

The annual cost in terms of SO₂ removed, or cost effectiveness, is calculated using Equation 1.32:

$$\text{Annual Cost Effectiveness} = \frac{TAC}{SO_2 \text{ removed}} = \frac{\$29,835,948/\text{year}}{54,150 \text{ tons/year}} = \$551/\text{ton}$$

1.2.5 Dry Flue Gas Desulfurization Systems

This section focuses on dry FGD systems used to control emissions of acid gases, such as HCl, SO₂ and sulfur trioxide (SO₃). Dry FGD systems can be used to control gas streams with typical SO₂ pollutant concentrations ranging from 250 to 1,000 ppmv (approximately 2 lb/MMBtu). These systems provide removal efficiencies between 50% and 95%.

In the past, dry FGD systems were typically installed on smaller boilers, furnaces, and incinerators. However, in recent years, some newer dry FGD systems have been installed on combustion units larger than 500 MW (5,000 MMBtu/hour) burning bituminous and subbituminous coal. Dry FGD systems typically have lower capital and operating costs and require less space than wet FGD systems, but generally use more expensive types of sorbent. [2, 16]

1.2.5.1 Process Description

Three basic types of dry FGD systems are currently available: dry sorbent injection (DSI), spray dryer absorber (SDA), and a post combustion circulating dry scrubber (CDS). In this section, we describe the SDA and CDS systems. DSI systems are not covered in this chapter as mentioned earlier in Section 1.1.

Spray Drying Absorber Systems

The SDA system is a semi-dry system that injects an aqueous slurry with a high concentration of sorbent into the flue gas stream. A diagram of a typical SDA system is shown in Figure 1.3. The SDA system requires a separate absorber vessel. The high temperature of the flue gas entering the absorber chamber causes the water to evaporate and the pollutants in the flue gas are absorbed to and react with the surface of the sorbent. Water remaining on the solid sorbent surface promotes the reaction with the acid gases. However, the amount of water entering the absorber must be carefully controlled to avoid saturating the gas stream. Saturation can cause the solids to adhere to components inside the absorber and particulate collection device. To avoid the buildup of solids, the water fed into the spray dryer is controlled to avoid saturation of the flue gas but maintain high SO₂ removal. The flue gas in the absorber chamber is typically maintained so that it approaches but remains above adiabatic saturation to achieve optimal pollutant removal. Temperatures between 20 and 30°F above the saturation temperature are typically considered optimal. [14, 30]

SDA systems use either calcium or sodium-based sorbents. However, most SDA systems use lime as the sorbent since it is more reactive than limestone, easier to manage than limestone, and less expensive than sodium-based reagents. The typical SDA system operates at a lime to

Wet Scrubber Spray Dry Manual

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