

CONTENTS

	<u>Page</u>
Summary and conclusions.....	1
Introduction.....	3
Acknowledgments.....	4
General review of pilot plant and coal-gasification process	4
Operating performance of pilot plant.....	4
Gasifier.....	4
Flow metering.....	12
Temperature measurement.....	13
Scrubber.....	14
Coal-feeding equipment.....	16
Steam-oxygen heater.....	18
Reactant-injection burner.....	20
Pilot burner.....	28
Coal gasified.....	32
Pilot-plant operating procedures.....	32
Sampling gases and residues produced during gasification...	34
Gases.....	34
Residues.....	35
Experimental plan.....	36
Accuracy of results.....	36
Measuring reactants and product gases.....	36
Gas analysis.....	37
Calculations and graphs.....	37
Results--discussion and analysis.....	37
Effect of varying operating conditions.....	38
Carbon gasified, percent.....	38
Oxygen requirement.....	40
Coal requirement.....	41
Exit-gas temperature, calculated, ° F.....	43
Heat loss.....	43
Appendix I.....	45
Appendix II.....	55
Additional details of method of calculating experimental results.....	55

ILLUSTRATIONS

<u>Fig.</u>	<u>Page</u>
1. Pilot-plant flowsheet for gasifier 3.....	5
2. Reactor for pressure gasification.....	6
3. Refractory detail for gasifier 3, design 3.....	7
4. Refractory condition after test P-25, gasifier 3.....	9
5. Refractory condition after test P-34, gasifier 3.....	9
6. Pressure gasifier 3.....	10
7. View of water-cooled coil for high-pressure reaction chamber, looking down into gasifier.....	11
8. Refractory condition following test P-39, gasifier 3.	12
9. Arrangement of Fireye on pressure gasifier 3.....	13
10. View of spray coil.....	14
11. High-pressure-gasifier; slag-removal equipment.....	15
12. Simplified flow diagram of cooling-water metering system for gasifier 3.....	15
13. High-pressure gasifier; method of thermocouple installation at reaction-zone liner coil.....	16
14. Venturi-type, high-pressure, water-letdown valve.....	17
15. Coal-feeding-system weigh tanks.....	19
16. 1,500 p.s.i.-1,000° F. valve for steam or steam-oxygen service.....	20
17. Reactant-injection burner, design 4 (gasifier 3)....	21
18. Reactant-injection burner, design 5 (gasifier 3)....	22
19. Reactant-injection burner, design 6 (gasifier 3)....	24
20. Reactant-injection burner, design 7 (gasifier 3)....	25
21. End view of reactant-injection burner.....	26
22. Photomicrographs--cone edge of reactant-injection burner.....	26
23. Velocities of steam-oxygen mixtures entering gasifier	28
24. Pilot burner for high-pressure gasifier.....	29
25. Pilot burner, design 4, gasifier 3.....	31
26. Cutaway view of pilot burner.....	32
27. Scatter of data about correlations; gasifier pressure, 75 and 100 p.s.i.g.....	39
28. Scatter of data about correlations; carbon gasified percent.....	40
29. Effect of oxygen-to-coal ratio on carbon gasified, percent; gasifier pressure, 75, 100, 150, and 300 p.s.i.g.....	41
30. Effect of oxygen-to-coal ratio on oxygen requirement; gasifier pressure, 75, 100, 150, and 300 p.s.i.g....	42
31. Effect of oxygen-to-coal ratio on coal requirement; gasifier pressure, 75, 100, 150, and 300 p.s.i.g....	42
32. Effect of oxygen-to-coal ratio on exit-gas temperature; gasifier pressure, 75, 100, 150, and 300 p.s.i.g.....	44
33. Effect of oxygen-to-coal ratio on heat loss; gasifier pressure, 75, 100, 150, and 300 p.s.i.g.....	44

TABLES

	<u>Page</u>
1. Variation in volume of refractory-lined reaction zone, gasifier 3.....	8
2. Results of high-pressure water scrubbing of make gas from gasifier 3.....	18
3. Average analysis and standard deviation of analyses of coal used in high-pressure gasification runs 23 to 68.....	33
4. Typical gas analyses for various combinations of oxygen-to-coal ratio and pressure.....	35
5. Operating conditions and principal results, gasifier 3.....	45
6. Deviations of dependent variables for tests at 75 and 100 p.s.i.g.....	49
7. Deviations of dependent variables for tests at 100 and 150 p.s.i.g.....	50
8. Deviations of dependent variables for tests at 150 and 300 p.s.i.g.....	51
9. Coding equations for variables.....	53
10. Coefficients (coded values).....	54
11. Values of Student's <i>t</i> for coefficients.....	54
12. Analysis of variance.....	54
13. Oxygen requirement at 100 p.s.i.g. and a nominal coal rate of 700 pounds per hour.....	56