE - 387 TE - 200 AT - 02 - 8 AT - 802 - 8 TE - 373 FY - 86 FY - 30 3Y - 30 AT - 02 - 3 TE - 370 TE - 370 TE - 372 TE - 372	DEG F DEG F PERCENT PPM DEG F F/MR F/MR F/MR F/MR F/MR F/MR F/MR F/M	34 565 18.96 731 FBH098 1200 6.07 325.1 7.50 16.19 1222 1146 1122	33, 566 19.16 720 FBH099 870 6.16 449.3 8.21 17.09 886 929 929	34 671 18.87 554 FBH100 6.10 6.10 448.8 8.20 16.88 907 922 843	36 607 18.92 604 FBH102 895 6.31 436.1 8.20 16.42 929 948 497	344 539 19,15 616 FBH103 896 6.34 435.5 8.20 16.53 9651 9651 9651	331 893 18.88 FBH104 894 6.20 442.3 8.20 16.67 943 943 943	34 614 18.75 495 58H106 870 6.07 449.1 8.20 16.78 901 9.19 919 945
FLUID BED HEATER FLE	T COND EX TINCEN 02 INCIN 02 INCIN 02 TSORB(12) MATURAL 048 ANTR AIR 049 FBH 02 TAHTR OUT T PLENUM TSORB(24) TVENT	TE-387 TE-200 AT-02-8 AT-802-8 FY-30 3Y-30 AT-02-3 TE-370 TE-370 TE-376 TE-376	DEGF PERCENT PPM DEGF \$/MR \$/MR \$/MR \$/MR \$/MR \$/MR \$/MR \$/MR	344 565 18.96 731 FBH098 1200 6.07 325.1 7.50 15.19 1222 1146 1170 937	33, 566 19,16 720 FBH099 870 6,16 449,3 8,21 17,09 886 929 862 801 801	34 571 18.87 554 FBH100 6.10 448.6 8.20 16.88 907 922 863 801	36 507 18.92 604 FBH102 895 6.31 4361 8.20 16.42 929 906 807 819 819	344 539 19.15 816 FBH103 896 6.34 435.5 8.20 16.53 961 965 965 8.20 16.53 965 965 965 965 965 965	331 593 18.88 FBH104 894 8.20 442.3 8.20 16.67 9.43 9.42 9.43 9.43 8.20 16.67	34 614 19.75 495 FBH106 870 6.07 449.1 8.20 16.78 901 919 861 801
FLUID BED HEATER FLE	T COND EX TINCEN 02 INCIN 02 INCIN 02 TSORB(12) MATURAL 048 AHTR AIR 04 FBH 02 TANTR AUT TPLENUM TSORB(24) TVENT THUM OUT TFBH PES	TE-387 TE-200 AT-02-8 AT-802-8 TE-373 FY-88 FY-30 SY-30 AT-02-3 TE-370 TE-372 TE-378 TE-378 FT-378 FT-378	DEGF PERCENT PPM DEGF S/MR F/XEC PERCENT DEGF DEGF DEGF DEGF DEGF DEGF H2O	34 566 18.96 1200 6.07 328.1 7.50 16.19 1222 1146 1170 937 500 6.62	33 566 19,16 720 FBH099 870 6,16 449,3 8,21 17,09 886 929 862 801 500 10,13	34 671 18.87 554 FBH100 870 6.10 448.8 8.20 16.88 907 922 363 801 800 3.84	36 607 18.92 604 FBH102 835 6.31 436.1 8.20 16.42 929 9368 807 819 500 9.11	344 539 19.15 616 634 435.5 8.20 16.53 961 969 836 836 818 500 9.58	331 593 18.88 586 FBH104 8.20 16.67 943 942 886 820 600 5.00 9.62	34 614 18.76 495 FBH106 870 6.07 449.1 8.20 16.78 901 919 861 801 500 10.01
FLUID BED HEATER FLE	T COND EX TINCE EX INCIN 02 INCIN 02 TSORB(12) MATURAL GAS ANTR AIR (M) FBH 02 TANTR AUT TPLENUM TSORB(24) TVENT THUM OUT TFBH P469 BED DP PLENUM OP	TE-387 TE-200 AT-02-6 AT-802-6 TE-373 FY-86 FY-30 SY-30 SY-30 SY-30 TE-376 TE-376 TE-376 FY-376 FY-376 FY-377	DEGF PERCENT PPM DEGF SMR SMR SMR F7/SEC PERCENT DEGF DEGF DEGF DEGF DEGF DEGF DEGF DEGF	344 5655 18.96 731 FBH090 8.07 325.1 7.60 18.19 1222 1146 1170 937 500 6.62 17.27 17.40	333 586 19.16 720 FBH099 6.16 449.3 9.21 17.09 886 929 862 801 500 10.13 10.20 11.24	34 671 18.67 554 FBH100 6.10 448.6 8.20 16.88 907 922 863 801 500 3.64 10.70 11.25	35 607 18.92 604 FBH102 895 6.31 426.1 8.20 16.42 929 945 945 807 510 9.11 10.37 11.14	344 539 19.16 818 FBH103 896 6.34 435.5 8.20 16.63 961 960 886 818 806 818 800 9.56 10.90 9.56 10.90	333 593 18.88 896 FBH104 8.20 442.3 8.20 16.67 943 943 943 943 943 943 943 943 943 943	34 614 18.75 495 FBH106 870 6.07 449.1 9.20 16.78 901 9.19 861 801 801 10.30 10.31 11.35
FLUID BED HEATER FLE	T COND EX T INC EX INCIN 02 INCIN 02 INCIN 02 TSORB(12) TSORB(12) MATURAL GAS AHTR AIR (M) FBH VEL TAHTR OUT TPLENUM TSORB(24) TVENT THUM OUT TFBH PRES BED DP PLENUM OP FBH NOX EBH VCA	TE-387 TE-200 AT-02-6 AT-802-6 TE-373 FY-88 FY-88 SY-30 SY-30 SY-30 TE-376 TE-376 TE-376 FY-376 FY-376 FY-376 FY-377 AT-N02-3	DEGF PERCENT PPM DEGF PERCENT PPM DEGF F MAR FT/SEC PERCENT DEGF DEGF DEGF DEGF DEGF DEGF DEGF DEGF	34 565 731 750 6.07 325.1 7.60 7.60 7.60 7.60 7.60 6.07 1146 1170 1170 1177 7.77 1146 1177 1146 1177 117.0 1	33 566 566 570 720 720 720 870 6.16 6.449.3 8.21 17.06 886 929 862 801 10.13 10.20 10.13 10.20	34 571 18.87 554 FBH100 6.10 448.6 8.20 16.88 907 922 863 801 800 3.84 10.70 11.26 10.71	35 507 16.92 604 FBH102 895 6.31 436.1 8.20 16.42 929 908 807 819 800 9.11 10.37 11.14 10.40	34, 539 19.16 815 FBH103 986 6.34 435.5 8.20 16.53 961 966 818 800 9.58 10.90 9.58 10.90 9.1.24 11.37 0.67	34 593 16.86 FBH104 6.20 6.20 16.67 943 942 943 8.20 9.62 10.60 9.62 10.60 11.28	34 614 18.76 995 991106 870 8.07 449.1 9.20 16.78 901 9.01 8.01 9.01 8.01 9.01 8.00 10.01 10.38 11.35 9.47 9.47
FLUID BED HEATER FLE	T COND EX T INC EX INCIN 02 INCIN 02 INCIN 02 TSORB(12) TSORB(12) TSORB(12) TSORB(12) FBH VEL FBH 02 TANTR OUT TPLENUM TSORB(24) TVENT THUM OUT TFBH PRES BED 0P PLENUM OP FBH NOX FBH NOX FBH NOX FBH NOX	TE - 387 TE - 200 AT - 02 - 6 AT - 802 - 6 FY - 30 SY - 30 SY - 30 AT - 02 - 8 FY - 90 SY - 30 AT - 02 - 3 FY - 30 TE - 376 TE - 376 TE - 376 TE - 376 TE - 376 TE - 376 TE - 376 PDT - 376 PDT - 377 AT - M02 - 3 AT - 802 - 3 FY - 30 FY - 3	DEG F PERCENT PPM DEG F PERCENT PPM DEG F AMR AMR AMR FTREC DEG F DEG F DEG F DEG F DEG F DEG F M20 H20 PPM SCFM SCFM	34 6565 731 731 731 78006 6.07 328.1 7.60 7.28.1 17.20 16.19 1222 1146 1170 600 6.52 17.27 17.40 18.41 18.41 18.41 13.32 27.12	33, 566 (57) 720 720 720 870 870 870 870 870 886 882 8929 882 801 800 800 800 800 800 800 800 800 800	34 571 18.87 554 554 554 554 6.10 6.10 6.10 6.10 6.10 6.20 16.88 507 322 863 801 801 801 801 801 801 801 801 801 801	36 507 18.92 604 FBH102 8955 6.31 4.98.1 8.20 16.42 929 956 807 819 909 9.11 10.37 11.14 10.40 0.00 9.44 7.11 10.40 9.45 11.4	34, 539 19.16 916 896 8.34 435.5 8.20 16.53 961 956 836 836 9.58 10.90 9.58 11.24 (11.37 9.67 9.63	33 593 586 586 886 886 886 894 894 894 894 894 894 894 894 894 894	34 614 18.76 4985 870 6.07 449.1 901 919 901 919 901 919 901 919 901 919 901 919 901 10.30 10.01 10.30 10.01 10.30 10.00
FLUID BED HEATER FLE	T COND EX T INC EX INCIN 02 INCIN 02 INCIN 02 TSORB(12) TSORB(12) TSORB(12) TSORB(12) TSORB(2) THENUM TSORB(24) TVENT THUM OUT TFBH PRES BED DP PLENUM OP PLENUM OP FBH NOX FBH SO2 ANTR AIR (M) REG NGAS (M) REG NGAS (M)	TE-387 TE-200 AT-802-8 AT-802-8 FY-30 SY-30 SY-30 AT-02-3 TE-378 TE-376 TE-376 TE-376 TE-376 TE-376 TE-377 TE-376 PDT-3776 AT-M02-3 AT-602-3 FY-300 FY-3008 FY-3008	DEG F DEG F PERCENT PPM DEG F F/HR F/JEC F/JEC PERCENT DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F M20 PPM PPM SCFM SCFM	34 6655 731 781000 6.07 328.1 7.60 1222 1146 1170 650 6.62 17.27 17.40 18.41 13.32 71.4 .0.22 0.00	33, 566 (19,16) 720 720 720 720 720 720 720 720 720 720	34 571 18.87 554 564 560 870 6.10 870 6.10 870 870 822 9833 901 16.88 807 922 9833 901 16.88 807 922 9833 901 11.26 10.71 10.70 11.20 20 22 0.22 0.000	36 507 18.92 504 FBH102 8.95 6.31 4.96.1 8.20 16.42 9.29 9.05 8.20 9.11 10.37 11.14 10.40 9.00 9.41 10.40 9.45 11.	34, 539 19.16 916 8966 8.34 455,5 8.20 16.83 966 818 8066 9.568 10.90 9.588 10.90 9.588 10.90 9.588 10.90 9.589 11.24 11.37 9.67 9.029 0.020	33 593 586 586 886 886 886 886 884 884 884 884 884 8	34 614 18.75 78H105 870 9.07 14.75 901 9.00 18.75 901 9.9 91 861 800 10.01 10.38 861 10.38 861 10.38 9.0 9.0 9.0 9.0 9.0 0.00 0.02 0.022
FLUID BED HEATER FLE	T COND EX T INC EX INCIN 302 NCIN 302 TSORB(12) NATURAL GAS AHTR AIR (MA FBH VEL FBH 02 TANTR OUT TPLENUM TSORB(24) TVENT THUM OUT TFBH PAES BED 0P PLENUM OP FBH NOX FBH NOX FBH SO2 AATTR AIR (M) REG NGAS (M)	$\begin{array}{c} TE = -387\\ TE = -200\\ AT = 502 - 6\\ AT = 802 - 6\\ FY - 802 - 6\\ FY - 80\\ FY - 30\\ SY - 30\\ TE - 376\\ TE $	DEG F DEG F PERCENT PPM DEG F F/HR F/HR F/HR F/HR F/HR F/HR F/HR F/H	34 866 18.96 1200 807 328.1 7.50 16.19 1222 1146 1170 837 660 8.62 17.27 17.40 18.41 3.32 17.46 18.41 3.32 71.10 8.52 17.27 17.40 18.41 3.52 17.27 17.40 18.41 3.52 17.27 17.40 18.41 3.52 17.40 18.41 19.55	33 566 5700 5700 570 570 570 570 570 5	34 571 18.87 554 870 870 870 870 822 863 801 16.88 807 922 863 801 16.89 800 3.84 10.70 11.25 800 3.84 10.71 10.70 98.2 90.220 0.220 0.220 0.520 98.22 9.520 98.22 9.520 9.5000 9.50000 9.5000 9.5000 9.50000 9.50000 9.50000 9.50000 9.5000000 9.50000000000	35 807 18.92 804 FBH102 835 631 438.1 8.20 18.42 829 807 819 807 819 807 819 807 819 807 819 807 819 807 819 807 819 807 819 807 819 807 819 819 819 819 819 819 819 819	34 539 19.16 815 955 6.34 435.5 6.34 6.35 6.34 6.35	33 593 18.86 586 586 586 586 586 586 586 5	34 614 18.75 78H105 870 870 870 449.1 18.75 901 901 901 801 18.75 800 10.01 10.38 861 10.38 861 10.38 861 10.38 90.3 90.3 90.3 90.3 90.22 0.000 FBC106
FLUID BED HEATER FLE	T COND EX T INC EX INCIN 302 NCIN 302 TSORB(12) TSORB(12) MATURAL GAS AHTR AIR (MA FBH VEL FBH 02 TANTR OUT TPLENUM TSORB(24) TVENT THUM OUT TFBH PAES BED 0P PLENUM OP FBH NOX FBH PAES BED 0P FBH SO2 AHTR AIR (M) REG NGAS (M) REG NGAS (M) REG NG (M)	TE - 387 TE - 200 AT - 02-8 AT - 802-8 FY - 80 FY - 88 FY - 30 8Y - 30 AT - 02-3 TE - 378 TE - 378 TE - 378 TE - 378 TE - 378 TE - 378 TE - 378 FY - 300 FY - 306 FY - 306 FY - 340	DEG F DEG F PERCENT PPM DEG F F/MR F/MR F/MR F/MR F/MR F/MR F/MR F/MR DEG F DEG F DEG F DEG F DEG F DEG F M20 PPM SCFM	34 866 18.96 1200 807 328.1 7.50 16.19 1222 1146 1170 837 6500 6.62 17.27 17.40 18.41 3.32 17.46 18.41 3.32 17.47 11.4 0.02 0.00 7.53 1950 96 7.53 1950 1950 1950 1950 1950 1950 1950 1950	33 566 5700 5700 570 570 570 570 570 5	34 671 18.87 554 970 610 448.8 520 610 448.8 507 3822 863 807 863 807 863 807 802 803 801 18.86 803 803 804 803 804 803 804 803 804 803 804 804 805 805 805 805 805 805 805 805 805 805	35 807 18.92 955 6.31 438.1 8.20 955 6.31 14.38 16.42 929 906 807 819 906 807 819 906 807 819 906 807 819 906 807 819 807 819 807 807 807 807 807 807 807 807	34 539 19.16 815 815 955 6.34 435,5 6.35 6.50	33 593 586 586 586 586 586 586 586 586	34 614 18.75 78H106 870 870 870 870 449.1 18.75 901 901 901 881 881 881 800 10.01 10.38 861 10.38 861 10.38 861 10.38 9.47 0.00 9.8.3 0.22 0.000 FBC106 8.48 254.4 254.4
FLUID BED HEATER FLE	T COMD EX T INCE EX INCIN 302 NCIN 302 TSORB(12) MATURAL GAS AHTFAIR (MA FBH VEL FBH 02 TANTR OUT TPLENUM OP FBH NOX FBH PAES BED 0P PLENUM OP FBH NOX FBH SO2 AHTR AIR (M) REG NGAS (M) REG NGAS (M) FBC AIR VEL AIR (M) TPLENUM	TE - 387 TE - 200 AT - 02 - 5 AT - 802 - 5 FY - 80 FY - 80 SY - 30 SY - 30 AT - 02 - 3 FY - 30 SY - 30 TE - 372 TE - 376 FY - 30 FY -	DEG F DEG F PERCENT PPM DEG F F/HR F/MR F/MR F/MR F/MR F/MR F/MR DEG F DEG F DEG F DEG F DEG F NEO PPM SCFM SCFM SCFM SCFM SCFM SCFM SCFM SCFM SCFM DEG F F/DEC F/	34 866 18.96 1731 781 7328 1220 0.07 328.1 7.80 16.19 1222 1146 1170 937 650 6.62 17.27 17.40 18.41 3.32 17.46 18.41 3.32 17.7.7 7.1,0 18.41 3.32 17.7.7 7.7.7 7.7.60 18.41 20.00 7.7.81 19.00 1	33, 566 5700 5700 570 570 570 570 570 5	34 671 18.87 5544 970 670 670 670 670 670 670 872 843 807 807 843 807 807 807 807 807 807 807 807 807 807	35 807 18.92 934 935 6.31 436.1 8.20 935 6.31 16.42 929 936 807 819 936 807 819 936 807 819 936 807 819 936 807 819 807 819 807 819 807 819 807 819 807 807 807 807 807 807 807 807	34 539 19.16 815 955 6.34 435.5 6.34 6.35 6.34 435.5 6.34 435.5 6.34 435.5 6.34 435.5 6.34 435.5 6.34 435.5 6.34 435.5 6.34 6.35 6.34 6.35 6.	33 593 586 586 586 586 586 586 586 586	34 614 18.75 70 870 870 870 870 870 97 449.1 9.870 901 993 861 18.75 860 10.03 861 10.38 861 10.38 9.47 0.00 9.8.3 0.22 0.00 75C108 8.48 26.44 1040 0.45 1040
FLUID BED HEATER FLE	T COMD EX T INCE EX INCIN 302 NCIN 302 TSORB(12) TSORB(12) MATURAL GAS AHTR AIR (MA FBH VEL FBH 02 TAHTR OUT TPLENUM TSORB(24) TVENT THUM OUT TSORB(24) TVENT THUM OUT FBH PAES BED 0P PLENUM OP FBH NOX FBH SO2 AHTR AIR (M) REG NGAS (M) REG NGAS (M) FBC AIR VEL AIR (M) TPLENUM	TE - 387 TE - 200 AT - 02-8 AT - 802-8 FY - 802-8 FY - 802-8 FY - 802-8 FY - 300 SY - 300 SY - 300 SY - 300 TE - 372 TE - 373 TE - 373 TE - 373 TE - 373 TE - 373 TE - 373 AT - 802 - 3 FY - 300 FY - 3106 FY - 3106 FY - 340 FY - 3	DEG F DEG F PFRCENT PPM DEG F F/HR F/HR F/MR F/MR PERCENT DEG F DEG F DEG F DEG F DEG F DEG F DEG F F/DEC F/DE	34 866 18.96 1731 781 732 1220 0.07 16.19 1222 1146 1170 18.22 1146 1170 18.22 1146 1170 18.41 1.322 1146 18.41 1.322 17.72 17.40 18.41 1.322 17.40 18.41 1.322 17.40 18.41 1.322 17.40 18.41 1.322 17.40 18.41 19.022 10.0	33, 566 5700 5700 5.16 5700 5.16 5700 5.16 5700 5.16 5700 5.16 500 500 500 500 500 500 500 50	34 6711 18.87 5544 970 610 448.8 907 982 863 807 982 863 807 863 807 802 863 801 802 863 801 802 863 801 802 863 801 802 863 803 803 804 803 804 803 804 804 804 804 804 804 804 804 804 804	35 807 18.92 955 6.31 436.1 437.1 437	34, 539 19.16 815 855 955 6.34 435,5 8.20 10.53 965 955 955 10.50 10.50	33 593 586 586 586 586 586 586 586 586	34 614 18.75 70 870 870 870 870 870 97 97 901 993 861 18.75 901 993 861 18.75 860 10.01 10.38 9.47 0.00 9.8.3 0.22 0.00 75C108 8.48 8.44 1040 9991 16.35
FLUID BED HEATER FLE	T CONDEX T INCE N 02 INCIN 902 TSORB(12) MATURAL GAS ANTR AIR (M) FBH VEL FBH 02 TANTR OUT TFOERLAN TSORB(47) TFUENUM OP PLENUM OP FBH PAES BED OP PLENUM OV FBH SO2 ANTR AIR (M) REG NGAS	TE - 387 TE - 200 AT-602-6 AT-802-6 FY-30 SY-30 AT-802-3 TE - 373 TE - 370 TE - 376 TE - 376 TE - 376 TE - 376 TE - 376 TE - 376 PDT-376 PDT-376 PDT-376 PDT-376 PDT-376 PDT-376 PDT-376 PDT-376 PDT-376 PDT-376 PDT-376 PT-366 PDT-366 PDT-366	DEG F DEG F PERCENT PERCENT PERCENT FIARC FIARC PERCENT DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F H20 H20 H20 FIARC FIAC	34 865 16.96 731 78000 6.07 325.1 7.800 6.11 17.800 6.92 1146 1170 937 7.90 6.92 1.927 7.77 7.70 8.92 0.00 7.83 225.3 1046 901 19.222 2.6.3 1046 901 19.222 2.6.3 1046 901 19.222 2.6.3 1046 901 19.222 2.6.3 1046 901 19.222 2.6.3 1046 901 19.222 2.6.3 1046 901 19.222 2.6.3 1046 901 19.222 2.6.3 1046 901 19.225 1046 1047 1047 1047 1047 1047 1047 1047 1047	33, 566 5700 5700 5.16 5700 5.16 5700 5.16 5700 5.16 5700 5.16 5700 5.16 500 500 500 500 500 500 500 50	34 671 16.67 554 70 610 610 610 610 610 70 922 923 801 500 16.88 907 16.88 907 10.77 922 963 3.64 10.70 9.00 96 22 0.22 0.22 0.22 0.22 0.22 0.22 0.22	35 807 18.92 934 935 631 436.1 436.1 436.1 436.1 937 837 837 837 837 837 837 837 8	34 539 549 559 562 563 563 563 563 563 563 563 563	33 593 593 594 594 594 594 594 594 594 594	34 614 18.75 78.4106 78.401 870 870 870 870 970 970 801 18.75 800 10.01 10.38 861 10.36 9.47 0.03 9.00 0.03 9.00 0.03 0.03 0.03 0.03
FLUID BED HEATER FLE	T COMD EX T INC EX INCIN 02 INCIN 02 INCIN 02 TSORB(12) MATURAL GAS ANTR AIR (M) FBH VEL FBH 02 TANTR OUT TFDERUM FBH PRES BED DP PLENUM OP FBH NOX FBH SO2 ANTR AIR (M) REG NZ (M) REG NZ (M) REG NZ (M) FBC AIR VEL AIR (M) T PLENUM OP FBC PRES T UPPER	TE - 387 TE - 200 AT - 602 - 6 AT - 602 - 6 AT - 602 - 6 FY - 30 SY - 30 TE - 373 TE - 376 TE - 376 TE - 376 TE - 376 TE - 376 TE - 376 TE - 376 PDT - 376 PT - 360 FY - 300 SY - 340 FY - 360 FY - 360 FY - 366 TE - 364 TE - 364 TE - 364	DEG F DEG F PERCENT PPM JMR JMR JMR JMR JMR JMR JMR JMR JTJSEC DEG F DEG F DEG F DEG F DEG F H20 H20 H20 H20 H20 H20 H20 H20 H20 H20	34 865 18.96 731 785 1200 8.07 1328.1 7.800 8.07 1322 1146 1370 937 1922 1146 1370 937 1922 17.97 17.40 18.32 0.00 7.83 226.3 1046 991 19.226 991 19.226 90 19.207 19.20	33 566 19.16 17.20 570 570 570 570 500 500 10.20 11.24 550 10.20 11.24 550 10.20 11.24 550 56.32 262.5 10.00 56.65 56.62 56.6	34 671 16.67 554 70 6.10 6.10 6.10 6.10 6.00 16.88 907 922 963 901 500 11.25 901 1.25 901 1.25 901 1.25 901 1.25 901 1.25 901 90.22 9.02 9.02 9.02 9.02 9.02 9.02 9.0	35 507 16.92 504 FBH102 895 6.31 435.1 8.20 16.42 929 906 907 919 9.11 10.37 11.14 10.40 95.49 90.00 9.11 10.37 11.14 10.42 929 908 907 919 910 95.49 909 900 911 10.37 11.14 95.42 909 900 911 10.37 11.14 95.42 909 900 900 911 10.37 11.14 95.42 900 900 900 900 900 900 900 90	34, 539 19.16 850 896 896 896 896 896 896 896 896	33 593 593 594 594 594 594 594 594 594 594	34 614 16.76 4665 870 6.07 449.1 9.00 16.78 90 16.78 90 10.39 80 10.39 90 10.39 90 10.39 90 10.39 90 10.39 90 10.39 90 0.00 90 90 0.00 90 90 0.00 90 90 90 90 90 90 90 90 90 90 90 90 9
FLUID BED HEATER FLE	T COMD EX T INC EX INCIN 02 INCIN 02 INCIN 02 TSORB(12) NATURAL GAS ANTR AIR (M) FBH VEL FBH 02 TANTR AUT TFUERUM FBH PRES BED DP FBH PRES BED DP FBH NOX FBH SO2 ANTR AIR (M) REG NGAS (M) FBC AIR VEL AIR (M) T PLENUM OP FBC PRES T UPPER T AIR T AIR T AIR T AIR T AIR T AIR	TE - 387 TE - 200 AT - 602 - 8 AT - 802 - 8 FY - 30 FY - 30 TE - 373 TE - 370 TE - 376 TE - 376 TE - 376 TE - 376 PDT - 376 FY - 300 FY - 300 FY - 300 FY - 300 FY - 300 FY - 360 FY - 360 FY - 360 FY - 360 FY - 366 TE - 362 TE - 361 TE - 362 TE - 362 TE - 362 TE - 362 TE - 362 FY - 366 TE - 361 TE - 361	DEG F DEG F PFRCENT PPM DEG F FARR FARR FTASEC DEG F DEG F DEG F DEG F DEG F DEG F H20 H20 PFM SCFM SCFM SCFM SCFM SCFM DEG F DEG F	34 865 18.96 731 785 1200 6.07 325.1 7.500 1222 1146 1170 937 600 6.62 17.27 17.40 1.322 717.40 1.3.41 3.32 717.40 1.3.41 3.32 717.40 1.3.41 3.32 7.41 1.0.22 0.00 FBC008 991 1992 5.69 5.69 5.69 5.69 5.69 5.69 5.69 5.69	33 566 19.16 19.16 7200 FBH099 870 6.16 449.3 8.21 17.39 929 962 901 10.13 10.20 960 10.13 10.20 96.3 96.3 0.22 0.00 FBC099 6.52 262.5 1000 956 6.49 2.244 950 956 6.49 2.244 950 956 6.49 2.244 950 956 6.49 2.244 950 956 6.49 2.244 950 11.545 6.49 2.244 950 11.545 1.545 1.000 11.545 1.000 11.545 1.0000 1.0000 1.0000 1.0000 1.0000 1.0000 1.0000 1.0000 1.0000 1.0000 1.0000 1.0000 1.00000 1.00000 1.0000 1.000000 1.00000 1.0000000 1.000000	34 6711 16.67 5544 FBH100 6.10 6.10 6.10 6.00 16.88 907 922 9633 901 16.88 907 922 9633 901 10.70 96.2 96.2 96.2 90.2 2 9.0.2 2 9.0.2 2 9.0.2 2 9.0.2 2 9.0.	35 807 18.92 804 FBH102 FBH102 FBH102 835 6.31 435.1 8.20 19.92 929 929 929 929 929 929 929	34 539 19.16 815 895 895 895 845 995 995 995 995 995 995 995 9	33 593 593 594 594 594 594 594 594 594 594	34 614 16.75 4695 70 6.07 919 901 901 901 901 901 901 901 901 901
FLUID BED HEATER FLE	Т СОМО ЕХ Т ІІКС ЕХ ІКСІМ 302 ТЗОАВ(12) ТЗОАВ(12) МАТИРА САВ АНТРА АВ (12) ТЗОАВ(12) ТЗОАВ(12) ТЗОАВ(12) ТЭСАВ(12) ТЭСАВ(2) РЕН УАС РЕН УАС РЕН РАСЗ ВСО ОР РЕСКИМ ОР ГЕЛИМО УТ ГВИ РАСЗ ВСО ОР РЕСКИМОР ГЕЛИМО УТ ГВИ АЛА (14) РЕСАЛЯ УЕЦ АЛЯ (14) Т ОСРЕЗ Т ОР САЛЯ УЕЦ АЛЯ СР Т ОР САЛЯ УЕЦ АЛЯ СР Т ОР САЛЯ УЕЦ АЛЯ СР Т ОР Т ОР Т ОР САЛЯ УЕЦ АЛЯ СР Т ОР Т О	TE - 387 TE - 200 AT - 602 - 8 AT - 802 - 8 FY - 30 FY - 88 FY - 30 TE - 379 TE - 379 TE - 376 PT - 376 FY - 300 FY - 3006 FY - 3006 FY - 3006 FY - 3006 FY - 3400 FY - 340	DEG F DEG F PFRCENT PPM DEG F FARE FARE FTSEC DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F H20 H20 H20 H20 H20 H20 H20 H20	34 865 18.96 1200 1200 1200 15.19 1222 1146 1170 1325 1146 1170 1327 10 1422 1170 1327 10 144 1170 1327 1146 1170 1441 1327 1146 1146 1147 10 14 14 14 10 14 14 14 10 14 14 14 14 14 14 14 14 14 14 14 14 14	33 566 19.16 19.16 17.200 FBH059 8700 5700 50000 5000 5000 5000 5000 50	34 6711 16.67 5544 FBH100 6.10 6.10 6.10 6.10 6.00 16.88 907 922 9633 9001 5.82 9001 1.25 9633 9001 1.25 9633 9001 1.25 9632 9633 9633	35 807 18.92 804 FBH102 FBH102 835 6.31 448.1 8.90 958 958 958 958 958 958 958 958 958 958	34 539 19.16 856 896 6.34 445.5 8.20 16.53 961 10.56 10.50 963 10.20 963 10.20 963 10.20 963 10.20 963 10.00 965 10.00 963 10.20 963 10.00 965 10.20 965 10.00 965 10.00 965 10.00 965 10.00 965 10.00 965 10.00 965 10.00 965 965 965 965 965 965 965 965	33 593 593 594 594 594 594 595 595 595 595	34 614 76 76 76 76 76 76 76 76 76 76 76 76 76
FLUID BED HEATER FLE	T CONDEX T INCE EX INCEN 02 INCEN 02 IN	TE -387 TE -200 AT-602-6 AT-802-6 FY-30 FY-30 FY-30 TE-370 TE-370 TE-376 PDT-376 PDT-376 PDT-377 AT-802-3 FY-30 FY-3006 FY-3006 FY-3006 FY-3006 FY-3006 FY-360 FY-366 PDT-366 FT-366 S02REF	DEG F PERCENT PPM DEG F FARCENT PPM FARCENT DEG F FTSEC DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F M30 H30 H30 FTSEC FARCENT FTSEC FARCENT DEG F H30 DEG F H30 DE	34 865 18.96 7311 FBH099 1200 6.07 328.1 7.500 18.19 1222 1146 1170 937 60.6 8.52 17.27 17.40 18.41 13.32 7.11 0.6 5.52 7.7.40 18.41 13.52 7.7.40 19.42 17.50 17.40 17.50 8.57 17.40 19.52 10.00 19.52 10.00 19.52 10.00	33 566 19.16 19.16 17.200 FBH059 8700 5700 50000 5000 5000 5000 5000 50	34 6711 16.87 5544 FBH100 6.10 6.10 6.10 922 9633 9001 5.82 900 3.644 10.70 98.2 0.00 98.2 0.00 78.00 258.6 977 6.89 9.2 9.00 258.6 977 6.89 9.2 9.00 258.6 977 6.89 9.2 9.2 9.2 9.2 9.2 9.0 9.2 9.0 9.0 9.0 9.0 9.0 9.0 9.0 9.0 9.0 9.0	35 807 18.92 804 FBH102 FBH102 895 995 995 995 995 995 995 995 995 995	34, 539 19.16 859 896 6.34 435.5 8.20 961 10.80 956 918 10.80 956 918 10.80 956 956 956 956 956 956 956 956	33 593 595 595 595 595 595 595 5	34 614 16.75 495 70 870 870 870 870 919 919 901 919 901 10.01 10.01 10.01 10.01 10.01 10.01 10.01 10.01 10.01 10.01 10.00 98.3 0.02 99.0 99.0 99.0 99.0 99.0 99.0 99.0
FLUID BED HEATER FLE	T COMD EX T INC EX INCIN 02 INCIN 02 IN	TE -387 TE -200 AT-602-6 AT-802-6 FY-30 FY-30 TE-379 TE-379 TE-379 TE-376 PDT-376 FY-30 FY	DEG F PERCENT PPM JEG F PERCENT PPM JAIA JAIA JAIA JAIA JAIA JAIA JAIA JAI	34 8655 18.96 7311 FBH099 1200 6.07 1328.1 7.800 1146 1170 1327 146 1170 1327 146 1170 1327 146 1170 146 1170 146 1170 16.02 17.47 19.47 1	33 566 19.16 17.200 FBH099 8700 5700 5700 5700 50000 5000 5000 5000 500	34 6711 16.87 5544 FBH100 6.10 448.6 570 6.10 582 963 3001 5.82 907 922 963 3001 5.82 907 922 963 3001 5.82 907 922 963 3.84 10.70 98.2 0.02 96.2 0.00 98.2 0.00 97.5 0.00 97.5 0.00 98.2 0.00 98.5 0.00 98.5 0 97.5 97.5 97.5 97.5 97.5 97.5 97.5 97.5	35 8077 18.92 804 FBH102 FBH102 895 995 995 995 995 995 995 995 995 995	34, 539 19.16 305 539 545 545 545 545 545 545 545 54	33 593 593 594 594 594 594 594 594 594 594	34 614 767 768 769 769 769 769 769 769 769 769 769 769
FLUID BED MEATER FLE	T COMD EX T INC EX INCIN 92 INCIN 92 IN	TE -387 TE -200 AT - 602-6 AT - 602-6 FY - 30 FY - 36 FY - 36 FY - 30 TE - 379 TE - 379 TE - 379 TE - 379 TE - 379 TE - 379 FY - 30 FY	DEG F PERCENT PPM JEG F PERCENT PPM JAIA JAIA JAIA JAIA JAIA JAIA JAIA JAI	34 8655 18.96 1200 6.07 1328.1 7.80 1222 1146 1170 1327 146 1170 1327 146 1170 146 1170 1327 146 1170 146 1170 146 1170 16.02 17.47 19.47	33 566 19.16 17.200 FBH099 8700 5700 5700 5700 5001	34 571 16.87 584 FBH100 6.10 448.8 570 6.10 448.8 570 922 9633 901 5.820 3.64 10.77 96.2 96.3 96.3 96.3 96.10 96.2 96.3 96.10 96.2 96.3 96.2 96.3 96.10 96.2 96.2 96.3 96.2 96.3 96.2 96.3 97.9 96.2 96.3 96.2 96.3 96.2 96.3 96.2 96.3 96.2 96.3 97.9 96.2 96.3 96.2 96.3 96.2 96.3 96.2 96.3 96.2 96.3 96.2 96.3 96.2 96.3 96.2 96.2 96.3 96.2 96.3 96.2 96.2 96.3 96.2 96.2 96.3 96.2 96.2 96.3 96.2 96.3 96.2 97.5	35 807 18.92 804 7584102 7584102 895 995 995 995 995 995 995 995 995 995	34, 539 19.16 305 5.50 5.	33 593 593 594 595 595 595 595 595 595 595	34 614 76 76 76 76 76 76 76 76 76 76 76 76 76
FLUID BED MEATER FLE	T COMD EX T INC EX INCIN 02 INCIN 02 INCIN 02 INCIN 02 INTURAL GAB AHTR AIR GM FBH VEL FBH 02 TAHTR AUT T PERNUM T PERNUM FBH NOX FBH	TE - 387 TE - 200 AT - 602 - 6 AT - 802 - 6 FY - 30 TE - 373 FY - 86 FY - 30 TE - 379 TE - 376 TE - 376 TE - 376 TE - 376 FY - 30 TE - 376 FY - 377 TE - 376 FY - 377 FY - 30 FY - 377 FY - 30 FY - 30 FY - 300 FY	DEG F PERCENT PPM DEG F FREENT PPM DEG F FTARC FTARC DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F H20 PPM SCFM SCFM SCFM PPM PPM PPM PPM PPM PPM PPM	34 8665 18.96 1200 1200 1200 15.19 1202 1200 15.19 1222 1146 1170 1327 1222 1146 1170 1327 1046 1146 1146 1146 1146 1146 1146 1146	33 566 57200 57200 57200 57200 5720 5720 5720 5720 5720	34 571 16.87 584 FBH100 6.10 6.10 570 6.10 522 6.33 600 500 500 500 500 500 500 500	35 8077 18.92 804 895 895 895 895 895 895 895 895 805 805 805 805 805 805 805 805 805 80	34, 539 19.16 315 535 545 545 545 545 545 545 54	33 593 593 594 595 595 595 595 595 595 595	34 614 78 78 78 70 870 870 870 870 877 449.1 870 870 870 870 870 870 870 870 870 870
FLUID BED HEATER FLE	T COMB EX T INC EX INCIN 92 INCIN 92 INCIN 92 INCIN 92 INTURAL GAB AHTR AIR GA FBH VEL FBH 02 TAHTR AIR GA FBH VEL FBH 02 TAHTR AUT T PUENUM TSORE(47) TVENT THUM OUT FBH PAES BED 0P FBH NOX FBH PAES BED 0P FBH NOX FBH SO2 AHTR AIR (M) REG NGAS (M) FBC PAES BED 0P FBC PAES T UPPER T AIR AIR PAES AIR 0P FBC PAES AIR 0P FBC PAES T NAR AIR PAES AIR 0P T AIR MO T T NOX(ADA) OUTLET SO2(ADA) AIR (M) TR HOPPER	TE - 387 TE - 200 AT - 602 - 6 AT - 802 - 6 AT - 802 - 6 FY - 30 TE - 373 FY - 30 AT - 62 - 8 FY - 30 AT - 62 - 8 FY - 30 TE - 379 TE - 300 SO - 340 TE - 360 TE - 360 SO 28 FY - 360 FY - 360 SO 28 FY - 360 FY - 360 SO 28 FY - 360 FY - 360 F	DEG F PERCENT PPM JEG F PERCENT PPM JEG F FTAEC PERCENT FTAEC DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F NBO SCFM SCFM SCFM PPM PPM PPM PPM PPM PPM PPM PPM PPM P	34 8665 18.96 1200 1200 16.07 1328.1 17.800 18.19 1222 122 122 122 124 1146 1146 1146 114	33 566 57200 57200 57200 57200 5720 5720 5720 57200 5720 5720 5720 5720	34 571 16.87 584 FBH100 6.10 6.10 6.10 6.20 16.88 907 922 953 965 925 953 965 907 98.2 0.00 98.5 0.00 98.5 0.00 975 13.87 6.88 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.00 975 5.85 0.85 0.00 975 5.85 0.85 0.00 975 5.85 0.00 975 5.85 0.85	35 8077 18.92 804 804 805 805 805 805 805 805 805 805 805 805	34 539 19.16 315 535 545 545 545 545 545 545 54	33 593 593 594 595 595 595 595 595 595 595	34 614 16.76 4955 70 970 9870 9870 9871 9891 9811 9811 9811 9811 9811 9811
FLUID BED HEATER FLE	T COMB EX T INC EX INCIN 92 INCIN 92 INCIN 92 INCIN 92 INTURAL GA8 ANTR AIR GA FBH VEL FBH 08 TANTR AUT T PERNUM TSORB(47) TVENT THUM OUT FBH PAES BED 0P FBH NOX FBH PAES BED 0P FBH NOX FBH SO2 ANTR AIR (M) TFBH PAES AIR (M) TFBC AIR VEL AIR (M) TCOMER BEO 0P FBC AIR VEL AIR (M) TCOMER AIR (M)	TE -387 TE -200 AT-802-6 AT-802-6 AT-802-6 FY-30 TE-373 TE-370 TE-376 TE-376 TE-376 TE-376 TE-376 PDT-376 PDT-376 PT-376 PT-377 AT-802-3 FY-30 ST-376 PT-376 PT-376 PT-376 PT-377 AT-802-3 FY-30 ST-376 TE-362 TE-37	DEG F DEG F PFRCENT PPM DEG F FIRE FTREC PERCENT FTREC DEG F DEG F DEG F DEG F DEG F DEG F DEG F N20 PPM SCFM SCFM SCFM SCFM SCFM SCFM SCFM SCFM SCFM SCFM SCFM SCFM SCFM DEG F PBG PPM PPM PPM PPM PPM PPM PPM PP	34 866 866 867 867 867 1200 8.07 1200 8.07 1200 8.07 1200 8.07 1200 8.07 1200 8.07 1200 8.07 1200 8.07 1200 8.07 1200 8.07 1200 8.07 1200 8.07 1200 8.07 1200 8.07 1200 8.07 1146 1.046 9.07 1.046 9.0466 9.046 9.046 9.0466 9.0466	33 566 57200 57200 57200 5721 5720 5721	34 571 16.87 584 FBH100 6.10 6.00 6.00 9.82 0.00 9.82 0.00 9.82 0.00 9.82 0.00 9.82 0.00 9.82 0.00 9.82 0.00 9.85 0.00 9.75 0.22 8.55 0.00 9.75 0.00 0	35 8077 18.92 804 804 805 805 805 805 805 805 805 805 805 805	34 539 19.16 816 816 816 816 816 816 820 19.64 19.64 10.90 8.63 949 949 949 949 949 949 949 94	33 533 533 586 586 586 586 586 586 586 580 580 580 580 580 580 580 580	34 614 16.76 4955 70 6.07 449.1 9.00 16.78 901 901 901 901 901 901 901 901 901 901
FLUID BED HEATER FLE	Т СОМО ЕХ Т ІІКС ЕХ ІКСІМ 302 ПСІМ 302 ТЗОЛВ(12) МАТИЛАL GAB АНТГА АВ (М) Р БІН VEL Р БІН ОВ ТАНТЯ АЙ (М) Т Р LENUM Т Р LENUM OP F БІН NOX F БІН РАЄЗ ВЕ D OP Р LENUM OP F БІН NOX F БІН NOX F БІН NOX F БІН SO2 АНТГА АІЯ (М) Т LENUM OP F БІС РАЄЗ (М) Р Е В СОР Р LENUM OP F БІС РАЄЗ (М) REG NGA (M) Т LENUM P LENUM OP F БІС РАЄЗ (М) Т LENUM OP F БІС РАЄЗ (М) Т LENUM OP F БІС РАЄЗ (М) Т LENUM OP F БІС РАЄЗ (М) ЛІЯ РАЄЗ (А) ОUTLET SO2(AD) AIR PAES AIR PAES AIR PAES AIR PAES AIR PAES AIR PAES AIR PAES AIR OP T LENUM OP F BC PAES T LEPPER T LAP COMB AIR T COMB AIR T COMB AIR T FUR REFR T FUR REFR T	TE -387 TE -200 AT-802-8 AT-802-8 AT-802-8 FY-30 FY-30 TE-373 TE-370 TE-377 TE-377 TE-377 TE-378 PDT-378 PT-378 PT-378 PT-378 PT-378 PT-378 PT-378 PT-378 PT-378 PT-378 PT-378 PT-378 TE-378 TE-378 TE-378 TE-378 TE-378 TE-378 TE-378 TE-378 TE-378 TE-378 TE-378 TE-378 TE-378 TE-380 PT-380 SV-380 FY-300 FT-360	DEG F DEG F PERCENT PPM JEG F FREGENT FTREC DEG F FTRECENT DEG F DEG F DEG F DEG F DEG F M20 H20 PPM SCFM SCFM SCFM SCFM SCFM DEG F H20 H20 PPM PPM PPM PPM PPM PPM PPM PPM PPM PP	34 866 18.96 1200 1200 1200 1200 1200 1200 1200 1116 1116	33, 566 5700 5700 5710 57200 5720 5720 5720 5720 5720 5720 5720 5720 5720 5	34 57 57 58 57 58 57 57 58 57 57 58 57 57 58 58 50 50 50 50 50 50 50 50 50 50	35 807 18.92 804 78H102 895 805 805 805 805 805 805 805 805 805 80	34, 539 19.16 316 316 316 316 316 316 316 3	33 33 33 34 35 35 35 35 35 35 35 35 35 35	34 614 16.76 495 70 449.1 9.0 9.0 9.19 9.19 9.19 9.19 9.19 9.1
FLUID BED HEATER FLE	T COMB EX T INC EX INCIN 302 INCIN 302 INCIN 302 INCIN 402 ANTURAL GAS ANTR AIR GM FBH VEL FBH 08 TANTR AUT T PLENUM T PLENUM FBH NOX FBH NOX	TE -387 TE -2000 AT-802-8 AT-802-8 AT-802-8 FY-30 FY-30 TE-373 TE-370 TE-377 TE-377 TE-377 TE-378 PDT-378 PT-378 PT-378 PT-378 PT-378 PT-378 PT-378 PT-378 PT-378 PT-378 PT-378 PT-378 TE-380 TE-380 PT-386 SO2REF NOXPEF NOXPEF NOXPEF NOXPEF TE-38 SO2REF NOXPEF TE-38 SO2REF NOXPEF TE-38 SO2REF TE-38 SO2REF TE-38 SO2REF TE-38 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-36 SO2REF TE-1 TE-6 TE-1 TE-6 TE-1	DEG F DEG F PERCENT PPM DEG F FIRE FTREC DEG F FTREC DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F D	34 546 566 587 598 1200 507 1200 507 1200 507 1200 507 1200 507 1200 507 1200 507 1166 1196 1	33, 566 5700 5700 5700 5700 5700 5700 501 5010 500	34 57 57 58 570 570 570 570 570 570 570 570	35 807 18.92 804 78H102 895 805 805 805 805 805 805 805 805 805 80	34, 539 19.16 316 316 316 316 316 316 316 3	33 33 33 34 35 35 35 35 35 35 35 35 35 35	34 614 16.76 495 70 449.1 9.0 9.0 9.19 9.19 9.19 9.0 9.19 9.19
FLUID BED HEATER FLE	Т СОМО ЕХ Т ІІКС ЕХ ІКСІМ 302 ПСІМ 302 Т SORB(12) Т SORB(12) МАТИРАК 4040 АНТГАК 4040 АНТГАК 4040 Т SORB(12) Т SORB(12) T SORB(12) SORB(12) T SORB(12) T SORB(1	TE -387 TE -200 AT-602-6 AT-802-6 AT-802-6 FY-30 AT-802-7 FY-30 AT-02-3 TE-373 TE-373 TE-373 TE-376 PDT-376 PDT-376 PDT-376 PDT-376 PDT-376 PT-370 FY-30 FY-3005 FT-305 FY-3005 FT-305 FY-3005 FT-305 FT-305 FT-305 FT-305 FT-305 FY-3005 FT-3	DEG F DEG F PERCENT PPM DEG F FREG FREG FREG FREG FREG FREG FREG FRE	34 546 566 58.96 1200 1200 1200 1200 1200 1200 1200 1200 1200 1200 1200 1200 1200 1200 1200 1200 1146 1170 1037 1046 104	33, 566 19.16 17.200 FBH059 870 6.16 449.3 8.21 17.09 8.20 17.09 8.21 17.09 8.20 10.13 10.20 10.13 10.20 10.13 10.20 10.2	34 57 57 58 57 58 57 57 58 57 57 57 58 58 58 58 58 58 58 58 58 58	35 807 18.92 804 FBH102 FBH102 895 6.31 495.1 820 16.42 929 855 800 956 800 951 11.14 10.40 9.55 11.14 10.40 9.55 11.14 10.40 9.55 11.14 10.40 9.55 11.14 10.40 9.55 11.14 10.40 9.55 11.14 10.40 9.55 11.14 10.40 9.55 11.14 10.40 9.55 11.14 10.40 9.55 11.14 10.40 9.55 11.14 10.40 9.55 11.14 10.40 9.55 11.14 10.40 9.55 10.00 9.55 10.00 9.55 10.00 9.55 10.00 9.55 10.00 9.55 10.00 10.00 9.55 10.00 10.00 9.55 10.00 10.00 9.55 10.00 10.00 10.00 9.55 10.00 10	34, 539 19.16 316 316 316 316 316 316 316 3	33 33 34 35 35 35 36 36 36 36 36 36 36 36 36 36	34 614 16.76 780 700 760 760 760 760 760 760 760 306 760 306 500 10.78 780 760 760 760 306 500 760 306 500 760 306 500 760 306 500 760 306 500 760 306 500 760 306 500 760 306 500 760 306 500 760 306 500 760 306 500 760 306 500 760 306 500 760 306 500 760 760 760 760 760 760 760 760 760 7
FLUID BED HEATER FLE	T COMP EX TINCEN 02 INCEN 02 INCEN 02 INCEN 02 INCEN 02 INCEN 02 INTERAL GAS ANTRAIL GAS ANTRAIL GAS ANTRAIL GAS ANTRAIL GAS TANTR OUT TFDERUM PEN 02 TANTR OUT TFDERUM 07 FBH PAES BED 0P PLENUM 07 FBH PAES BED 0P PLENUM 07 FBH PAES BED 0P FBH NOX FBH SO2 ANTRAIR (M ANTRAIR OF FBC AIR VEL AIR (M TFLENUM 07 FBC AIR VEL AIR (M TFLENUM 07 TPLENUM 07 TRE NOZAD (M TRE NOZAD AIR (M TRE NOZAD AIR (M TR NOPER AIR 07 TRE NOZAD AIR (M TR NOZAD AIR (M T	TE -387 TE -2000 AT-02-6 AT-802-6 AT-802-6 FY-30 SY-30 TE-373 TE-376 PDT-376 PDT-376 PDT-377 PDT-376 PDT-377 PDT-376 FY-300 SY-340 FY-340 FY-340 FY-340 FT-360 TE -362 TE -362	DEG F DEG F PERCENT PERCENT PERCENT PERCENT FTAREC TARE FTAREC DEG F DEG F DEG F DEG F DEG F DEG F H20 H20 H20 H20 H20 H20 H20 H20 H20 H20	34 54 565 16.96 1200 1200 1200 1200 1200 1200 1200 1222 1176 1222 1176 1222 1176 1222 1176 1177 100 1222 1176 1176 1192 1222 1176 1176 1192 1222 1176 1196 1197 1297	33 566 19.16 17.20 570 570 570 570 500 500 500 50	34 671 16.87 554 FBH100 6.10 6.10 6.10 6.20 16.88 507 922 963 901 500 1.25 901 1.25 901 1.25 901 1.25 901 1.25 901 1.25 901 1.25 901 1.25 901 1.25 901 1.25 901 1.25 901 1.25 901 1.25 901 1.25 902 9.22 9.75 1.57 7.5 5.50 9.75 1.57 7.5 5.50 9.75 1.57 7.75 5.54 5.50 9.76 1.57 7.75 5.55 5.50 9.22 9.55 5.50 9.22 9.55 5.50 9.22 9.55 8.50 9.22 9.55 8.50 9.75 9.55 8.50 9.22 9.55 8.50 9.22 9.55 8.50 9.55 8.50 9.22 9.55 8.50 9.55 8.50 9.22 9.55 8.50 9.55 8.50 9.55 8.50 9.55 8.50 9.55 8.50 9.55 8.50 9.55 8.50 9.55 8.50 9.55 8.50 9.55 8.50 9.55 8.50 9.55 8.50 9.3	35 807 16.92 804 FBH102 895 805 805 805 805 805 805 805 80	34, 539 549 549 549 549 549 549 549 54	33 593 593 594 594 594 594 594 594 594 594	34 614 16.76 16.76 4465 570 16.77 449.1 5.00 16.07 919 501 500 10.01 11.35 500 0.00 0
FLUID BED HEATER FLE	T COMD EX T INC EX INCIN 02 INCIN 802 TSORB(12) NATURAL GAS ANTR AIR GAS TSORB(12) TSORB(12) NATURAL GAS ANTR AIR GAS FBH VEL FBH PRES ED DP PLENUM OUT FBH PRES BED DP PLENUM OUT FBH PRES BED DP PLENUM OUT FBH NOX FBH NOX FBH SO2 ANTR AIR (M) REG R2 (M) REG R2 (M) REG R2 (M) FBC AIR VEL AIR (M) FBC AIR VEL AIR (M) TPLENUM OP FBC PRES T UPPER T AIR AIR 02 PEENUM OP FBC PRES T UPPER T AIR AIR 02 ANTR AIR OP PLENUM OP FBC PRES T UPPER T AIR AIR OP PLENUM OP FBC ORS T UPPER T AIR AIR OP PLENUM OP FBC ORS T UPPER T AIR AIR OP COMB AIR T CO AIR HTR T MOT AIR T FUR REAT T OF GAS T ABS FGAS T ABS FGAS T ABS OT T ABS 21 T ABS 21 T ABS 21 T	TE -387 TE -2000 AT-602-6 AT-602-6 AT-602-6 FY-300 TE-373 FY-86 FY-300 SY-300 TE-3770 TE-376 PDT-376 PDT-377 PDT-376 PDT-377 FY-300 FT-360 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-360 FT-30 FT-30 FT-30 FT-360 FT-30 FT-30 FT-30 FT-30 FT-360 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30 FT-30	DEG F DEG F PERCENT PPM JMR JMR JMR JMR JMR JMR JMR JMR JMR JM	34 54 565 18.96 1200 1200 1200 1200 17.90 1222 1116 1177 500 6.67 17.40 1.177 500 6.62 17.92 17.40 1.177 500 6.62 17.92 17.40 1.177 500 6.62 17.92 17.40 1.1744 1.1744 1.1744 1.174	33 566 57200 57200 5720 5720 5720 5720 5720 5720 5720 5720 5829 5	34 57 67 16.87 564 FBH100 6.10 6.10 6.10 6.10 6.20 16.88 507 922 503 500 11.25 500 11.25 500 11.25 500 11.25 500 500 500 500 500 500 500 5	35 807 18.92 804 FBH102 FBH102 895 803 1435 1435 1435 1435 1435 1435 1435 1435 1435 1445 1545 1	34, 539 549 549 549 549 549 549 549 54	33 33 34 35 35 35 35 35 35 35 35 35 35	34 614 16.78 469 7649.1 870 6.07 449.1 8.20 16.78 901 919 861 10.38 11.35 500 10.01 11.35 500 10.01 11.35 500 10.01 11.35 500 10.01 11.35 500 10.01 11.35 500 10.00 11.35 500 10.00 11.35 500 10.00 11.35 500 10.00 11.35 500 10.00 11.35 500 10.00 11.35 500 10.00 11.35 500 10.00 11.35 500 10.00 11.35 500 10.00
FLUID BED HEATER FLE	T COMD EX T INC EX INCIN 02 INCIN 802 TSORB(12) NATURAL GAS ANTR AIR (M) FBH VEL FBH 02 TANTR AIR (M) FBH VEL FBH PRES BED DP PLENUM OP FBH PRES BED DP PLENUM OP FBH NOX FBH 802 ANTR AIR (M) REG NGAS	TE -387 TE -2000 AT-02-6 AT-802-6 AT-802-6 FY-300 TF-378 PFY-30 TE-3770 TE-3770 TE-3770 TE-3776 PDT-3767 PDT-3777 PDT-3777 PDT-3777 PDT-3777 PDT-3777 PDT-37	DEGF DEGF PFM PFM JARR JARR JARR JARR JARR JARR JARR JAR	34 565 16.96 1200 1200 1200 1200 1200 1200 1200 1200 1200 1200 1222 117.60 0.00 6.62 17.70 0.00 6.62 17.70 0.00 6.62 17.40 1.17.40 1.17.40 1.3.52 1.17.40 1.3.52 1.17.40 1.3.52 1.17.40 1.3.52 1.17.40 1.5.52 1.5.5	33 566 57200 57200 57200 5720	34 57 57 58 57 58 57 58 57 58 57 58 50 50 50 50 50 50 50 50 50 50	35 807 18.92 804 FBH102 FBH102 FBH102 928 9395 9305	34, 539 549 549 549 549 549 549 549 54	33 593 593 594 594 594 594 594 594 594 594	34 614 614 614 616 607 607 607 607 607 607 607 60
FLUID BED HEATER FLE	T COMD EX T INCE N 02 INCEN 02 INCEN 02 INCEN 02 INCEN 02 INCEN 02 INCEN 02 INTERAL GAS ANTRAIL GAS ANTRAIL GAS ANTRAIL GAS INTERAL GAS INTERNIC INTER	TE -387 TE -200 AT-602-6 AT-602-6 AT-602-6 AT-602-8 FY-30 FY-30 SY-30 TE-370 TE-376 PT-376 PDT-377 PDT-377 PDT-377 PDT-377 PDT-378 PDT-378 PDT-378 PDT-378 PT-368 FY-30 SY-30 F	DEGF DEGF PPM JEGF PERCENT PPM JEGF JANR FTRECE DEGF DEGF DEGF DEGF DEGF H20 DEGF H20 DEGF H20 DEGF H20 DEGF H20 H20 DEGF H20 H20 DEGF DEGF DEGF DEGF DEGF DEGF DEGF DEGF	34 54 565 18.96 1200 1200 1200 1200 17.90 1222 1146 1170 1222 1146 1170 1222 1146 1170 1222 1146 1170 1222 1146 1170 1222 1146 117,800 6.62 17.90 7.40 1.0.42 2.0.00 FBC088 6.62 17.90 7.40 5.90 9.91 1.10 6.62 7.63 9.00 7.60 7.60 7.	33 566 57200 57200 57200 5720	34 57 57 58 57 58 58 58 58 50 50 50 50 50 50 50 50 50 50	35 807 18.92 804 FBH102 FBH102 FBH102 929 935 945 945 945 945 945 945 945 94	34, 539 549 550 550 550 550 550 550 550 55	33 593 593 594 594 594 594 594 594 594 594	34 614 614 614 616 607 607 607 607 607 607 607 60
FLUID BED HEATER FLE	T COMD EX T INCE X INCEN 02 INCEN 02 IN	TE -387 TE -200 AT-602-6 AT-602-6 AT-602-6 AT-602-7 FY-30 FY-30 SY-30 TE-370 TE-376 PT-376 PT-376 PT-376 PT-376 PT-376 PT-376 PT-376 PT-376 PT-376 PT-376 PT-376 PT-376 PT-376 PT-376 PT-376 PT-376 FY-30 FY-	DEG F DEG F PFRCENT PPM JEG F JAHR FTRECENT DEG F FTRECENT DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F DEG F D	34 54 565 18.96 1200 1200 1200 1200 1200 15.19 1222 1146 1170 1322 1146 1170 1322 1146 1170 1322 1146 11750 607 10.02 17.500 6.62 17.500 10.600 10.500	33 566 5700 5700 5700 5700 5700 500 500	34 57 57 58 57 58 58 58 58 58 58 58 58 58 58	35 807 18.92 804 FBH102 835 6.31 438.1 8.20 19.85 807 919 900 911 10.37 11.14 10.40 95.9 900 911 10.37 11.14 10.40 95.9 900 911 10.37 11.14 10.40 95.9 900 911 10.37 11.14 10.40 95.9 900 900 911 10.40 95.9 900 900 911 10.37 11.14 10.40 95.9 900 900 900 900 900 900 900 9	34, 539 549 550 550 550 550 550 550 550 55	33 33 34 35 35 36 36 36 36 36 36 36 36 36 36	34 614 614 614 616 607 607 607 607 607 607 607 60

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MBCUO-10	PARAMETER	TAG	E/V	1	2	3	4	8		- 1	
				COMB091	COMB092	COMBORS	COMB094	COMBOSE	COMBOS	COMB097	
COMBUSIONFILE	COMB AIR	FY-1	\$/HR	503.1	502.9 0.00	803.9 0.00	0.00	0.00	21.81	21.92	
	NATURAL GAS	FY-20	#/HR	25.01	25.01	25.01	25.01	26.01	3.13	3.13	
	COAL	WKT-25	J/HA	0.00	0.00	0.00	0.00	0.00	39.70	39.23	
	EXCESS AR	BY-X	%X8A	20.00	19.99	20.01	19.95	20.01	21.92 683790	21.81	
	HEATINPUT	BTU EV-16	STU/HR	670117	673220	566.3	566.2	566.2	821.8	520.2	
	FURNACE 02	AT-02-0	*	3.77	3.81	3.91	3.80	3.86	3.96	-1.08	
	FURNACE P	PT-6 PT-1	H2O Psig	-0.99	4.69	4.65	4.76	8.02	4.89	4.62	
	MOTIVE AIR P	PT-3	PSK	98.04	98.03	99.22	98.06	96.66	8.51	8.52	1
	NATURAL GAS P	PT-20 PT-16	-H20	4.00	6.27	6.13	8.19	6.09	4.64	5.40	
	COOL H20 P	PT-25	PSIG	113.46	113.30	419.16	419.22	419.21	375.35	377.28	
	THEOR AIR	BY-X AT-CO2-0	PERCENT	10.03	10.00	9.91	9.84	9.80	14.37	14.47	
	FURNACE CO	AT-CO-0	PPM	10.52	11.27	11.76	12.33	9.89	80.01	80.18	
	MOTIVE AR V	SY-3 FY-15	SCFM	121.3	121.4	121.4	121.4	121.4	111.4	111.8	
	PLOC GIV (1)			100100	488108	ABS110	AB8111	AB8112	AB8113	ABS114	1
ABSORBER FLE	INF ET 802	AT-502-1	PPM	2246	2264	2240	2283	2242	205	2077	
	INLET NOX	AT-NOK-1	PPM	225	264	4.39	4.34	4.46	3.9	3.58	
	INLET 02	AT-802-1	PPM	300	33	284	382	400	274	314	
	OUTLET NOX	AT-NOX-2	PPM	218	26	2 210	4.47	4.61	4.0	3.96	
	NO SPIKE	FT-101	#/HR	0.00	0.0	0.00	0.00	0.00	0.0	0.00	4
	SO2 SPIKE	FT-102	#/HR	1.56	0.00	0 0.001	0.001	0.001	0.16	5 0.000	1
	BED OP	PDT-19	H2O	1.07	1.2	6 1.61	1.80	507.7	1.5	508.2	1
	FLUE GAS (M)	FY-17	#/HR -H20	8.02	7.9	7 7.83	7.90	7.7	6.2	7.18	P
	SCREEN DP	PDT-21	H20	0.87	0.9	9 1.94	1.21	1.60	0.7	7 736	1
	GAS INLET	TE-18 TE-21	DEGF	681	68	1 68	67	67	5 58	8 870	1
	SORB IN	TE-390	DEGF	714	72	1 714	67	3 66	5 69	0 601	i
	SORB OUT	SO2REF	PERCENT	36.4	84.	8 87.1	83.	82.	86.	5 84.8	4
	NOX REMOVAL	NOXREF	PERCENT	2.0	0.	4 1.0	108.	108.	108.	9 106.	5
	FLUE GAS (V)	FT-17	- OURM	100.	1		PEOL	DE CI14	REGIN	REG114	Н
REGENERATOR FILE		AT-02-44	PERCENT	RE G108	REG10	HEG110	2 0.0	0 0.0	0 0.0	1 0.04	-
	REGEN 802	AT-802-4	PERCENT	42.3	45.5	4 46.7	39.7	3 46.9 1 13.7	6 39.6 1 17.2	2 19.0	ť
	REGEN CH4	AT-CH4-4	PERCENT	41.6	2 44.0	3 40.0	\$ 36.7	6 38.3	9 37.8	3 37.2	1
	REGEN H28	AT-H28-4	PERCENT	0.0	0 0.0	0 0.0	0 0.0	0.0	0 0.0	5 0.1	5
	REGEN 02	AT-02-48	#/HR	0.2	0 0.4	0.4	1 0.6	0 0.4	1 0.0	0 0.6	2
	NITROGEN	FY-310	#/HR	0.0	0 0.0	0.0	0 0.0	0 0.0	7 3.4	7 2.3	8
	REGEN P SOBBLEVEL	PT-380 LT-380	INCHES	24.9	8 26.1	8 16.5	8 24.9	2 7.8	6 24.1	2 25.1	
	TSORB (2)	TE-381	DEGF	85	7 8	15 55	1 79	2 88	1 8	16 84	2
	TSORB (177 TSORB (327)	TE-363	DEGF	86	4 8	73 94	8 82	0 96	4 8	8 85	5
	TSORB (47)	TE-384	DEGF	90	9 9	29 94	1 88	4 92	8 9	14 97	5
	T OFFGAS	TE-386	DEGF	27	6 2	76 27	9 27	8 27	3 2	6 <u>27</u> 33 3	릙
	T COND EX	TE-387	DEGF	62	2 6	33 54	9 50	50 50	2 6	7 59	4
	INCIN 02	AT-02-5	PERCEN	r 18.8	2 18.	67 19.1	2 19.1	0 18.0	9 3	75 22	5
	INCIN SO2	AT-802-1	PPM	- 49	3 0					FOUND	
FLUID BED HEATER FLE			-	FBH10	FBH10	9 FBH110	FBH11	FBH11	2 FBH11	24 92	26
	TSORB(12)	TE-373	JEGF #/HR	6.0	4 6.	65 6.1	2 6.1	9 6.	6.	43 6,4	-
	AHTR AIR (M)	FY-30	#/HR	415	.2 411	29 8	.0 460	.6 461	31 8.	29 8.3	10
	FBH VEL FBH 02	AT-02-3	PERCEN	T 16.0	2 16.	06 16.	6 16.	78 16.	56 16. 7 10	45 16.1	7
	TAHTR OUT	TE-370	DEGF	10	10 10	48 10	50 9	35 9	50 9	81 98	4
	TSORB(247)	TE-374	DEGF	9	57 9	65 9	57 8	72 8	92 9	17 91	릙
	TVENT	TE-376	DEGF	8	00 5	92 8	9 5	00 8	00 5	00 50	00
	FBH PRES	PT-376	H20	9.	87 9.	54 9.	10.	02 10.	28 9. 59 9.	49 8.5	74
	BED DP	PDT-376	H20 H20	10.	95 11	.08 11.	06 11.	28 11.	36 11.	21 11.4	22
	FBH NOX	AT-NOX-	3 PPM	16.	45 16	.04 17.	34 12.	46 13. 00 2.	36 5	66 3.	75
	FBH 502	FY-30	SCFM	90	.8 9	1.7 94	.3 96	.7 96	15	22 0	4
	REG NGAS (V)	FY-3008	SCFM	0.	22 0	.15 0.	00 0.	00 0.	00 0	00 0.0	00
	HEG N2 (V)	PT-3105	BUT M			-		1 EBAN	2 FRC	3 FBC11	4
FLUID BED COOLER FLE	ERC APRIL	8V-160	FT/SEC	FBC10	51 FBC1	.50 8.	61 8.	48 8.	48 8	.49 8.	48
	AIR (M)	FY-360	#/HR	251	.6 25	2.8 26	0.0 25	75 10	8.0 25 79 10	7.9 253	65
	TLOWER	TE-362	DEGF	10	04 10	06 9	78 9	94 5	99	10	02
	BED DP	PDT-36	H20	12.	81 10	23 14	71 14.	23 7	.67 11	.00 11.	<u>∡1</u> 93
	FBC PRE8	PT-366	H20	2	16 2	.27 2	21 2	.30 2	.55 2	.49 2.	23
	TUPPER	TE-364	DEGE	10	55	007 S	55 5	158 0	58	567 5	46
	THEATER	TE-360	DEG	'°	80	79	92	82	74	82	78
	AIR PRES	PT-360	PSKi H2O	2	.84 0	.72 2	.91 0	.86 0	.85	.87 0.	.84
	INLET SO2(ADJ	SO2REF	PPM	21	40 2	351 23	48 23	102 2	425	281 2	122
	INLET NOXIAD	NOXREF	PPM		34	264	233	216	220	348 5	118 509
	OUTLET NOXIAD	A NOXREF	PPM		230 5.1	265 3	5.9 5	5.8 5	6.4 8	6.4 5	5.6
	TR HOPPER	SSCYCLE	B CYCL	E	519	848 1	78 1	150 1	721 1	931 21	113
THE ADDRESS OF THE				TEMPO	91 TEMP	092 TEMP	193 TEMP	94 TEMP	095 TEMP	096 TEMPO	97
TEMPENATURE FILE	COMB AR T	TE-1	DEGI	-	73	72	50	550	67	650	599
	CO AIR HTR T	TE-3	DEG		65	67	68	60	56	67	66
	FUR REFR T	TE-4	DEG	2	246 2	233 2	262 2	267 2 016 1	264 2	087 1	187
	FURN EXIT T TOT FGAS T	TE-18	DEG	F	855	855	861	849	845	867 0	844
	ABS FGAS T	TE-18	DEG		386	386	385	385	385	385	305
	BGHS TOP T	TE-29	DEG		359	358	358	357	356	354	353
	BGHS BOT T	TE-30	DEG	F	369	750	750	750	750	760	760
	ABS Z2 T	TIC-64	DEG	F	761	750	750	750	750	760	741
	ABS Z3 T ABS Z4 T	TIC-91	DEG	F	750	750	780	750	750	750	760
	ABS Z6 T	TIC-97	DEG	F	750	750	109	111	106	107	10
	CW SUP T	TE-42	DEG	F	147	149	160	162	167	155	160
	CWECC EXT	TE-44	DEG	F	89	91	/0	10	/ 4		

Table 8. Gas Phase and Solid Phase Sulfur Recoveries

Test number & condition	Regener- ation temp, °F	Residence time, min	Absorber outlet hopper	Regenerator outlet hopper	Sorbent feed rate Ib/hr	SO ₂ removed (gas phase) #mol/hr	SO ₂ regen- erated (gas ph) #mol/hr	Error%	SO ₂ removed (solid phase) #mol/hr	Error%
MBCUO-8										
TC #5 1/21/96	850	120	3.27	1.65	45				0.0228	
TC #1 1/23/96	850	120	3.67	2.01	45	0.029	0.031	+6.9%	0.0233	-19.7%
TC #3 1/25/96	850	120	3.24	1.68	45	0.0246	0.0228	-7.3%	0.0219	-10.8%
TC #1A 1/26/96	850	120	3.97	2.06	45	0.0286	0.0345	+20.8%	0.0269	-5.9%
MBCUO-9										
TC #1 2/23/96	850	180	3.75	1.76	45	0.0277	0.0272	-3.7%	0.0280	+1.1%
TC #2 2/24/96	850	180	3.13	1.51	60	0.0307	0.0290	-5.5%	0.0304	-0.98%
TC #8 2/26/96	850	180	3.07	1.36	60	0.0295	0.0271	-8.1%	0.0321	+8.8%
TC #5 2/27/96	850	180	3.16	1.51	90	0.0316	0.0311	-1.9%	0.0464	+46.8%
TC #9 2/28/96	850	180	3.98	1.45	90	0.0433	0.0419	-4.3%	0.0712	+64.3%
TC #10 2/29/96	850	180	3.14	1.33	45	0.0347	0.0359	+3.5%	0.0254	-26.8%
TC #7 3/01/96	850	180	3.51	na	45	0.0278	0.0279	+0.4%	na	na
MBCUO-10										
TC #1 3/22/96	850	180	na	na	45	0.0279	0.0257	-7.9%	na	na
TC #3 3/23/96	850	180	3.36	1.5	45	0.0274	0.0227	-17.2%	0.0262	-4.4%
TC #4 3/24/96	850	120	3.34	1.37	45	0.0281	0.0242	-13.9%	0.0277	-1.4%
TC #5 3/25/96	800	180	3.5	1.55	45	0.0272	0.0257	-5.5%	0.0274	+0.07%
TC #7 3/27/96	850	60	3.51	1.8	45	0.0264	0.0241	-8.6%	0.0240	-9.1%
TC #8A 3/27/96	850	180			45	0.0281	0.0251	-10.7%	na	na

Table 9. Effect of Screen Design and Sorbent on Performance*

Parameter	MBCUO-6-9	MBCUO-7-1	MBCUO-8-1	MBCUO-9-1	MBCUO-10-1				
Sorbent	1/16" Gi	race		1/8" Alcoa					
Screen	Square Weave & Perforated Plate]	Bar					
Bed Dimensions H(ft) x W (ft) x D (in)		8 x 1 x 5							
SO ₂ Removal (%)	94	93	87	85	86				
Total Absorber Pressure Drop (in H ₂ O)	2.5	1.4	1.0	0.8	1.1				
Major Observations	Screen plugged with ash/sorbent fines during coal burn	New screen reduces plugging with lower pressure drop and no apparent change in SO ₂ removal	Larger sorbent yields lower pressure drop but also lower SO ₂ removal	Absorber parametric study	Regenerator parametric study				

* Natural Gas Fire; 110 SCFM Flue Gas Flow; 750°F Absorber; 2250 ppm SO₂ Spike; 0.75 lb/min Sorbent Flow; 850°F Regenerator; 2 or 3 Hr Regenerator Residence Time; Twice Stiochiometric Requirement of Methane fed to Regenerator.

PROTECTED CRADA INFORMATION Table 10. Absorber Pressure Drop Information in MBCuO-09.

Test Condition	MBCu(J-9-1	MBCu	10-9-2				MBCuO-9-8														
Fuel	Natura	l Gas	Naturi	al Gas									Coal	1								
Pulsing Status	Prof	ile	Рго	file	Pre-P	ulse	Post-F	lulse	Pre-P	ulse	Post-P	ulsc	Pre-P	ulse	Post-]	Pulse	Pre-H	Pulse	Post-F	.'ulse	Pro	file
Pressure Drop (in H ₂ O)	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total
Тор	0.7	0.8	0.7	0.9	4.8	5.0	0.7	1.1	3.9	4.3	0.9	1.2	2.9	3.3	1.2	1.7	3.9	4.5	0.6	1.1	0.6	1.0
Middle	0.6	0.8	0.7	0.9	4.1	4.8	1.1	1.6	3.1	4.3	0.9	1.5	2.2	3.5	0.8	1.4	2.2	3.9	0.3	1.1	0.3	0.9
Bottom	0.6	0.8	0.7	0.9	2.6	4.8	0.5	1.3	1.9	4.4	0.6	1.5	1.3	3.6	0.7	1.9	1.5	4.3	0.4	1.1	0.7	0.9
Test Condition				MBC	'uO-9-5								MBCu	0-9-9								
Fuel				C	Coal					1			Co	al			-					
Pulsing Status	Pre-P	ulse	Post-]	Pulse	Post-F	?ulse	Prof	äle	Pre-P	ulsc	Post-F	ulse	Pre-F	ulse	Post-]	Pulse	Pro	file				
Pressure Drop (in H ₂ O)	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total				
Тор	3.4	3.7	1.2	1.6	0.6	0.9	0.4	0.8	3.2	3.4	1.7	2.0	3.3	3.5	0.9	1.2	0.9	1.2				
Middle	3.3	3.8	1.0	1.5	0.5	0.8	0.5	0.9	3.0	3.4	1.6	2.0	3.0	3.5	0.8	1.0	1.0	1.2				
Bottom	2.7	3.7	1.0	1.4	0.6	0.8	0.5	0.9	2.2	3.4	1.5	2.1	2.4	3.4	0.8	1.1	0.9	1.0				

Test Condition		MBCuO-9-10										9-7 (1a)		
Fuel					Co	al					Natura	l Gas		
Pulsing Status	Pre-P	Pre-Pulse Pre-Pulse Pre-Pulse Profile										Profile		
Pressure Drop (in H ₂ O)	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total	Rear Screen	Total		
Тор	2.4	2.9	4.6	5.1	3.5	3.7	3.8	4.1	1.0	1.3	0.7	0.9		
Middle	2.0	3.1	3.5	4.9	1.4	2.0	3.2	4.2	1.0	1.3	0.8	0.9		
Bottom	1.7	3.0	2.5	0.9	1.2									

Note: Rear screen pressure taps located at three bed heights (top, middle, and bottom). Pressure taps for total pressure drop (front screen, sorbent bed, plus rear screen) are located at one bed height (near bottom). Total pressure drop is simultaneously recorded while rear screen pressure drop is sequentially profiled at three bed heights.

		MI	SCUO-7-5	&6	N	ABCUO-8-	3	м	BCUO-9-	10	MI	SCUO-10-	8a
Equi	pment	Mass	% Fra	action	Mass	% Fra	iction	Mass	% Fr	action	Mass	% Fra	ction
		(lb)	Total	Fly	(1b)	Total	Fly	(lb)	Total	Fly	(lb)	Total	Fly
Furnace Ashpot	Total Dust	32.9	35.9	-	14.2	30.2	-	10.0	24.2	-	NA	-	-
Absorber Inlet Ashpot	Total Dust	6.8	7.4	11.6	1.6	3.4	4.9	8.4	20.3	26.8	2.8	NA	14.1
Absorber Outlet Ashpot	Total Dust	7.0	7.6	11.9	4.6	9.8	14.0	2.6	6.3	8.3	4.0	NA	20.2
Furnace Baghouse	Total Dust	8.8	9.6	15.0	7.0	14.9	21.3	9.2	22.2	29.3	3.8	NA	19.2
Fluid-Bed Heater Baghouse	Total Dust	36.2	39.5	61.6	19.6	41.7	59.8	11.2	27.1	35.7	9.2	NA	46.5
Total	Total Dust	91.7			47.0			41.4			19.8		

Table 11. Total Dust Distribution for Select Coal-Fired Test Conditions

		N	1BCUO-7			MBCUO-8	3	N	ABCUO-9		M	IBCUO-10	,
Equi	pment	Mass	% Fra	action	Mass	% Fra	iction	Mass	% Fr	action	Mass	% Fra	ction
		(lb)	Total	Fly	(lb)	Total	Fly	(lb)	Total	Fly	(lb)	Total	Fly
Furnace Ashpot	Total Dust	73.7	33.6	-	15.0	11.5	-	84.0	21.2	-	17.2	7.9	-
Absorber Inlet Ashpot	Total Dust	11.2	5.1	7.7	7.7	5.9	6.6	42.0	10.6	13.4	21.9	10.1	11.0
Absorber Outlet Ashpot	Total Dust	14.1	6.4	9.7	22.4	17.1	19.3	67.0	16.9	21.4	29.8	13.7	14.9
Furnace Baghouse	Total Dust	35.3	16.1	24.2	11.1	8.5	9.6	47.8	12.1	15.3	18.7	8.6	9.4
Fluid-Bed Heater Baghouse	Total Dust	81.4	37.1	55.9	57.2	43.7	49.3	118	29.8	37.8	99.8	46.0	50.0
Fluid-Bed Cooler Cyclone	Total Dust	4.0	1.8	2.7	17.6	13.4	15.2	37.6	9.5	12.0	29.4	13.6	14.7
Total	Total Dust	219.3			131			396.4			216.8		
Coa	burnt	1905			808			2841			1147		
Ехрес	cted ash	191			80.8			284			115		
Sorben	t makeup	67.3			43.1			239			265.7		
Dust (expected) makeup	balance ash + sorbent -total dust)	39	17.8		-7.1	-5.4		127	32.0		164	75.6	

Table 12. Material Balances for Total Dust During MBCUO Tests

Test Condition	Cu%	# dust	# sorbent	# ash
#5, NG 1/21/96				
AB-IN-POT	0.6*	0.2	0.02	0.18
AB-OUT-POT	6.4*	2.6	2.52	0.08
вн	na	0	0	0
FBH	3.1*	5.4	2.54	2.86
#1, NG 1/23/96				
AB-IN-POT	0.6*	0.1	0.01	0.09
AB-OUT-POT	6.4*	3.8	3.68	0.12
ВН	0.3*	0.6	0.03	0.57
FBH	3.1 •	12.	5.64	6.36
#3, COAL 1/25/96				
AB-IN-POT	0.6	1.6	0.15	1.45
AB-OUT-POT	6.9	4.6	4.6	0
ВН	0.3	7	0.32	6.68
FBH	4.8*	19.6	14.25	5.35
#1A, NG 1/26/96				
AB-IN-POT	0.6	1.2	0.12	1.08
AB-OUT-POT	6.4	3	2.91	0.09
вн	0.3	2.6	0.13	2.47
FBH	3.1	11	5.17	5.83
POST				
AB-IN-POT	1	4.6	0.7	3.9
AB-OUT-POT	6.4	2.0	1.94	0.06
ВН	0.3	0.5	0.023	0.477
FBH	4.8	2.8	2.04	0.76
FBC	8.2	17.6	17.6	0
Ash collected in furnace pot				15.
Total wt, lbs		102.8	64.39	53.41
Coal fired	808 lbs			ash 80.8 lbs
Sorbent attrited	43.05			

Table 13. Ash and Sorbent Balances for MBCUO-8

Dust enclosure = (102.8 + 15) - (43.05 + 80.8) = -6.05 lbs (shortage)

Sorbent balance = 64.39 - 43.05 = 21.34 ibs (surplus) = 49.57% of sorbent makeup

Coal ash balance = 53.41 - 80.8 = -27.39 lbs (shortage) = -33.9% of expected coal ash including slag on furnace wall.

Note: If dust copper analysis is 6.6% or greater, the dust is considered as 100% sorbent.

* Indicates default copper analysis value.

Table 14. Ash and Sorbent Balances for MBCUO-9

Test Condition	Cu%	# dust	# sorbent	# ash
#1, NG 2/23/96				
AB-IN-POT	3.9	3.2	1.89	1.31
AB-OUT-POT	7.	26.2	26.2	0
вн	4.2	3.2	2.04	1.16
FBH	5.7	18.2	15.72	2.48
#2, NG 2/24/96			<i></i>	
AB-IN-POT	5.9	0.4	0.36	0.04
AB-OUT-POT	6.7	11.2	11.2	0
вн	1.2	0.2	0.04	0.16
FBH	6.3	26.6	25.39	1.21
#8, COAL 2/26/96	(921 Lbs fired)			
AB-IN-POT	3.4	11.8	6.08	5.72
AB-OUT-POT	6.8	13.6	13.6	0
ВН	0.5	11.8	0.89	10.91
FBH	6.4	17.0	16.48	0.52
#5, COAL 2/27/96	(744 Lbs fired)			
AB-IN-POT	0.5	2.4	0.18	2.22
AB-OUT-POT	5.9	6.2	5.54	0.36
ВН	0.3	7.6	0.35	7.25
FBH	4.5	18	12.27	5.73
#9, COAL 2/28/96	(549 Lbs fired)			
AB-IN-POT	0.2	13	0.39	12.61
AB-OUT-POT	7	4.4	4.4	0
ВН	0.2	11.4	0.35	11.05
FBH	3.4	16.2	8.35	7.85
#10, COAL 2/29/96	(549 Lbs fired)			
AB-IN-POT	0.1	8.4	0.13	8.27
AB-OUT-POT	4.5	2.4	1.64	0.76
вн	0.2	9.2	0.28	8.92
FBH	3.7	11.2	6.28	4.92

Table 14 continuation				
#7, NG 3/1/96				
AB-IN-POT	0.2	1.0	0.03	0.97
AB-OUT-POT	5.2	1.2	0.95	0.25
ВН	0.2	3.8	0.12	3.68
FBH	4	6.8	4.12	2.68
POST 3/4/96				
AB-IN-POT	0.2	1.8	0.05	1.75
AB-OUT-POT	5.4	1.6	1.3	0.3
ВН	0.2	0.6	0.02	0.58
FBH	4.7	4.0	2.85	1.15
FBC	8.0	37.6	37.6	0
TOTAL ASH IN FURNACE POT				84.0
TOTAL WT		312.2	207	189
COAL FIRED	2841 lbs			COAL ASH EXPECTED = 284 Ibs
SORBENT ATTRITED	239 lbs			•

TOTAL DUST UNACCOUNTED FOR = (284 + 239) - (207 + 189) = 523 - 396 = 127 Lbs

Sorbent balance = 207 - 239 = -32 lbs (shortage) = 13.4% of sorbent makeup

Coal ash balance = 189 - 284 = -95 lbs (shortage) = 33.5% of coal ash input

Note: If copper analysis on dust is 6.6% or greater it is considered as 100% sorbent dust.

Table 15. Ash and Sorbent Balances for MBCUO-10

Test	Cu%	# dust	# sorbent	# ash
Condition			# 001001R	<i>"</i> uon
#1 NG 3/22/96			·	
AB-IN-POT	0.5*	0.5	0.038	0.46
AB-OUT-POT	5.9*	8.0	7.15	0.85
вн	0.6*	6.4	0.58	5.82
FBH	5.4*	32	26.18	5.82
#3 NG 3/23/96				
AB-IN-POT	0.5	0.6	0.045	0.555
AB-OUT-POT	5.9	3.2	2.86	0.34
вн	0.6	0.3	0.027	0.273
FBH	5.4	7.2	5.89	1.31
#4 NG 3/24/96				
AB-IN-POT	· · · · · ·	0	0	0
AB-OUT-POT	5.9	3.8	3.4	0.6
BH		0	0	0
FBH	5.8	11.2	9.84	1.36
#5 NG 3/25/96				
AB-IN-POT	0.4	0.2	0.012	0.188
AB-OUT-POT	6.2	3.6	3.38	0.22
вн	0.6	0.6	0.055	0.545
FBH	5.6	11.0	9.33	1.67
#7 NG 3/27/96				
AB-IN-POT	0.5	0.2	0.015	0.185
AB-OUT-POT	6.2	3.2	3.0	0.2
вн	0.4	0.6	0.036	0.564
FBH	5.5	10	8.33	1.67

Table 15 continuation				
#8A COAL 3/27				
AB-IN-POT	0.2	2.8	0.085	2.715
AB-OUT-POT	0.3	4	0.18	3.82
вн	0.3	3.8	0.17	3.63
FBH	4.9	9.2	6.83	2.37
Table 15 continuation				
8C COAL 3/29				
AB-IN-POT	0.09	7.8	0.11	7.69
AB-OUT-POT	5.9	3	2.68	0.32
вн	0.9	4.4	0.6	3.8
FBH	4.8	9.6	6.98	2.62
POST				
AB-IN-POT	0.1	9.8	0.15	9.65
AB-OUT-POT	0.2	1.0	0.03	0.97
вн	0.2	2.6	0.079	2.521
FBH	8.8	9.6	9.6	0
FBC	7.2	29.4	29.4	0
Ash in furnace pot				17.2
TOTAL WT lbs		200.03	137.4	79.9
COAL FIRED	1147 lbs			coal ash expected = 115 lbs
SORBENT ATTRITED	265.73 lbs			

Total dust unaccounted for = (265.73 + 115) - (137.4 + 79.9) = 163.4 lbs

Sorbent unaccounted for = 265.73 - 137.4 = 128.33 lbs = 48.3% of sorbent

Coal ash unaccounted for = 115 - 79.9 = 35.1 lbs = 30.5% of coal ash

Note: If dust copper analysis is 6.6% or greater the dust is considered as 100% sorbent.

• Indicates default copper analysis value. The default value depends upon coal or gas fired.

		МВ	CUO-7-5	&6	N	(BCUO-8-:	3	M	BCUO-9-	10	MB	CUO-10-8	a
Equi	pment	Mass	% Fra	ction	Mass	% Fra	ction	Mass	% Fra	ction	Mass	% Fra	tion
		(lb)	Total	Fly	(lb)	Total	Fly	(lb)	Total	Fly	(lb)	Total	Fly
Furnace	Ash				14.2	51.3	-	10	30.4	-	NA	-	-
Ashpot	Total Dust	32.9	35.9	-	14.2	30.2	-	10.0	24.2	-	NA	-	-
	Ash				1.45	5.2	10.8	8.27	25.2	36.2	2.72	21.7	21.7
Absorber Inlet	Sorbent				0.15	0.8		0.13	1.6		0.09	1.2	
Ashpot	Total Dust	6.8	7.4	11.6	1.6	3.4	4.9	8.4	20.3	26.8	2.8	NA	14.1
	Ash	-			-	-	· _	0.76	2.3	3.3	3.82	30.5	30.5
Absorber Outlet	Sorbent			-	4.6	23.8		1.64	19.7		0.18	2.5	
Ashpot	Total Dust	7.0	7.6	11.9	4.6	9.8	14.0	2.6	6.3	8.3	4.0	NA	20.2
	Ash				6.68	24.1	49.6	8.92	27.1	39.0	3.63	28.9	28.9
Furnace Baghouse	Sorbent				0.32	1.7		0.28	3.4		0.17	2.3	
	Total Dust	8.8	9.6	15.0	7.0	14.9	21.3	9.2	22.2	29.3	3.8	NA	19.2
	Ash				5.35	19.3	39.7	4.92	15.0	21.5	2.37	18.9	18.9
Fluid-Bed Heater	Sorbent				14.3	73.8		6.28	75.4		6.83	93.9	
Baghouse	Total Dust	36.2	39.5	61.6	19.6	41.7	59.8	11.2	27.1	35.7	9.2	NA	46.5
	Ash				27.7			32.9			12.5		
Total	Sorbent				19.3			8.33			7.3		
	Total Dust	91.7			47.0			41.4			19.8		

Table 16. Sorbent/Ash Distribution for Select Coal-Fired Test Conditions

Table 17. Sorbent Attrition Data

Test	Sorb	ent		Absorber Design		Sorbent Number of Attrited Transport		Hours of Operation	Attrition Rate		
	Туре	Dia (in)	Retention Screen	Cross Section H(ft) x W(ft)	Bed Depth D(in)	(lb)	Hopper Cycles		(lb/hr)	(lb/hopper cycle)	
MBCUO-2						46.8	2533	80	0.585	0.018	
MBCUO-3	SOX-3		Square Wire Mesh			142.5	6740	208	0.686	0.021	
MBCUO-4		1/16	& Perforated			144.4	4834	150.4	0.960	0.030	
MBCUO-5		1/10	Plate			145	6153	191.4	0.758	0.024	
MBCUO-6	Grace			8 x 1	5	73	5210	130	0.562	0.014	
MBCUO-7						67.3	2085	122	0.552	0.032	
MBCUO-8			Spaced Bar with	· · · · ·		43.1	1423	170	0.254	0.030	
MBCUO-9	Alcoa	1/8	Vertical			239.1	2763	221	1.082	0.087	
MBCUO-10			Side			265.7	2082	219	1.213	0.128	

Sorbent Type	Sub- strate (5/8/96)	New (5/8/96)	Used (5/8/96)	Used (5/14/96)	
Bulk Density (lb/ft ³)	48.2	54.1	50.8	49.8	
Regulator Pressure (psig)	12	12	12	15	
Sorbent Removed to give 10 lbs. retained on 0.093 mesh (g)	53	· 9.	1542	N/A	
Begin Weight (g)	3016.4	3483.5	3179.0	3200.1	
Removed After 2nd transport (g)	2.7	2.6	4.1	6.4	
Removed After 4th transport (g)	2.0	3.0	5.4	11.2	
Removed After 6th transport (g)	2.1	2.3	6.0	9.8	
Returned After 8th transport (g)	2986.0	3433.4	3126.0	3114.5	
Removed After 8th transport (g)	2.2	2.7	6.0	12.4	
After Last Transport:					
0.093" > x >0.0278 " (g)	15.9	19	106.3	145.3	
0.0278" > x (g)	2.7	4	8.8	16.0	
Total Sorbent Fines Collected:					
x <0.0278" (g)	11.7	14.6	30.3	55.8	
0.093" > x >0.0278 " (g)	15.9	19	106.3	145.3	
TOTAL REMOVED (g)	27.6	33.6	136.6	201.1	

Table 18. Transport Attrition Results

Cold	Weight (g)	Percent of Initial	Percent of FBC Collection
Sorbent at Start	18144.0		
Final Sorbent from FBC	12627.7	69.6	
Sorbent from FBC > 0.093"	9296.0	51.2	73.6
Sorbent from FBC 0.093 > x > 0.0278	3114.1	17.2	24.7
Sorbent from FBC < 0.0278	217.0	1.2	1.7
Sorbent from FBC cyclone	4378.4	24.1	

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Ho+	Weight (g)	Percent of Initial	Percent of FBC Collection
Sorbent at Start	18144.0		
Final Sorbent from FBC	14860.4	81.9	
Sorbent from FBC > 0.093"	12089.3	66.6	81.4
Sorbent from FBC $0.093 > x > 0.0278$	2629.6	14.5	17.7
Sorbent from FBC < 0.0278	141.5	0.8	1.0
Sorbent from FBC cyclone	1732.5	9.6	

Table 19. Cold and Hot Attrition Results from the Fluidized-Bed Cooler



Figure 1. Pressure Drop and SO₂ Removal Versus Time for MBCUO-7 and MBCUO-8



Figure 2. Pressure Drop and SO2 Removal Versus Time for MBCUO-9





Figure ω Pressure Drop and S02 Removal Versus Time for MBCUO-10

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Figure 4. Effect of SO_2 Concentration on SO_2 Removal: Experimental and Calculated



Figure 5. Effect of Sorbent Flow on SO₂ Removal: Experimental and Calculated