



NETL Life Cycle Inventory Data

Process Documentation File

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| Carbon Dioxide [Intermediate Product] | <i>Carbon dioxide captured from F-T conversion process for sequestration or enhanced oil recovery</i> |
| LP Gas | <i>LP gas co-product of F-T fuel</i> |
| Sulphur [Inorganic Intermediate Product] | <i>Sulphur co-product recovered from F-T conversion process</i> |
| Electricity | <i>Electricity co-product exported from F-T conversion process</i> |

Section II: Process Description

Associated Documentation

This unit process is composed of this document and the data sheet (DS) *DS_Stage3_O_FTjet_CBTL_Opct_Biomass_2012.01.xls*, which provides additional details regarding calculations, data quality, and references as relevant.

Goal and Scope

The scope of this unit process covers the production operations for F-T jet fuel from Montana Rosebud coal in Life Cycle (LC) Stage #3. This unit process is based on the reference flow of 1 kg of F-T jet fuel production, as described below, and in **Figure 1**. The inputs to the unit process include Montana Rosebud coal (technosphere), groundwater (resource), and surface water (resource). Rosebud coal is used as the feedstock for the F-T process; the energy and material flows for the upstream production and delivery of coal as well as LC emissions of coal production are not included in the boundary of this process. The air emissions from the coal conversion process, and water usage, are included in the boundary.

Boundary and Description

The LC boundary of this unit process starts with the delivery of Montana Rosebud coal to the CTL facility and ends with F-T jet fuel ready for delivery to end-use. The production operations for F-T jet fuel are based on the estimated coal and water consumption of the conversion process and the yield rate of F-T jet fuel. **Figure 1** provides an overview of the boundary of this unit process. As shown, upstream emissions associated with the production and delivery of coal are accounted for outside of the boundary of this unit process. The methods for calculating these operating activities are described below. **Figure 2** provides a process diagram for the CTL facility.

At the CTL facility, it is assumed that the coal is brought from the storage area and sent to milling and drying. Here, the coal is dried from the as-received value of 26% moisture down to 18% for feeding to the TRIG gasifier. The coal is then injected into the TRIG gasifier just above the mixing zone. Steam and oxygen are added to the gasifier, and the coal is transformed into raw synthesis gas (syngas). Sensible heat from the hot syngas is recovered in a waste heat boiler/superheater and the gas is cooled for

feeding to the raw shift and COS hydrolysis units. A portion of the cooled syngas is recycled to the TRIG gasifier. The shifted syngas is further cooled and sent to mercury removal. Upon exiting mercury removal, the syngas enters the two-stage Selexol unit. Here, hydrogen sulfide and carbon dioxide are removed in separate absorbers. The hydrogen sulfide stream is sent to the Claus unit for sulfur recovery. The Claus offgas enters Claus Offgas Treating (COT) to reduce breakthrough sulfur dioxide. The hydrogen sulfide from COT is recycled to the Selexol unit. The carbon dioxide stream is sent to dehydration and compression to produce a high pressure CO₂ stream suitable for pipeline transport and carbon management.

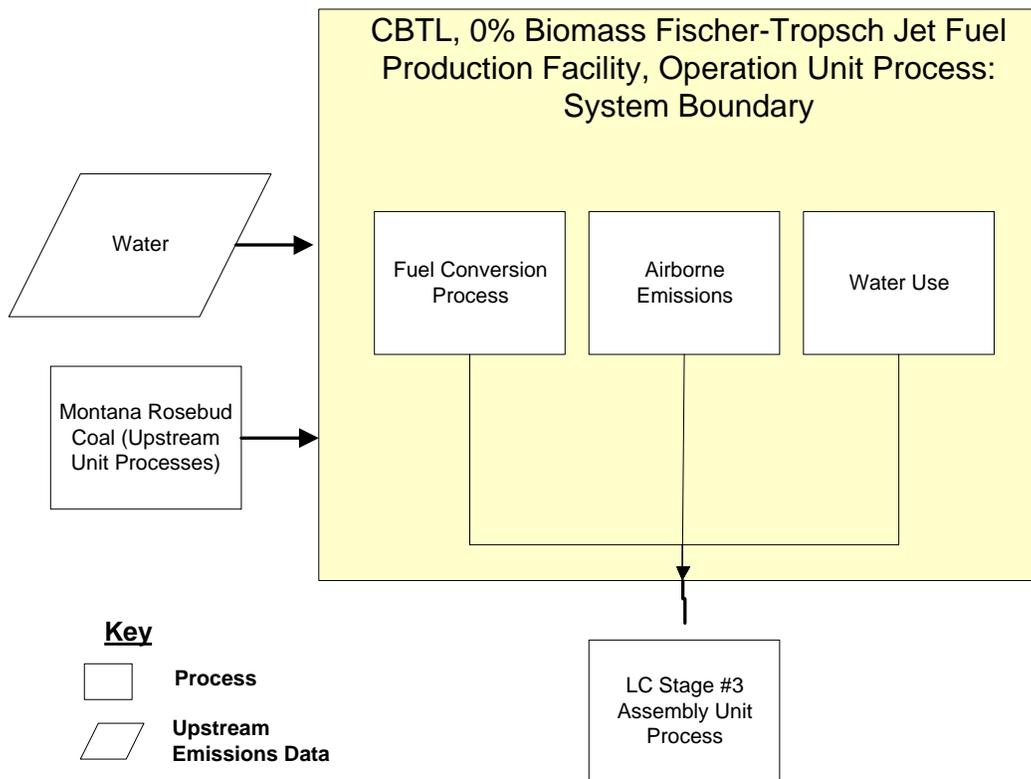
The cleaned syngas exiting Selexol is further reduced in sulfur by a zinc oxide sulfur polisher. The syngas would then contain less than 30 parts per billion of sulfur. The cleaned syngas then enters the slurry-phase, iron-based catalytic Fischer-Tropsch (F-T) reactors. The raw F-T products and unconverted synthesis gas are separated in the raw product separation unit into overhead gases that includes CO₂, CO, H₂, light hydrocarbons, an aqueous stream containing oxygenates, naphtha, distillate, and wax.

The overhead gas is sent to a methyldiethanolamine (MDEA) unit for CO₂ removal then to a cryogenic separation unit to separate a methane-rich gas, a hydrogen-rich gas, and liquefied petroleum gas (LPG). The methane rich gas that includes CO is sent to an oxygen-blown autothermal reformer (ATR). The ATR exit gas contains some methane, CO, H₂, and CO₂. This gas stream is divided so that some of the gas is used for plant fuel gas needs, some is recycled to the FT reactors, and the remainder is sent to the gas turbine combustors to generate electric power. The hydrogen-rich gas is sent to the pressure swing adsorption (PSA) unit to produce a pure hydrogen stream for the refinery and a low pressure fuel gas. The LPG stream is separated as a co-product of the plant.

The aqueous stream contains the oxygenate compounds like alcohols, acids, and ketones. This stream is sent to wastewater treatment. The naphtha is distilled from the distillate stream and receives no further treatment. The distillate is hydrotreated to remove olefins and becomes the diesel fuel product. The wax is hydrocracked to a jet fuel product. Jet fuel has a very narrow boiling point range and hence a small range of carbon numbers, typically from C₁₀ to C₁₆. When the FT wax, which has a wide range of carbon numbers (~C₂₃ to C₄₀₀), is hydrocracked to be within the narrow jet fuel range a large amount of over cracking occurs. This produces, in addition to the jet fuel, a significant amount of light hydrocarbon gases including LPG, and additional naphtha. The final products from the refinery are jet fuel, diesel, naphtha, and LPG.

Refinery fired heaters for distillation and feed heating for hydrotreating and hydrocracking are heated in heaters using fuel gases. The flue gases from these heaters are vented to the atmosphere. The separate fuel gases sent to the gas turbines generate electric power for the plant. Heat is recovered from the turbine exhaust in HRSGs and the steam raised is used in the steam turbine for additional power generation. The exhaust flue gas from the HRSG is vented to the stack. Power produced in excess of plant parasitic requirements is sold. Steam turbine exhaust is condensed using conventional mechanical draft cooling towers.

Figure 1: Unit Process Scope and Boundary



The F-T conversion process results in the direct emission of greenhouse gases (GHGs), criteria air pollutants (CAPs), other air pollutant emissions, and water use. The emissions factors for GHGs are based on suggested values for F-T jet fuel production from coal and woody biomass (Noblis 2012a/Noblis 2012b). Emissions of NO_x, particulate matter, and mercury are based on prior work completed by NETL estimating the emissions associated with an alternative configuration CTL facility (NETL 2010)

Table 1 provides a summary of the site conditions for the modeled CBTL facility.

Table 2 provides a summary of modeled input and output flows. Additional details regarding input and output flows, including calculation methods, are contained in the associated DS sheet.

Table 1: CBTL Facility Site Conditions

| Site Characteristic | Site Condition |
|--|--|
| Elevation (Feet) | 0 |
| Barometric Pressure (PSIA) | 14.7 |
| Design Ambient Temperature, Dry Bulb (F) | 60 |
| Wet Bulb Temperature (F) | 52 |
| Ambient Relative Humidity (%) | 60 |
| Location | Greenfield, South Eastern USA |
| Topography | Level |
| Size, Acres | 1,300 |
| Transportation | Rail and Road |
| Ash Disposal | Off Site |
| Water | Municipal (assumed to be surface water) 50%: Groundwater 50% |
| Access | Landlocked; Access by rail and highway |
| CO ₂ Disposition | Compressed to 2215 psia on site then transported by pipeline to an EOR facility |

Table 2: Unit Process Input and Output Flows

| Flow Name* | Value | Units (Per Reference Flow) |
|--|----------|----------------------------|
| Inputs | | |
| PRB Coal | 9.286 | kg |
| Biomass | 0.000 | kg |
| Torrefied biomass | 0.000 | kg |
| Water (ground water) [Water] | 8.220 | kg |
| Water (surface water) [Water] | 8.220 | kg |
| Outputs | | |
| F-T Jet Fuel [Valuable Products] | 1.00 | kg |
| FT Naphtha | 6.40E-01 | kg |
| FT Diesel | 1.96E-01 | kg |
| Carbon dioxide [intermediate product] | 9.37E+00 | kg |
| LPG | 1.14E-01 | kg |
| sulphur [inorganic intermediate product] | 3.37E-02 | MWh |
| Electricity | 1.87E-03 | kg |
| Carbon dioxide [Inorganic emissions to air] | 1.34E+00 | kg |
| Carbon monoxide [Inorganic emissions to air] | 0.00E+00 | kg |
| Carbonyl sulfide [other emissions to air] | 3.15E-13 | kg |
| Hydrogen chloride [Inorganic emissions to air] | 0.00E+00 | kg |
| Ammonia [Inorganic emissions to air] | 4.57E-05 | kg |
| Sulphur dioxide [Inorganic emissions to air] | 1.20E-11 | kg |

| Flow Name* | Value | Units (Per Reference Flow) |
|--|----------|----------------------------|
| Ash [Waste for recovery] | 8.87E-01 | kg |
| Methane [Organic emissions to air (group VOC)] | 0.00E+00 | kg |
| Nitrogen dioxide [Inorganic emissions to air] | 6.57E-05 | kg |
| Particulate Matter, unspecified [Other emissions to air] | 3.96E-04 | kg |
| Mercury (+II) [Heavy metals to air] | 3.83E-08 | kg |
| NMVOG [Organic emissions to air (group VOC)] | 0.00E+00 | kg |

* **Bold face** clarifies that the value shown *does not* include upstream environmental flows. Upstream environmental flows were added during the modeling process using GaBi modeling software, as shown in Figure 1.

Embedded Unit Processes

None.

References

- White et al. 2012a White et al., Model for the Production of Jet Fuel from Coal and Woody Biomass: A Comparative Analysis of Coal/Wood Co-Gasification and Separate Coal and Wood Gasification Configurations. Noblis. 2012.
- White et al. 2012b White et al., Production of Jet Fuel from Coal and Woody Biomass: A Comparative Analysis of Coal/Wood Co-Gasification and Separate Coal and Wood Gasification Configurations. Noblis. 2012.
- NETL 2010 NETL (2010). NETL Life Cycle Inventory Data – Unit Process: CBTL Plant Operation with Coal and SRWC Feed. U.S. Department of Energy, National Energy Technology Laboratory. Last Updated: February 2010 (version 01). www.netl.doe.gov/energy-analyses (<http://www.netl.doe.gov/energy-analyses>)

Section III: Document Control Information

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