SCR Deactivation Mechanisms Related to Alkali and Alkaline Earth Elements

C. Senior, K. Davis, and M. Bockelie
Reaction Engineering International

L. Baxter and C. Bartholomew
Brigham Young University

K. Whitty and E. Eddings
University of Utah

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77 West 200 South, Suite 210
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EPRI

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REI SCR Catalyst Deactivation Program

- DOE-funded program, with EPRI participation to
  - Develop industrially useful slipstream reactor
  - Quantify deactivation by blinding + poisoning
  - Focus on Na and K (poisoning) and Ca (blinding)
  - Develop engineering model for catalyst deactivation useful for industry for fuel switching or blending, fuel selection

- Principal Tasks:
  - Fundamental analysis of SCR catalyst poisoning and regeneration (BYU)
  - Multi-catalyst slipstream reactor to be tested at PRB (or PRB-blend) utility boiler for six months (REI, UU)
  - SCR deactivation model suitable for CFD code (REI)

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Mechanisms for SCR Catalyst Deactivation

- Fouling (surface deposition)
  - Deposition of ash
  - Sulfation of deposit observed with PRB
- Pore condensation (and/or pore blockage)
- Poisoning
  - Vapor-phase As (as As_2O_6) thought to react with active sites in some cases

Literature suggests fouling plays a role in deactivation from both PRB and biomass

Pore condensation could be a factor

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Subtask 1 – Catalyst Deactivation Studies

- Laboratory Investigation at BYU using small catalyst samples
- Effects of Alkali Impurities on Reactivity
- Characterization of catalyst (physical and chemical) before and after lab/field testing
  - Adsorption studies in flow reactor
  - Surface analysis (e.g. XPS), TEM/SEM, XRD, FTIR, TPD
  - No chemical analysis of any commercial catalysts.
- *Current Status:* Literature search completed and laboratory reactor under construction

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Two Primary Analysis Systems

- Catalyst characterization system (CCS)
  - Obtains quantitative activities/deactivation over long exposure times
  - Focuses on kinetic coefficient and mechanistic information
- *In situ* spectroscopy reactor (ISR)
  - Quantifies species adsorbed on surfaces during reaction
  - Provides quantitative indication of acidity and active site mechanisms

Subtask 2 – Field Testing in Slipstream

- Six catalysts evaluated in parallel
  - Four vendors to supply catalyst; one “generic” catalyst from BYU
- Monitor catalyst activity by
  - NO_x measurement
  - Periodic removal of catalyst samples for lab testing at BYU
- Two tests (each ~6 months) planned

Current Status: Discussing field test sites with utilities; obtaining catalyst samples from vendors; Univ. of Utah designing slipstream reactor

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Features of Reactor Design

- Multiple catalysts in parallel (plate and honeycomb)
- Catalyst exposed to gas and particulate matter
- Velocity of full-scale SCR
- 1 ½ - 3 foot catalyst samples to avoid favoring end effects
- On-line, continuous NO_x measurement for detailed kinetic information

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Multicatalyst SCR Reactor

Flue gas inlet

Catalyst chambers (outer doors have been removed)

Flow control (individual chambers) and sample ports

Flue gas outlet

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Subtask 3 – Catalyst Regeneration

- Investigate methods for regeneration on
  - Laboratory samples
  - Field-exposed samples

Current Status: Literature search completed

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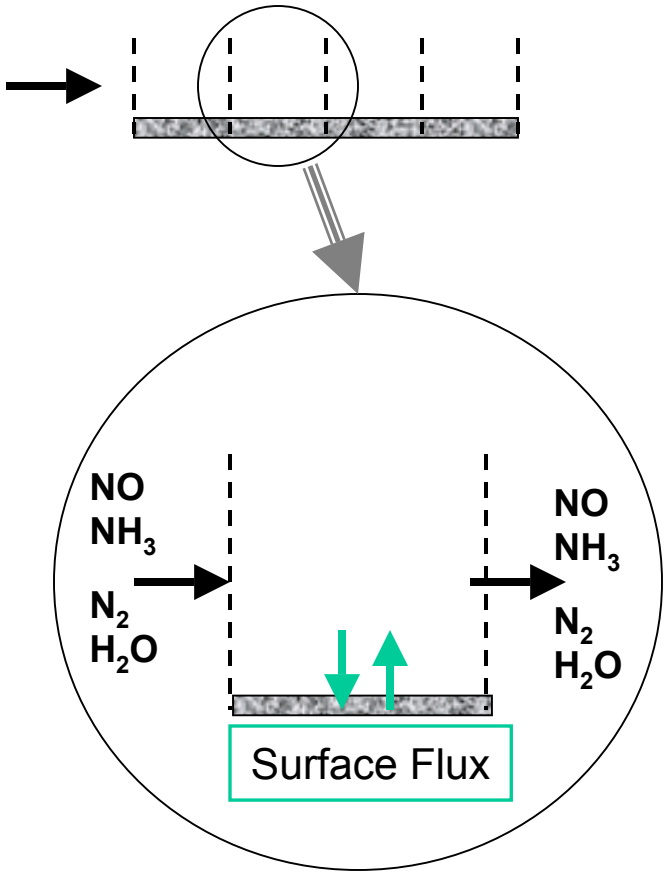
Subtask 4 – Deactivation Model Approach

- Solve gas transport and surface reactions along length of catalyst
- Surface equations are solved
  - Surface species concentrations of specific sites
  - Steady state assumption
  - Solution dependent on local gas species concentration
- Effectiveness factor to compensate for porous diffusion
- Gas species transport equations
  - Rates from surface equation solution



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