

Sulfur and cyanide removal from coal gas
with sulfuric acid recovery

FRC desulfurization system

Feature

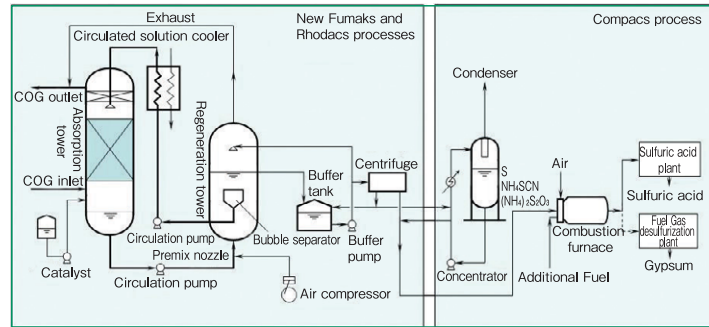
- Using an oxidation catalyst, the system efficiently removes hydrogen sulfide and hydrogen cyanide from coal gas.
- No additional desulfurizing agent is required because ammonium contained in coal gas is used for desulfurization. No steam is needed for regeneration either.
- Desulfurization waste liquor is recovered as sulfuric acid. No secondary contamination.



Premix-type recovery tower



Fumaks desulfurization plant



FRC desulfurization system

Introductory Track Record

Year of installation	Site name	Applied process	Gas processed Nmi/H	Gas
1987	Tianjin Gas Company, China	New Fumaks Rhodacs Compacs	35,000	Coal gas
1988	Kwangyang Ironworks, POSCO, Korea	New Fumaks Rhodacs (Soda base)	24,500	Coal gas Secondary desulfurization
1989	〃	〃	24,500	〃
1990	〃	〃	24,500	〃
1991	〃	〃	32,000	〃
1999	Shanghai Baosteel Group Corporation, China	New Fumaks Rhodacs Compacs	105,000	Coal gas
2012	Boashan Iron & Steel Co., Ltd. / Shanghai Baosteel Chemical Co., Ltd., China	New Fumaks Rhodacs Compacs	105,000	Coal gas

- Installations in Asian countries (The New Fumaks process uses the premix nozzle.) The system was installed by a number of Japanese companies and institutions including Nippon Steel & Sumitomo Metal, Kawatetsu Chemical Industry, The Kansai Coke and Chemicals and Osaka Gas.

Effects

- High desulfurizing efficiency by catalytic reaction of picric acid.
- A metal-free catalyst enables combustion of desulfurizing solution.
- The pre-mix nozzle needs less air for regeneration. The exhaust may be injected into COG.
- The pre-mix nozzle needs no tall regeneration tower.
- Highly reactive sulfur enables efficient HCN removal.
- Cost-efficient with no need of steam or heat.
- H₂S and HCN are fixed within the desulfurizing solution. As withdrawn solution can be stored in the tank, the waste recovery plant (sulfuric acid plant) can be maintained while the desulfurizing plant is in operation.
- It is not necessary to handle highly toxic H₂S and HCN gases.

Overview

(Technical principles, Flows , etc.)

Fumaks process: The principle of desulfurization process

Circulating desulfurizing solution mixed with a pinch of picric acid in the absorption tower, the system absorbs and removes hydrogen sulfide along with ammonium contained in coal gas. Exposing desulfurizing solution, which is transferred to the regeneration tower, to air leads oxidative decomposition of hydrogen sulfide with picric acid working as a catalyst to separate sulfur for regeneration. The solution free of hydrogen sulfide is recirculated to the absorption tower. Very quick reaction by means of picric acid and advanced type pre-mix nozzles enable highly efficient and smooth processing. The regeneration process does not need steam, thus is cost-efficient. Absorption and regeneration reactions are presented in the following formulas.

- Absorption reaction $\text{NH}_4\text{OH} + \text{H}_2\text{S} \rightarrow \text{NH}_4\text{HS} + \text{H}_2\text{O}$
- Regeneration reaction $\text{NH}_4\text{HS} + 1/2\text{O}_2 \xrightarrow[\text{(Picric acid)}]{\text{Catalyst}} \text{NH}_4\text{OH} + \text{S} \downarrow$

Rhodacs process : The principle of Cyanide removal process

Sulfur generated in the desulfurizing solution within the Fumaks process is in the form of highly reactive colloid. This colloidal sulfur changes hydrogen cyanide, which is absorbed from coal gas along with hydrogen sulfide, into rhodanate which is not toxic. Thus, presented in the following formulas, cyanide is removed.

The two step reactions in the Rhodacs process are,

- Polysulfide reaction $2\text{NH}_3 + \text{H}_2\text{S} + \text{xS} \rightarrow (\text{NH}_4)_2\text{S}_{\text{x}+1}$
- Rhodanation reaction $(\text{NH}_4)_2\text{S}_{\text{x}+1} + \text{HCN} + \text{NH}_3 \rightarrow \text{NH}_4\text{SCN} + (\text{NH}_4)_2\text{S}_{\text{x}}$

Compacs process: The principle of waste recovery process

Desulfurizing solution containing sulfur, rhodanate, etc. is concentrated and combusted to recover sulfuric acid. This makes a closed system for removal of hydrogen sulfide and hydrogen cyanide without secondary contamination.

Applicable field
Ironworks and refinery of fuel gas more than 100,000 m³/h

Water

Energy saving/Energy recovery

Energy storage/Energy creation

New energy

Waste disposal/
Recycling/
Resource saving

Air

Soil

Other

Osaka Gas Engineering Co., Ltd. Environmental Department

2-4-9 Bingo-machi, Chuo-ku, Osaka 541-0051 Japan

● TEL / +81-6-6220-1218 ● FAX / +81-6-6220-1240 ● E-Mail / tanimoto@oge.co.jp ● http://www.oge.co.jp