

Process Design Technical Note

TECHNICAL NOTE

SULPHUR DIOXIDE SCRUBBING

*P & I Design Ltd.
2Reed Street, Thornaby, Cleveland, TS17 7AF*

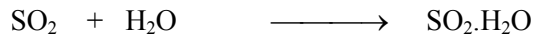
*Tel: (01642) 617444
Fax: (01642) 616447
E Mail: jee@pidesign.co.uk*

Sulphur Dioxide

Molecular weight	64.06
Melting Point	-75.5°C
Boiling Point	-10.0°C
Relative density (AIR)	2.264

1. Dissolution

Sulphur dioxide is soluble in water and is present in solution as hydrated SO₂ (SO₂.H₂O).



Solubility in water: 228 g/l @ 0°C,
45 g/l @ 50°C.

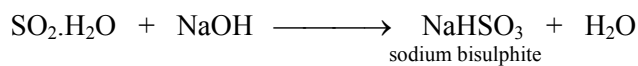
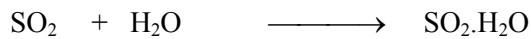
It is soluble in sulphuric acid

2. Scrubbing of sulphur dioxide

There are several methods of scrubbing sulphur dioxide. The method selected for a given situation depends on the rate and quantity involved and the availability and site compatibility of the neutralising chemicals required.

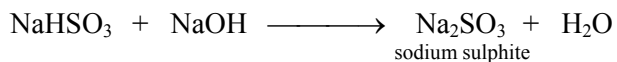
2.1 Sodium hydroxide solution

Scrubbing sulphur dioxide with caustic soda can be represented chemically as follows:-

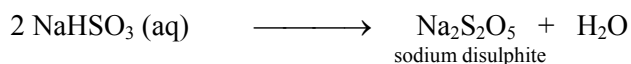


The **bisulphite** is the predominant species formed in **dilute** solutions.

Further reaction will take place with excess sodium hydroxide:-



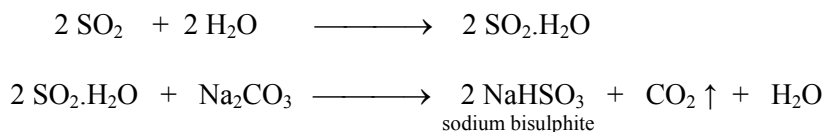
In the presence of excess sulphur dioxide the following will occur:-



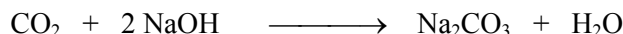
Under all scrubbing conditions one mole of sulphur dioxide will require one mole of sodium hydroxide for absorption and chemical reaction, irrespective of the final mixture of the sodium salts formed.

2.2 Sodium carbonate solution

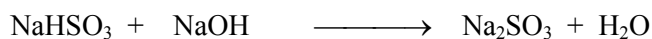
Scrubbing sulphur dioxide with sodium carbonate solution can be represented chemically as follows:-



The CO_2 generated can be vented to atmosphere or to a second scrubber containing sodium hydroxide solution when the following occurs:-



The two scrubbers could be switched and the sodium bisulphite solution discarded or further treated with sodium hydroxide solution as follows:-

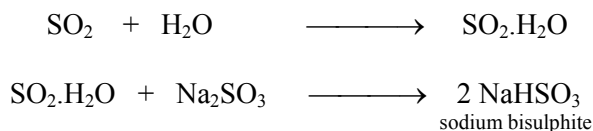


2.3 Mixed solution of sodium hydroxide and sodium carbonate

This achieves in a single scrubber the reactions outlined in 2.2. The scrubber will have to be designed for the carbon dioxide absorption case.

2.4 Sodium sulphite solution (Dual alkali system)

Scrubbing sulphur dioxide with sodium sulphite solution can be represented chemically as follows:-



The resultant bisulphite solution could then be reacted with lime (calcium hydroxide) as follows:-

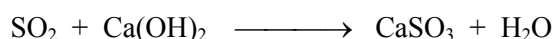


The gypsum can be filtered out and the sulphite solution re-used.

This method is suitable for higher emission rates and can be used to scrub a sulphur dioxide / sulphur trioxide mixture.

2.5 Lime slurry

Scrubbing sulphur dioxide with lime slurry can be represented chemically as follows:-



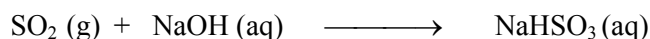
The calcium sulphite is further oxidised with air



3. Heats of Reaction

3.1 Sodium hydroxide solution

Heats of formation, $\Delta H_f @25^\circ\text{C}$	SO_2 (g)	-70.94 kcal/mole
	$\text{SO}_2 \cdot \text{H}_2\text{O}$ (aq)	-146.88
	NaOH (aq)	-112.19
	NaHSO_3 (aq)	-269.42 (<i>estimated from CODATA</i>)

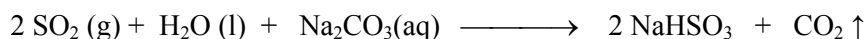


$$\begin{aligned} \text{Heat of reaction} &= -(-70.94 + (-112.19)) + (-269.42) \\ &= 183.13 - 269.42 = \underline{-86.29 \text{ kcal/mole}} \end{aligned}$$

i.e. **86 kcal/gm mole sulphur dioxide exotherm**

3.2 Sodium carbonate solution

Heats of formation, $\Delta H_f @25^\circ\text{C}$	SO_2 (g)	- 70.94 kcal/mole
	H_2O (l)	- 68.32
	Na_2CO_3 (aq)	-275.13
	NaHSO_3 (aq)	-269.42 (<i>estimated from CODATA</i>)
	CO_2 (g)	- 94.05



$$\begin{aligned} \text{Heat of reaction} &= -(2 \times (-70.94) + (-68.32) + (-275.13)) + (2 \times (-269.42) + (-94.05)) \\ &= 485.33 - 632.89 = \underline{-147.56 \text{ kcal/mole}} \end{aligned}$$

i.e. **148 kcal/gm mole sulphur dioxide exotherm**

3.3 Sodium sulphite solution

Heats of formation, $\Delta H_f @25^\circ\text{C}$	SO_2 (g)	- 70.94 kcal/mole
	H_2O (l)	- 68.32
	Na_2SO_3 (aq)	-264.1
	NaHSO_3 (aq)	-269.42 (<i>estimated from CODATA</i>)



$$\begin{aligned} \text{Heat of reaction} &= -(-70.94 + (-68.32) + (-264.1)) + (2 \times (-269.42)) \\ &= 403.36 - 538.84 = \underline{-135.48 \text{ kcal/mole}} \end{aligned}$$

i.e. **135 kcal/gm mole sulphur dioxide exotherm**