

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

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Keith Masters



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Handbook of Industrial Drying Arun S. Mujumdar, 2014-07-11 This Fourth Edition book includes 12 new chapters covering computational fluid dynamic simulation solar impingement and pulse combustion drying drying of fruits vegetables sugar biomass and coal physicochemical aspects of sludge drying and life cycle assessment of drying systems Addressing commonly encountered dryers as well as innovative dryers with future potential the fully revised text not only delivers a comprehensive treatment of the current state of the art but also serves as a consultative reference for streamlining industrial drying operations to increase energy efficiency and cost effectiveness *Handbook of Industrial Drying, Fourth Edition*

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Keith Masters, 1985 This edition reflects the changes which have occurred in spray drying technology and plant design since the publication of the fourth edition The author argues that spray drying will remain the most important dehydration technique available to convert pumpable fluid feedstocks into powders Topics covered include the drying principles a survey of auxiliary equipment and the applications of spray drying in industry There is a new chapter on spray drying in environmental control and there is a list of spray drying patents issued within the last five years This edition also contains more data and tables that cover operation and design information for a wide range of products Provided by the publisher

Pollution Control Handbook for Oil and Gas Engineering Nicholas P. Cheremisinoff, 2016-04-20 This is a major new handbook that covers hundreds of subjects that cross numerous industry sectors however the handbook is heavily slanted to oil and gas environmental management control and pollution prevention and energy efficient practices Multi media pollution technologies are covered air water solid waste energy Students technicians practicing engineers environmental engineers environmental managers chemical engineers petroleum engineers and environmental attorneys are all professionals who will benefit from this major new reference source The handbook is organized in three parts Part A provides an extensive compilation of abbreviations and concise glossary of pollution control and engineering terminology More than 400 terms are defined The section is intended to provide a simple look up guide to confusing terminology used in the regulatory field as well

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,1981 *Wet Scrubbers, Second Edition* Howard D. Hesketh, Kenneth C. Schiffner, 1996-02-20 A basic technical book on the design and application of gas cleaning technologies that use liquids first published in the 1980 s and used by plant and environmental engineers regulatory personnel and others concerned with air pollution The second edition enlarges the discussion on the theory of operation includes new sections on hybrid scrubber systems and irrigated fiberbed filters that use Brownian motion capture techniques and incorporates the more stringent air pollution regulations Annotation copyright by Book News Inc Portland OR

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Table of Contents Wet Scrubber Spray Dry Manual

1. Understanding the eBook Wet Scrubber Spray Dry Manual
 - The Rise of Digital Reading Wet Scrubber Spray Dry Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Wet Scrubber Spray Dry Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Wet Scrubber Spray Dry Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Wet Scrubber Spray Dry Manual
 - Personalized Recommendations
 - Wet Scrubber Spray Dry Manual User Reviews and Ratings

- Wet Scrubber Spray Dry Manual and Bestseller Lists
- 5. Accessing Wet Scrubber Spray Dry Manual Free and Paid eBooks
 - Wet Scrubber Spray Dry Manual Public Domain eBooks
 - Wet Scrubber Spray Dry Manual eBook Subscription Services
 - Wet Scrubber Spray Dry Manual Budget-Friendly Options
- 6. Navigating Wet Scrubber Spray Dry Manual eBook Formats
 - ePub, PDF, MOBI, and More
 - Wet Scrubber Spray Dry Manual Compatibility with Devices
 - Wet Scrubber Spray Dry Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Wet Scrubber Spray Dry Manual
 - Highlighting and Note-Taking Wet Scrubber Spray Dry Manual
 - Interactive Elements Wet Scrubber Spray Dry Manual
- 8. Staying Engaged with Wet Scrubber Spray Dry Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Wet Scrubber Spray Dry Manual
- 9. Balancing eBooks and Physical Books Wet Scrubber Spray Dry Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Wet Scrubber Spray Dry Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Wet Scrubber Spray Dry Manual
 - Setting Reading Goals Wet Scrubber Spray Dry Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Wet Scrubber Spray Dry Manual
 - Fact-Checking eBook Content of Wet Scrubber Spray Dry Manual
 - Distinguishing Credible Sources

13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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