

Quarterly Technical Progress Report – Phase I

COOPERATIVE AGREEMENT DE-FC26-00NT40899

Calla Energy Biomass Cofiring Project

March 2002

CONTRACTOR NAME

Gas Technology Institute
1700 South Mount Prospect Road
Des Plaines, IL 60018-1804

PERIOD OF PERFORMANCE

From: January 1, 2002
To: March 31, 2002

CONTRACT PERIOD

From: September 25, 2000
To: February 28, 2003

DISCLAIMER

This report was prepared as an account of work sponsored by an agency of the United States Government. Neither the United States Government nor any agency thereof, nor any of their employees, makes any warranty, express or implied, or assumes any legal liability or responsibility for the accuracy, completeness, or usefulness of any information, apparatus, product, or process disclosed, or represents that its use would not infringe privately owned rights. Reference herein to any specific commercial product, process, or service by trade name, trademark, manufacturer, or otherwise does not necessarily constitute or imply its endorsement, recommendation, or favoring by the United States Government or any agency thereof. The views and opinions of authors expressed herein do not necessarily state or reflect those of the United States Government or any agency thereof.

ABSTRACT

The Calla Energy Biomass Project, to be located in Estill County, Kentucky is to be conducted in two phases. The objective of Phase I is to evaluate the technical and economic feasibility of cofiring biomass-based gasification fuel-gas in a power generation boiler. Waste coal fines are to be evaluated as the cofired fuel. The project is based on the use of commercially available technology for feeding and gas cleanup that would be suitable for deployment in municipal, large industrial and utility applications. Define a combustion system for the biomass gasification-based fuel-gas capable of stable, low-NO_x combustion over the full range of gaseous fuel mixtures, with low carbon monoxide emissions and turndown capabilities suitable for large-scale power generation applications.

The objective for Phase II is to design, install and demonstrate the combined gasification and combustion system in a large-scale, long-term cofiring operation to promote acceptance and utilization of indirect biomass cofiring technology for large-scale power generation applications.

During this Performance Period work efforts focused on completion of the Topical Report, summarizing the design and techno-economic study of the project's feasibility.

GTI received supplemental authorization A002 from DOE contracts for additional work to be performed under Phase I that will further extend the performance period until the end of February 2003. The additional scope of work is for GTI to develop the gasification characteristics of selected feedstock for the project. To conduct this work, GTI will assemble an existing "mini-bench" unit to perform the gasification tests. The results of the test will be used to confirm or if necessary update the process design completed in Phase Task 1

TABLE OF CONTENTS

Abstract	2
Table of Contents	3
Introduction	4
Executive Summary	4
Experimental	5
Results and Discussion.....	8
Conclusion.....	9

List of Graphical Materials

None	
------------	--

INTRODUCTION

The Gas Technology Institute, GTI, has assembled a team to perform this project. The team includes Calla Energy Partners, who is providing cost sharing resources. Calla is a developer of energy projects, and plans to generate steam and electricity from the completed facility in an industrial park to be located in Estill County Kentucky. Biomass in the form of saw dust and wood chips shall be acquired from lumber mills located in the region. Coal waste from the impoundment ponds at the site is planned as the cofiring fuel.

GTI shall work with CARBONA and NEXANT to develop a design for a complete gasification facility capable of delivering low-Btu fuel gas, LCV, to a boiler to be provided by Calla. GTI shall also design a dual-fuel natural gas/LCV gas burner to provide clean, high-efficiency combustion to be installed in Calla's boiler.

EXECUTIVE SUMMARY

Contract Objectives

This project is to be conducted in two phases. The objective of Phase I is to evaluate the technical and economic feasibility of cofiring biomass-based gasification fuel-gas in a power generation boiler. Waste coal fines are to be evaluated as the cofired fuel. The project is based on the use of commercially available technology for feeding and gas cleanup that would be suitable for deployment in municipal, large industrial and utility applications. Define a combustion system for the biomass gasification-based fuel-gas capable of stable, low-NOx combustion over the full range of gaseous fuel mixtures, with low carbon monoxide emissions and turndown capabilities suitable for large-scale power generation applications. The design of the gasifier will be confirmed with mini-bench scale testing of the fuels selected for the project.

The objective for Phase II is to design, install and demonstrate the combined gasification and combustion system in a large-scale, long-term cofiring operation to promote acceptance and utilization of indirect biomass cofiring technology for large-scale power generation applications.

Current Activities

During this Performance Period work efforts focused on identification of the scope of work for the "mini-bench" scale testing effort to be conducted to verify the design of the facility for Calla Energy. GTI received final authorization from DOE to proceed with this effort in March 2002 by an extension of Phase I. GTI has been working to inventory and identify existing facilities to be used in the mini-bench facility and equipment needed to ready the facility for testing.

Technical Approach Changes

None

EXPERIMENTAL

Project Tasks

Task 1.0 Phase I - Feasibility Study

The objective of Phase I is to evaluate the major technical and economic factors determining project viability and to define the specific fuel sources, fuel handling requirements, gasification system and combustion system configurations necessary to insure a successful biomass cofiring demonstration. This objective will be accomplished through the following tasks:

Task 0.0. NEPA Information

Calla Energy Partners will provide reports and documentation deemed necessary for DOE to prepare a NEPA review of the project. This information shall describe all anticipated environmental impacts of the proposed project. The NEPA review and approval process shall be completed by DOE before Phase II is initiated.

Task 1.1. Feedstock Evaluation

In this task, GTI and Calla shall identify and fully characterize the available economically viable biomass fuel resources for the plant. Approximately 1000 tons per day of sawdust is known to be available from 3 sawmills within eleven miles of the plant site. Fuel supply and transportation contracts will be negotiated during Phase I to insure adequate primary and backup feedstock supplies for the plant. In negotiating any contracts, realization will be made that the project may end at the completion of the feasibility study and not proceed further. Based on the fuels identified, gasifier sizing, feed handling, feed preparation and gasifier feed system requirements will be defined for the process simulation modeling and the conceptual plant design.

Task 1.2. Process Simulation and Combustion System CFD Modeling

Based on the range of feedstocks identified in Task 1.1, the GTI Team shall perform process modeling to evaluate and optimize plant configuration, reliability and efficiency. GTI will use its proprietary gasification model to develop gasifier heat and material balances, perform gasifier sizing calculations, predict product fuel gas compositions, and define process input and output flow ranges for each feedstock identified and mixtures thereof. NEXANT shall use APEN simulation to model the remaining plant systems and components under consideration using information developed under previous and on-going studies for the US Department of Energy (DOE) to the extent possible, providing a consistent basis of information and methodologies with previous DOE efforts. GTI will use the Fluent Computational Fluid Dynamics software to perform modeling calculations for the FIR low-NO_x LCV gas burner design. Fluent modeling has been developed specifically for, and used extensively in, the FIR burner development work by GTI to date.

Task 1.3. Conceptual Plant Design

Based on the feedstock and design configuration modeling results from Tasks 1.1 and 1.2, the GTI team shall develop detailed flow sheets with heat and material balances, performance estimates, and total plant capital cost estimates for the design cases agreed upon. This information will form the basis for the technoeconomic study conducted in Task 1.4.

At the beginning of the conceptual design task, Calla Energy Partners shall prepare a project permitting study identifying all federal, state and local permits required for the entire project through demonstration operations. This study will include a listing of all likely actions necessary to satisfy each permitting requirement, an approximate average time required to obtain the permit based on local experience with similar projects, the likely cost to the project, and the suggested project team member to be responsible for obtaining the permit.

Task 1.4. Technoeconomic Analysis

The capital costs at the total plant cost (IPC) level shall be determined including equipment, materials, labor, indirect construction costs, engineering, and contingencies. Operation and maintenance cost values will be determine on a first-year basis and subsequently levelized on the basis of a 20-year plant book life to form a part of the economic analysis. Quantities for major consumables such s fuels and sorbent will be taken from the technology-specific heat and material balance diagrams developed for each plant application. Other consumables will be evaluated on the basis of the quantity required using reference data. Operation costs are determined on the basis of the number of operators. Maintenance costs are evaluated on the basis of requirements for each major plant section. The capital and operating cost results for each plant case are combined with plant performance in the comprehensive evaluation of the COE. Details of the plant design definition, capital cost estimate, operations and maintenance cost estimate and economic analysis will be reported as follows:

- Plant Design
- Process Flow Sheets (heat and material balances)
- Performance Summary Table
- Overall efficiency and net plant heat rate (HHV basis)
- Summary Capital Estimate including detailed Code of Accounts
- Summary of production costs with details of the following sub-accounts: Fixed O&M, Variable O&M, Consumables, By-product Credit, and Fuel
- COE based on 15-year private sector financing based on 90% capacity factor

Task 1.5. Project Management – Phase I

Project review meetings shall be conducted as required. A topical report shall be prepared at the completion of Phase I that describes the findings of the study. A GO/NO-GO decision on Phase II must be received from DOE before initiation of detailed design and construction.

Task 1.6. Technology Conceptualization

GTI shall prepare a feasibility analysis of the advanced technology, based on their gasification experience. This report shall focus on the potential future opportunities of the proposed technology and other related gasification opportunities for biomass.

Task 1.7 Gasification Characterizations of Selected Feedstocks

GTI shall determine experimentally the gasification characteristics of selected feedstock for the project. To conduct this work, GTI will assemble an existing “mini-bench” unit to perform the gasification tests. The results of the test will be used to confirm or if necessary update the process design completed in Phase Task 1.3. GTI will work closely with Calla Energy Partners to identify suitable materials for testing.

Subtask –1

GTI will identify several feedstocks that are available for long term supply to Calla Energy. GTI and Calla will confirm the availability of the feedstock and procure sufficient representative samples for biomass gasification tests at GTI. The samples will be analyzed for their physical and chemical properties prior to selection and procurement.

Subtask –2

GTI will assemble, pressure test, the existing mini-bench scale gasification test unit. The instrumentation and data acquisition systems will be calibrated. Test material will be dried and readied for testing.

Subtask – 3

GTI will conduct gasification tests of the selected feed materials. These will characterize the gasification temperatures, steam/feed ratio, air/feed ratio, and other key process parameters. GTI will conduct tests to optimize conversion efficiency and determine conditions that minimize oil/tar formation.

Subtask – 4

The results of Subtask 3 will be used to update GTI’s gasification computer model. The results of the testing will be used to compare to the design basis used for Task 1.3 and to update the design basis if necessary.

Phase II Plant Design, Construction and Demonstration

Contingent on a decision to proceed based on the results of the Phase I feasibility study, detailed design, construction and demonstration of the biomass gasification–based fossil fuel cofiring facility will be completed in Phase II. This will be covered under a follow-on contract to this agreement.

RESULTS AND DISCUSSION

Task 0.0. NEPA Review

No activities this period.

Task 1.1 Feedstock Evaluation

No activities this period.

Task 1.2. Process Simulation and Combustion System CFD Modeling Combustion System

No activities this period.

Gasification System

No activities this period.

Task 1.3. Conceptual Plant Design

No activities this period.

Task 1.4. Technoeconomic Analysis

The final topical report was completed and submitted to DOE during this period.

Task 1.5. Project Management – Phase I

GTI has continued to manage the work flow to keep the project on schedule. GTI worked to complete the definition of the scope of work for the operation of the mini-bench facility to conduct confirmation tests with biomass under the expansion of Phase I.

The supplement to this project consists of conducting bench scale research at GTI to support the design effort by confirming the design assumptions and updating the design for the specific feedstock to be provided by Calla Energy. Activities include:

- Feedstock selection
- Equipment Setup and Preparation
- Biomass Gasification Tests
- Modeling and Process Update

Task 1.6. Technology Conceptualization

No activity this period.

Task 1.7 Gasification Characterizations of Selected Feedstocks

GTI conducted an equipment inventory of existing hardware available for construction of the “mini-bench” facility. Based on the inventory, a list of supplemental equipment needed to be purchased was developed.

GTI developed a material and energy balance based on the Calla Energy Phase I design for the operation of the mini-bench facility. Equipment will also be sized to compare

atmospheric design conditions with operation at pressures consistent with gas turbine operation.

Preliminary Process Flow Diagrams (PFDs) and Process and Instrument Diagrams (P&IDs) were prepared for final review.

CONCLUSION

Summary Status Assessment And Forecast

GTI has initiated work under the amendment to the Phase I activities. Engineering for assembly of the “mini-bench” facility is actively proceeding.

Open Items

None

Future Work Plan Next Quarter:

- Begin assembly of bench scale reactor
- Procure equipment necessary to operate bench scale reactor
- Acquire test feedstock
- Initiate Testing