Contents

List of figures and tables *xi*

Preface *xx*

List of contributors *xxi*

1 Introduction **1**

1.1 Current status of bioenergy 3

1.2 Combustion as main bioenergy technology 4

1.3 This handbook 5

1.4 References 6

2 Biomass Fuel Properties and Basic Principles of Biomass Combustion **7**

2.1 Introduction 7

2.2 The process of biomass combustion 8

2.2.1 Drying, pyrolysis, gasification and combustion 9

2.2.2 Operational and design variables affecting the combustion process 11

2.2.3 Principles of medium- to large-scale combustion applications 22

2.2.4 Thermodynamics and gas phase kinetics 23

2.2.5 Solid fuel kinetics and gas phase interaction 23

2.2.6 Basic engineering calculations 23

2.2.7 Basic emission conversion calculations 29

2.2.8 Batch versus continuous combustion 31

2.2.9 Modelling biomass combustion 33

2.2.10 Ash formation 34

2.3 Physical and chemical characteristics of biomass fuels 38

2.3.1 Overview 38

2.3.2 Fuel characteristics and interaction with the combustion system 38

2.3.3 Databases on biomass fuel characteristics 48

2.3.4 Standardization of biomass fuels 49

2.4 References 50

3 Biomass Fuel Supply and Pre-treatment **54**

3.1 Quality-related influences along the supply chain of biomass fuels 56

3.1.1 Influences on the fuel quality during the growing phase 57

3.1.2 Influences on the fuel quality during the supply phase 58

3.1.3 Fuel quality control and price calculations 59

3.2 Biomass production 60

3.2.1 Forest residues 60

3.2.2 Herbaceous biomass fuels 61

3.2.3 Short rotation woody crops 62

3.3 Fuel pre-treatment 64
3.3.1 Comminution of woody biomass 64
3.3.2 Pre-treatment of waste wood 69
3.3.3 Baling and bundling of biomass fuels 72
3.3.4 Pellets and briquettes 74
3.3.5 Drying of biomass 78
3.4 Storage, handling and transport systems 83
3.4.1 Storage of biomass 83
3.4.2 Fuel-feeding and handling systems 89
3.4.3 Transport systems for biomass fuels 95
3.5 System perspectives on bioenergy 96
3.5.1 Case 1 Multifunctional bioenergy systems (MBS) 98
3.5.2 Case 2 Co-firing opportunities in Poland 102
3.5.3 Conclusions from the two cases 108
3.6 References 108

4 Domestic Wood-Burning Appliances 112
4.1 Introduction 112
4.2 Design considerations 112
4.3 Residential batch-fired wood-burning appliances 113
4.3.1 Wood-stoves 113
4.3.2 Fireplace inserts and zero clearance fireplaces 115
4.3.3 Heat-storing stoves 116
4.3.4 Wood log boilers 118
4.4 Wood pellet appliances and burners 122
4.4.1 Background 122
4.4.2 Technical features 122
4.4.3 Safety requirements regarding back-burning 123
4.4.4 Emissions 123
4.4.5 Efficiency 124
4.4.6 Certification 124
4.4.7 Pellet burners for central heating systems 125
4.4.8 Wood pellet stoves 127
4.5 Woodchip appliances 128
4.5.1 Pre-ovens 128
4.5.2 Under-fire boilers 129
4.5.3 Stoker burners 129
4.6 Certification and testing standards 129
4.6.1 European standards 130
4.6.2 North American standards 132
4.7 References 133

5 Combustion Technologies for Industrial and District Heating Systems 134
5.1 Introduction 134
5.2 Fixed-bed combustion 135
5.2.1 Grate furnaces 135
5.2.2 Underfeed stokers 146

5.3 Fluidized bed combustion 147
5.3.1 Bubbling fluidized bed (BFB) combustion 148
5.3.2 Circulating fluidized bed (CFB) combustion 149
5.4 Pulverized fuel combustion 150
5.5 Summary of combustion technologies 154
5.6 Heat recovery systems and possibilities for increasing plant efficiency 155
5.7 Process control systems for biomass combustion installations 161
5.7.1 Control objectives 161
5.7.2 Process dynamics 161
5.7.3 State-of-the-art process control 163
5.7.4 Advanced process control 164
5.8 Techno-economic aspects of biomass combustion plant design 167
5.8.1 Technical and economic standards for biomass combustion and district heating plants 168
5.8.2 Plant dimensioning/boiler size 169
5.8.3 Annual utilization rate of the biomass system 170
5.8.4 Size of the fuel storage unit 170
5.8.5 Construction and civil engineering costs 171
5.8.6 Heat distribution network 171
5.8.7 Heat generation costs and economic optimization 171
5.9 References 173

6 Power Generation and Co-generation 175
6.1 Overview of power generation processes 175
6.2 Closed thermal cycles for power production 175
6.3 Steam turbines 177
6.3.1 Working principle 177
6.3.2 Rankine cycle 179
6.3.3 Economic aspects 182
6.4 Steam piston engines 183
6.5 Steam screw engines 187
6.6 Organic Rankine cycle (ORC) 189
6.7 Closed gas turbines 192
6.8 Stirling engines 193
6.9 Comparison of heat, power and CHP production 197
6.10 Summary 200
6.11 References 201

7 Co-combustion 203
7.1 Introduction 203
7.2 Operational experience 203
7.3 Co-firing concepts 206
7.3.1 Direct co-firing 207
7.3.2 Indirect co-firing 207
7.3.3 Parallel co-firing 207
7.4 Examples of biomass co-firing in pulverized coal-fired boilers 208
7.4.1 Direct co-firing of demolition wood waste with coal, Gelderland Power Station, Nijmegen, the Netherlands 208

7.4.2 Direct co-firing of sawdust and woodchips with coal, Wallerawang Power Station, NSW, Australia 209
7.4.3 Direct co-firing of straw with coal, Studstrup, Denmark 212
7.4.4 Direct co-firing of wood fuels with coals, St Andrea, Austria 215
7.4.5 Indirect co-firing of biomass fuel gas with coal, Zeltweg Power Plant, Austria 216
7.4.6 Indirect co-firing of biomass fuel gas with coal, Amer Power Plant, the Netherlands 218
7.4.7 Parallel co-firing of biomass and fossil fuels, Avedøre Power Plant, Denmark 219
7.4.8 Summary of experience of biomass co-firing in pulverized coal-fired boilers 220
7.5 Fuel preparation, processing and handling issues 223
7.5.1 Preliminary size reduction 224
7.5.2 Bulk handling 225
7.5.3 Long-term storage 226
7.5.4 Drying 228
7.5.5 Secondary size reduction 228
7.6 Operational and environmental issues 232
7.6.1 General fuel characteristics of coals and biomass 232
7.6.2 Particle size and residence time 233
7.6.3 Boiler efficiency 235
7.6.4 Rate of combustion and char burnout 235
7.6.5 Flame stability 237
7.6.6 System integration and control issues 237
7.6.7 Ash deposition 237
7.6.8 Gas-side corrosion of boiler components 239
7.6.9 Impact on emissions 239
7.6.10 Performance of NO_x and SO_x emissions abatement equipment 243
7.6.11 Efficiency of particulate emissions abatement equipment 244
7.6.12 Flyash utilization 245
7.7 References 247

8 Biomass Ash Characteristics and Behaviour in Combustion Systems 249
8.1 Introduction 249
8.2 Biomass ash characteristics 250
8.2.1 Introduction 250
8.2.2 Laboratory characterization techniques for biomass ashes 251
8.3 High temperature behaviour of inorganic constituents of biomass in combustion systems 258
8.3.1 Introduction 258
8.3.2 Grate-fired combustors 260
8.3.3 Fluidized bed combustors 263
8.3.4 Pulverized fuel combustion systems 264
8.4 Formation and nature of ash deposits on the surfaces of combustors and boilers firing or co-firing biomass materials 266
8.4.1 Introduction to ash deposition 266
8.4.2 Slag formation processes 267

8.4.3 Convective section fouling processes 269
8.4.4 Deposit growth, shedding and online cleaning 271
8.5 Impact of ash on the flue gas cleaning equipment in biomass-firing systems 272
8.5.1 Introduction 272
8.5.2 The impact of co-firing on electrostatic precipitators 273
8.5.3 The impact of biomass co-firing on SCR catalysts 273
8.5.4 The impact of biomass co-firing on FGD plants 275
8.6 Impact of biomass ash on boiler tube corrosion, and on erosive and abrasive wear of boiler components 276
8.6.1 Technical background to gas-side corrosion processes in boilers 276
8.6.2 Corrosion mechanisms 277
8.6.3 Plant experience and boiler probing trials with biomass firing and biomass–coal co-firing 278
8.6.4 Preventive and remedial measures for fire side corrosion 283
8.6.5 Erosion and abrasion of boiler components and other equipment 285
8.7 Biomass ash utilization and disposal 286
8.8 References 288

9 Environmental Aspects of Biomass Combustion 291
9.1 Introduction 291
9.2 Environmental impacts of biomass combustion 292
9.2.1 Emission components and their main influencing factors 294
9.2.2 Measuring emissions from biomass combustion 304
9.2.3 Emissions data 304
9.2.4 Primary emission reduction measures 309
9.2.5 Secondary emission reduction measures 318
9.2.6 Emission limits in selected IEA member countries 339
9.3 Options for ash disposal and utilization 348
9.3.1 Introduction: General, ecological and technological limitations 348
9.3.2 Physical and chemical properties of biomass ashes 350
9.3.3 Material fluxes of ash-forming elements during combustion of biomass 359
9.3.4 Conclusions 361
9.4 Treatment technologies and logistics for biomass ashes 362
9.4.1 Combustion technology 362
9.4.2 Downstream processes: Ash pre-treatment and utilization 363
9.4.3 Examples of guidelines for the utilization of biomass ashes in Austria 365
9.4.4 Recommended procedure and quantitative limits for biomass ash-to-soil recycling in Austria 365
9.5 Waste-water handling from flue gas condensation 367
9.6 References 372

10 Policies **379**
10.1 Introduction 379
10.2 Global expansion of biomass combustion 379
10.2.1 Trends in selected OECD member countries 381
10.2.2 Trends in selected non-OECD member countries 385
10.2.3 Relevant policy issues 385
10.3 Financial support instruments 387
10.3.1 Fixed feed-in tariffs and fixed premiums 387
10.3.2 Green certificate systems 387
10.3.3 Tendering 387
10.3.4 Investment subsidies 387
10.3.5 Tax deduction 388
10.4 Other policies that influence the establishment of biomass combustion 389
10.5 References 390

11 Research and Development: Needs and Ongoing Activities **391**
11.1 Investigation of potentials of biomass resources 391
11.2 Development of improved combustion technologies 392
11.3 Gaseous (especially NO_x) reduction technologies 392
11.4 Ash and aerosol-related problems during biomass combustion including dust (fine particulate) reduction technologies 393
11.5 Innovative micro-, small- and medium-scale CHP technologies based on biomass combustion 394
11.6 Technology development and unsolved problems concerning co-firing of biomass in large-scale power plants 394
11.7 Fuel pre-treatment technologies 395
11.8 CFD modelling and simulation of thermochemical processes 395
11.9 References 396

Annex 1 Mass Balance Equations and Emission Calculation *408*
Annex 2 Abbreviations *413*
Annex 3 European and National Standards or Guidelines for Solid Biofuels and Solid Biofuel Analysis *417*
Annex 4 Members of IEA Bioenergy Task 32: Biomass Combustion and Cofiring *423*

Index *426*