U.S. DOE's Hg Control Technology RD&D Program—Significant Progress, But More Work to be Done!

A&WMA's 99th Annual Conference & Exhibition

Hg Control Technology Panel

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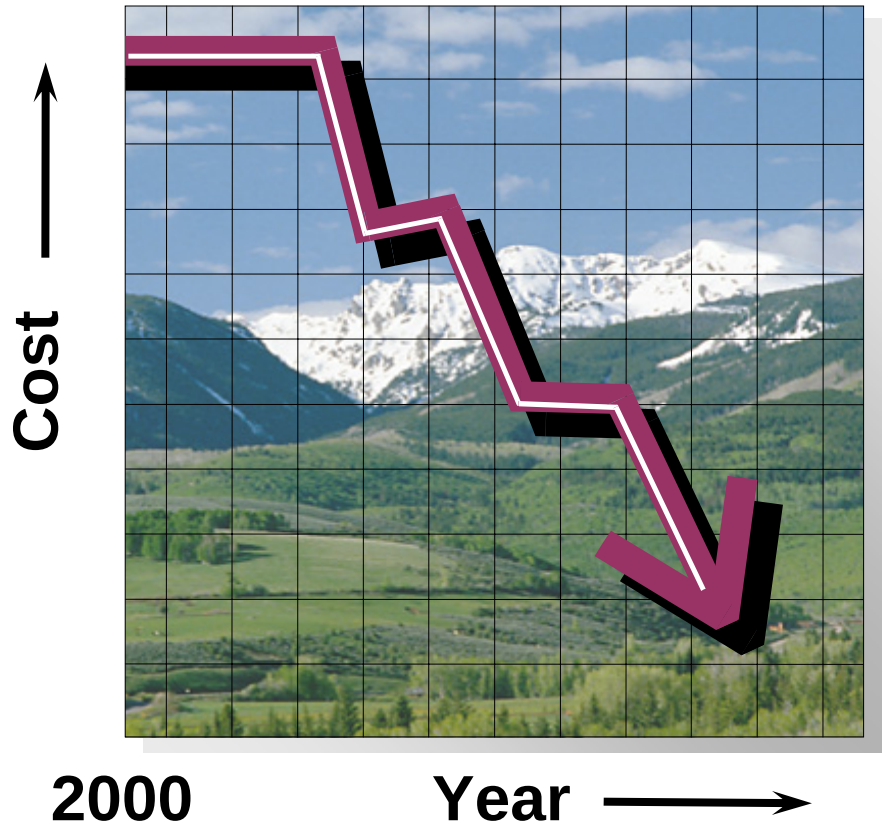
Outline

- Background
- Phase II project update/Phase III project descriptions
- BOP and related technical issues
- Preliminary economic assessment
- Byproduct-Hg issues/potential economic impacts
- Conclusion

Mercury Control Technology Program
Performance/Cost Objectives

- Have technologies ready for commercial demonstration by:
  - 2007 that can reduce "uncontrolled" Hg emissions by 50-70%
  - 2010 for all coals that can reduce "uncontrolled" Hg emissions by +90%
- Reduce cost by 25-50% compared to baseline cost estimates



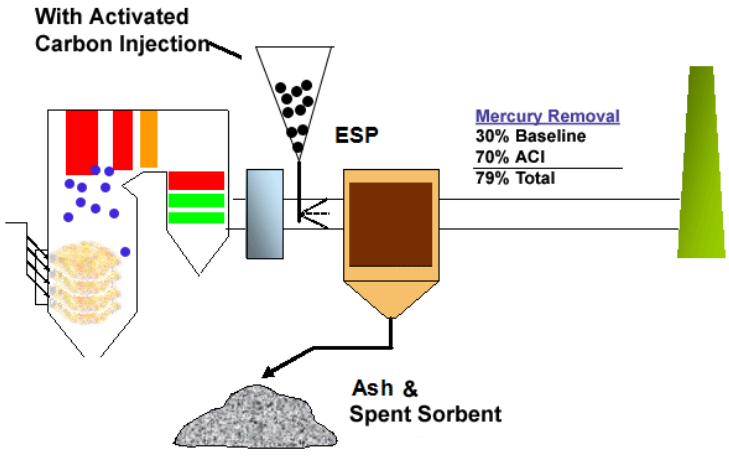
Baseline (1999) Costs: $60,000 / lb Hg Removed

NETL's Hg Control Technology R&D

- **Sorbent injection technology**
  - Carbon-based sorbents
    - Treated AC
    - Untreated AC
  - Non-carbon-based sorbents
    - Amended Silicates
    - MinPlus
- **Oxidation additives and catalysts**

Mercury Control Technology R&D
Improved Results with Western Coals

- Previous pilot-scale studies and field testing suggested lower-rank coals more difficult to control due to lower Cl/higher element Hg content
- Focused R&D on development and testing of chemically treated (e.g., halogenated) activated carbon (AC)
- Treated AC has achieved 70-90% total Hg capture with western coals in recent field tests on both ESP and fabric filter configurations
- However, additional demonstration of Hg capture technologies needed to address balance-of-plant and byproduct impacts



Balance-of-Plant Issues/Lessons Learned

TOXECON Retrofit for Hg and Multi-Pollutant Control
U.S. DOE Clean Coal Power Initiative, Round 1

Presque Isle Power Plant, Marquette, MI

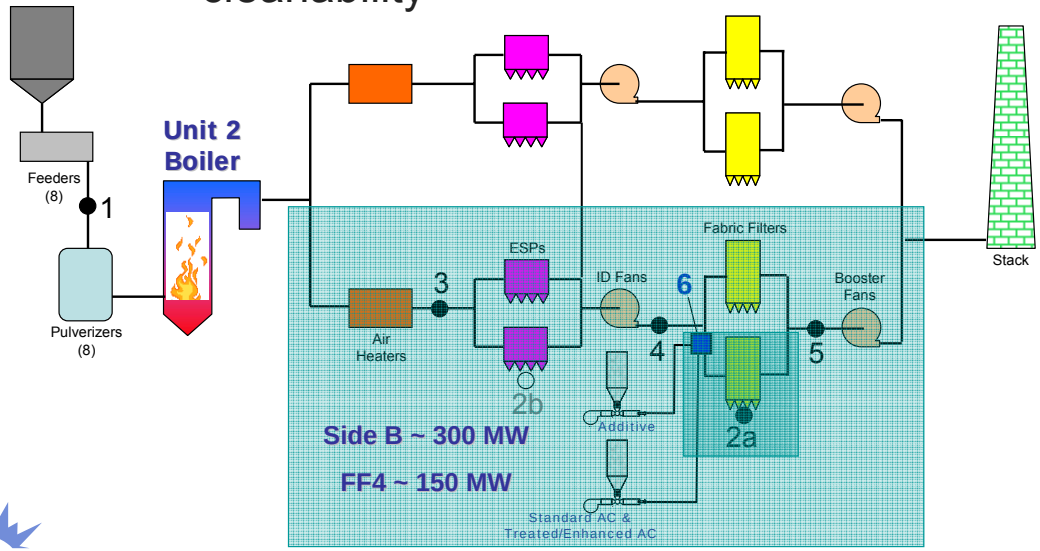
- **Plant was built in early 1950's and expanded over the years to 9 coal fired Units**
- **Nine units total 625 MW representing approximately 50% of the power generation in Michigan Upper Peninsula**
- **Units 7,8 & 9 are 90 MW units burning western bituminous, PRB coal**
- **PIPP currently sells fly ash for concrete**

Problem with Overheating Powdered Activated Carbon at Presque Isle

- Hot burning embers found on February 27, by March 2 all hoppers had embers
- System bypassed and opened to atmosphere, worsened situation, causing flames that damaged 200 bags in 2 (of 10) compartments
- Likely cause is excessive temperatures from hopper heaters
- PAC can ignite at temperature greater than 700 ^{o}F. (welding, cutting, hopper heaters)
- Investigation is ongoing

Mercury Control Options for TXU's Big Brown

- **Project Objective: Evaluate long term feasibility of activated carbon (AC), treated carbon, and additive injection for mercury control**
  - ≥ 55% mercury removal
  - Evaluate balance-of-plant (BOP) impacts
    - Increase in ΔP across FF4 over time
    - Increased difficulty in bag cleanability



- **Possible sources of BOP impacts:**
  - Injection of sorbent/additive material causing filter blockage.
  - Changes in flue gas or ash chemistry due to addition of sorbent/additive materials.
  - Changes in operating conditions during test period:
    - Flow rate variations (rebalancing of flow, increased flow)
    - Frequent flow bypass (when ΔP exceeded 10" H_2O)
    - Temperature fluctuations
    - Use of ash conditioning
    - Variation in fuel blend
    - Load variation
    - Unplanned outages, chemical and morphology analysis is ongoing

Upcoming NETL Field-Testing at Bituminous Units

Bituminous Unit	APCD Configuration	Start Date	Mercury Control	Coal Sulfur Content (wt%)
Yates Unit 1	CS-ESP / Wet FGD	September 2005	Oxidation Catalysts	0.93
Yates Unit 1	CS-ESP / Wet FGD	November 2005	MerCAP™	0.93
Yates Unit 1	CS-ESP / Wet FGD	Fall 2005	Wet FGD additive	0.93
Lee Unit 1	CS-ESP	November 2005	Enhanced ACI	0.77
Lee Unit 3	CS-ESP / SO_3 conditioning	1st Quarter 2006	Integrated Approach	0.82
Miami Fort Unit 6	CS-ESP	1st Quarter 2006	Amended Silicates™	2.21
Conesville Unit 6	CS-ESP / Wet FGD	March 2006	Enhanced ACI	3.00
Portland Unit 1	CS-ESP	March 2006	Mer-Cure™	2.01
Gavin Station	CS-ESP / Wet FGD	Unknown	TOXECON™ II	3.76

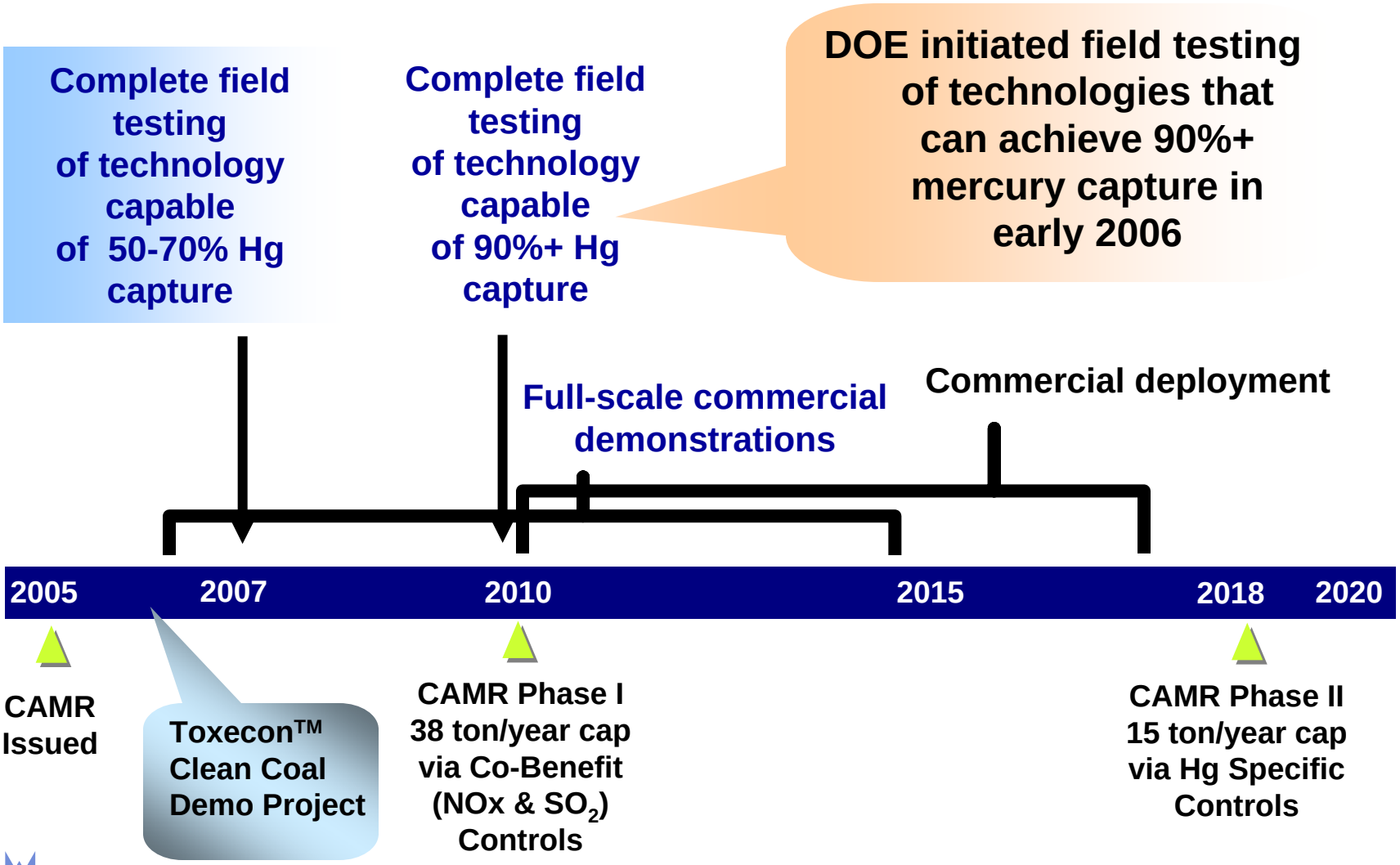
Preliminary Results of Field Testing at Conesville Power Plant – Impact of High-S Coal

- 400 MW T-fired PC burning high-S (3.5-4%) bituminous coal equipped with ESP and wet FGD
- Very little baseline Hg removal
- Initial tests w/ treated and untreated activated C yielded only 5-31% Hg removal @ 9-18 lb/MMacf

Conesville Power Plant, Coshocton, OH

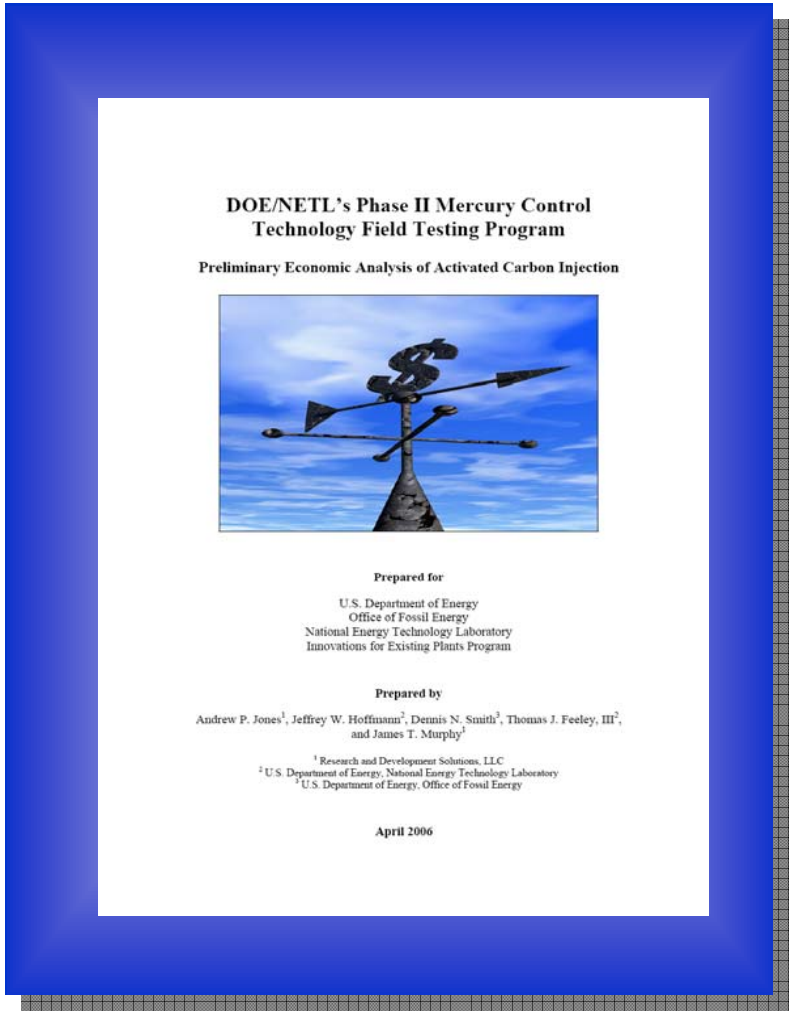
- 2nd round of parametric testing with "improved" sorbents yielded worst results (3-13% removal), even with improved AC distribution
- High sulfur trioxide (SO_3) suspected to compete with sorbtion sites on AC or otherwise compromise AC Hg removal capabilities

DOE Hg Control RD&D Timeline in Sync with the Clean Air Mercury Rule (CAMR)



RD&D – Research, Development and Demonstration

Phase II Field Testing Economic Analysis



DOE/NETL's Phase II Mercury Control Technology Field Testing Program

Preliminary Economic Analysis of Activated Carbon Injection

Prepared for

U.S. Department of Energy
Office of Fossil Energy
National Energy Technology Laboratory
Innovations for Existing Plants Program

Prepared by

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[2] U.S. Department of Energy, National Energy Technology Laboratory
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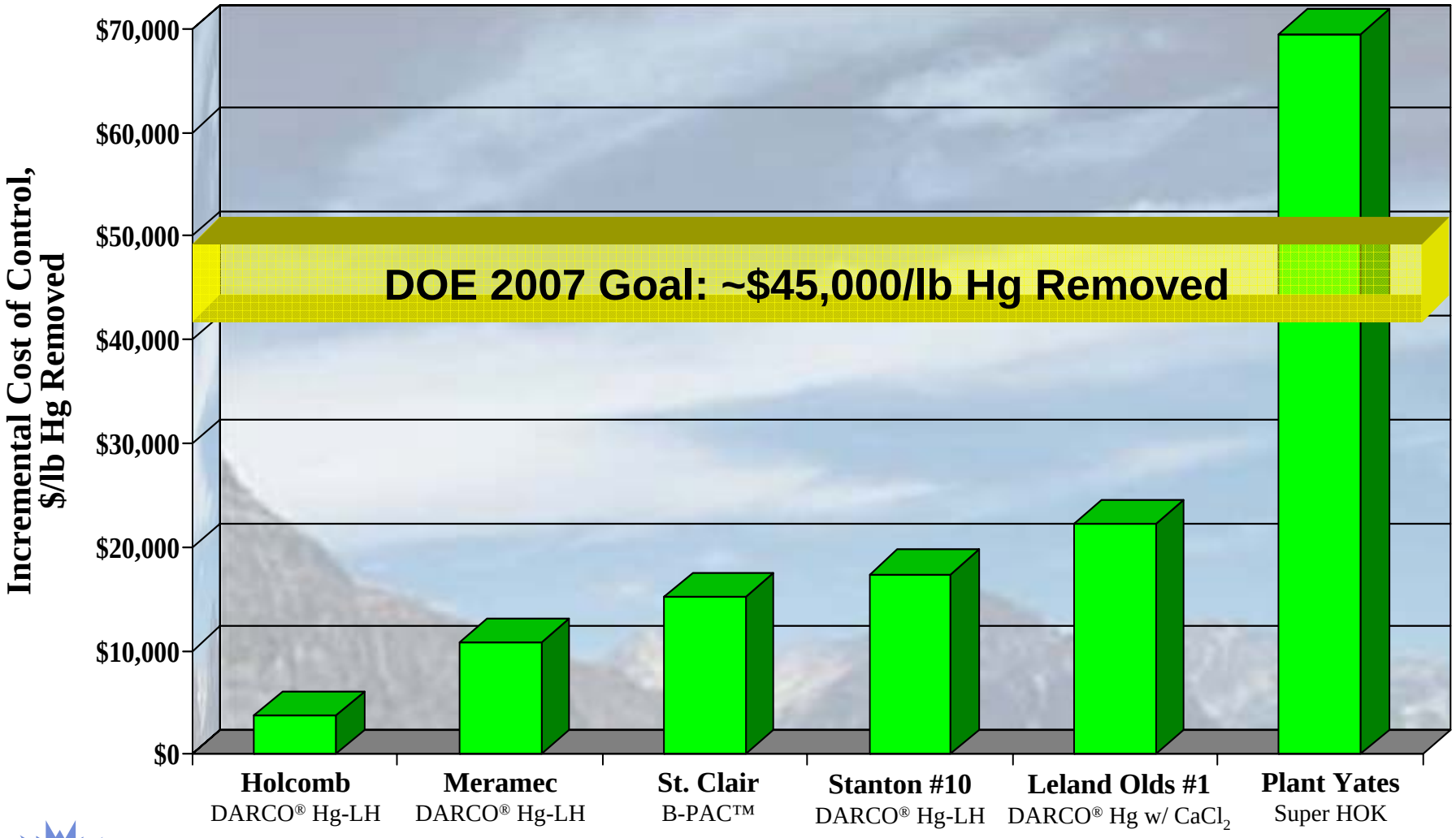
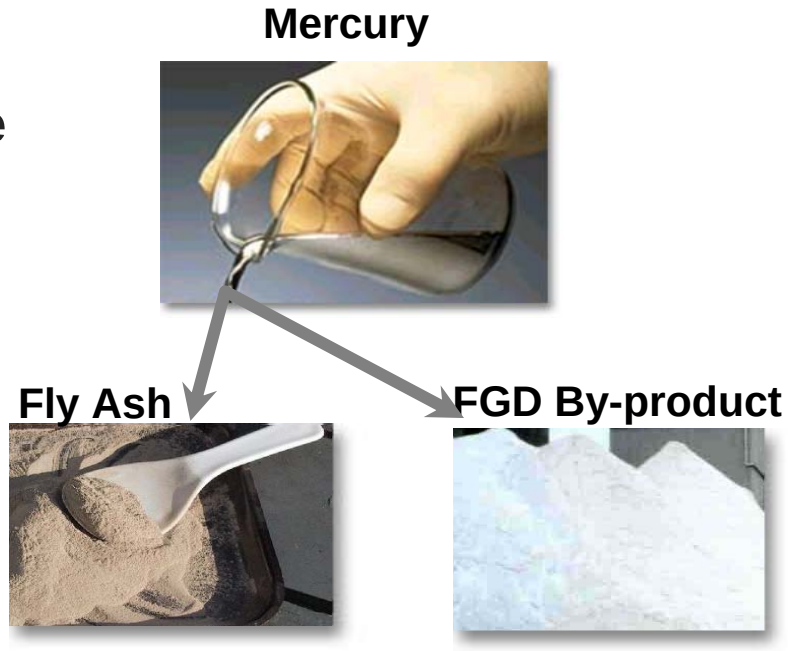
April 2006

Incremental Cost of 70% ACI Mercury Control



Key Challenges to Continued/Increased By-Product Use

- Installation of additional FGD to meet CAIR (SO_2) will increase volume of scrubber solids
- Installation of additional advanced combustion technology and SCR to meet CAIR (NOx) will increase UBC and NH_3 in fly ash
- Use of PAC injection for Hg control could negatively impact fly ash utilization due to increased carbon content

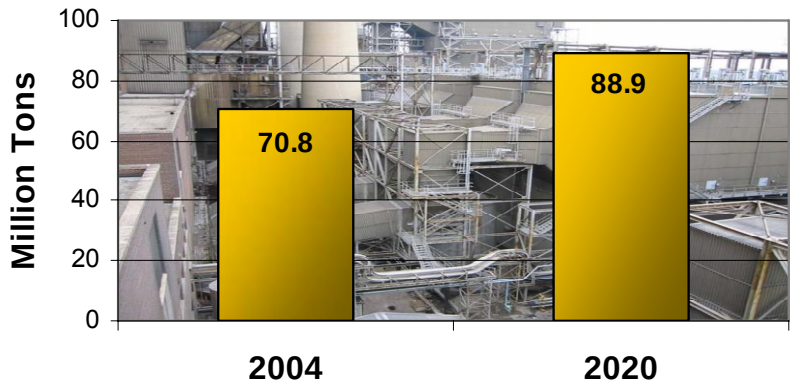


- Increased public scrutiny of CUBs due to transfer of Hg from flue gas to fly ash and scrubber solids

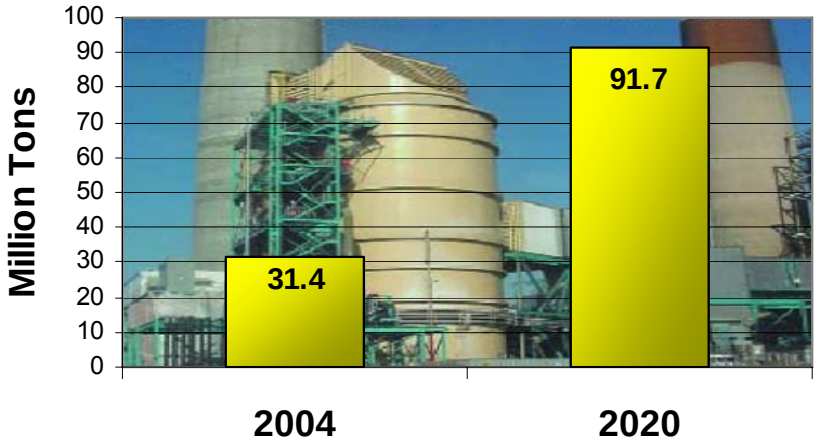
Projection of U.S. Coal-Fired Power Plant CUB Production

Coal-fired power generation projected to increase from 1,916 to 2,405 billion kWh from 2004 to 2020

Flyash Production



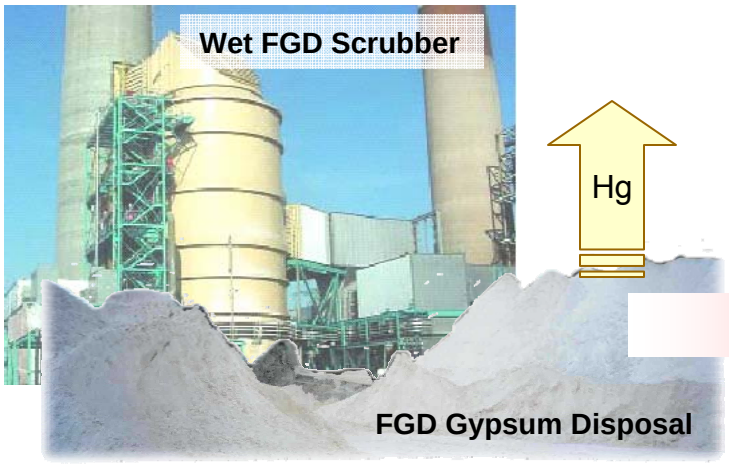
FGD Solids Production

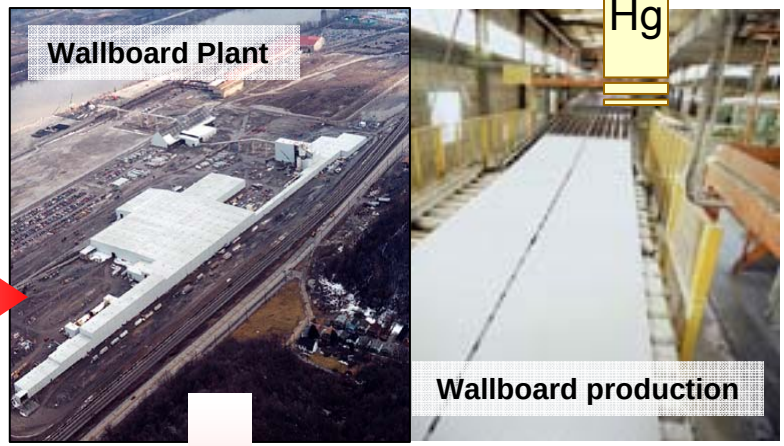


FGD capacity projected to increase from 100 to 231 GW from 2004 to 2020

Sources: ACAA, EIA AEO 2006, and EPA IPM Analysis for CAMR/CAIR

FGD Gypsum:
Pathways for Potential Mercury Release

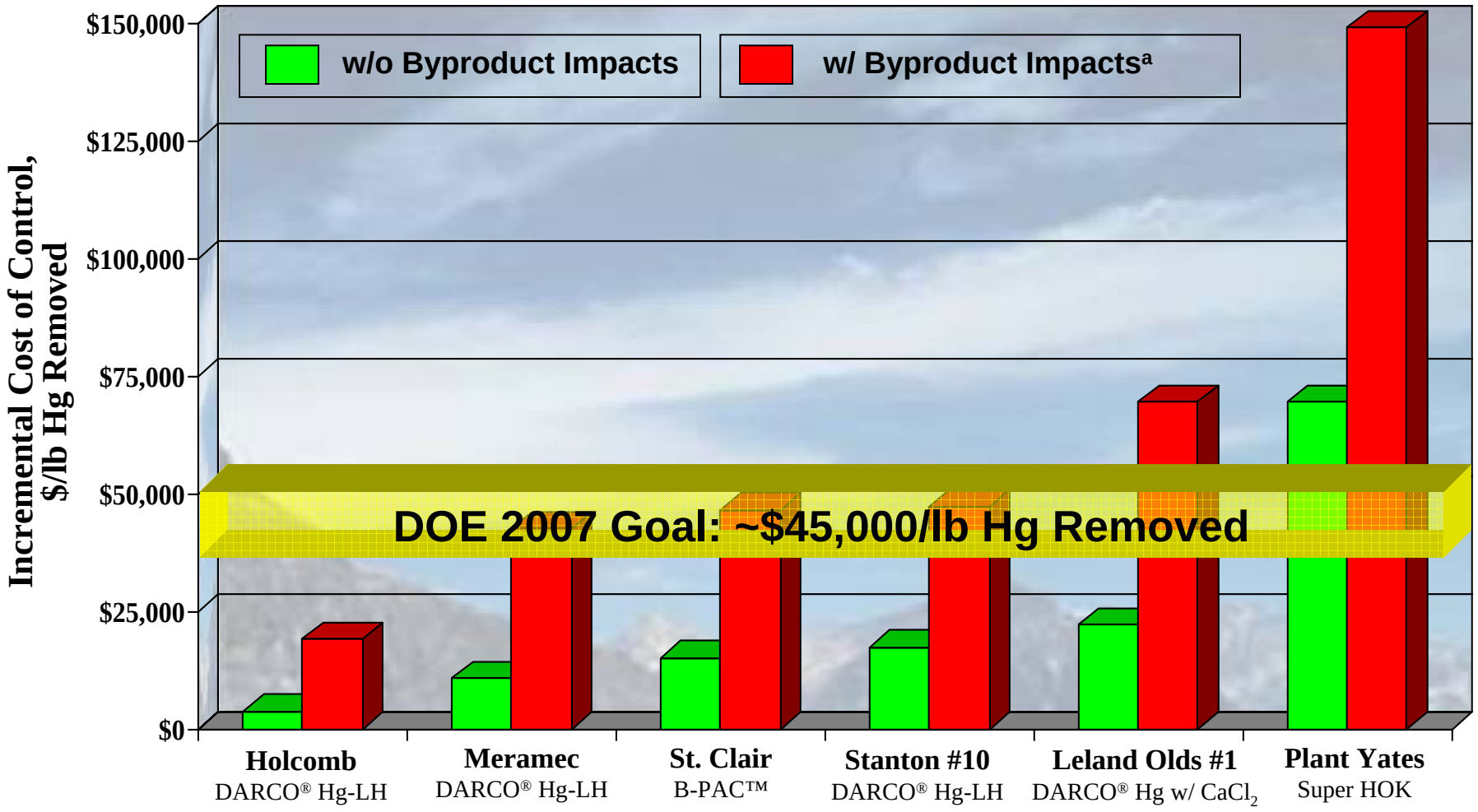




Home Construction

Wallboard disposal

Incremental Cost of 70% ACI Mercury Control

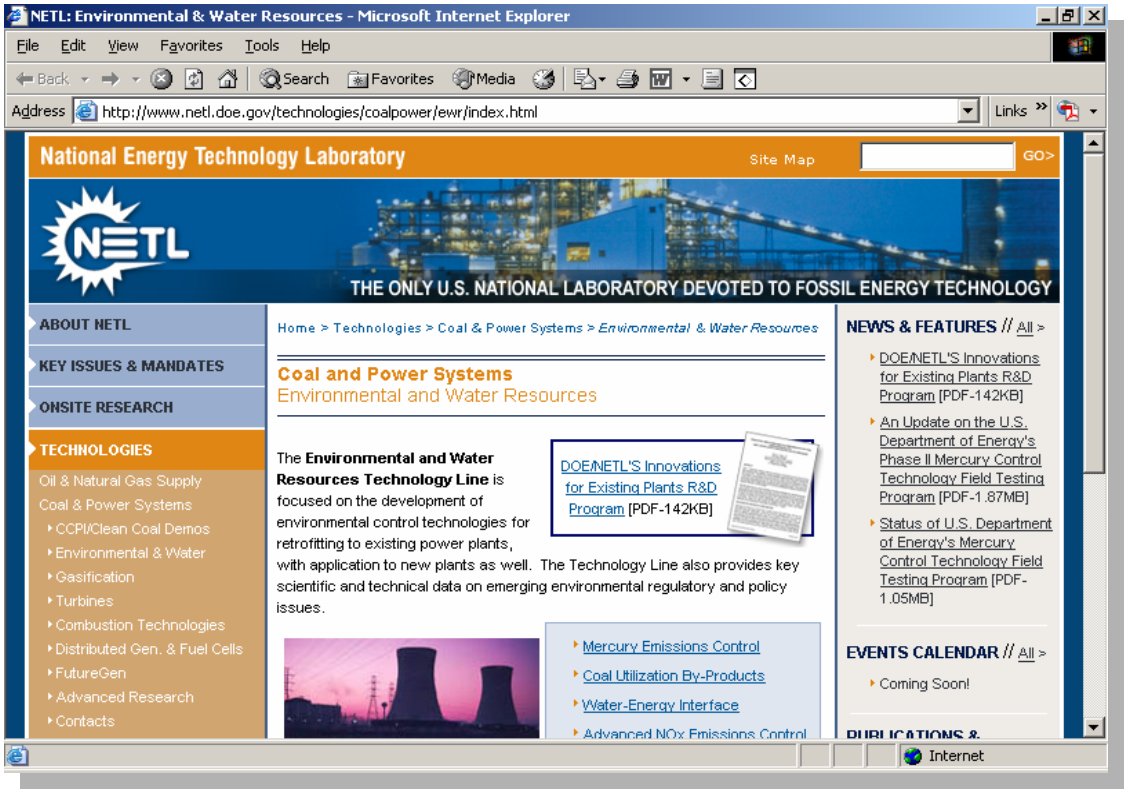


[a] For units equipped with CS-ESP, byproduct impacts include the fly ash disposal cost ($17/ton) and lost revenue from fly ash sales ($18/ton) assuming 100% utilization. For the SDA/FF configuration, only the cost of SDA byproduct disposal is included.

Key Takeaways from Field Testing

- **Halogenated activated carbon and halogen-based additives have shown to be effective in capturing elemental Hg from low-rank coals with both ESP and fabric filters**
- **Estimated cost of Hg control on a $/lb removed basis continues to decline under “no by-product impact” scenario**
- **SCR combined with wet- or dry-scrubbing systems can provide high (~80%-95%) Hg removal with bituminous coals – re-emissions may decrease total Hg capture; uncertainty remains with low-rank coals**
- **Further long-term field testing is needed to bring technologies to commercial-demonstration readiness, particularly related to potential BOP issues and impacts of sulfur/SO_3 and small SCA ESP on ACI effectiveness**
- **Potential coal combustion byproduct impacts on cost of mercury control remain a “wild card”**
- **DOE’s RD&D model projects broad commercial availability in 2012-2015**

DOE/NETL Environmental and Water Resources (Innovations for Existing Plants Program)



To find out more about DOE/NETL's Hg R&D activities visit us at:
http://www.netl.doe.gov/technologies/coalpower/ewr/index.html