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(54) Title: SYSTEM AND METHOD FOR CONTROLLING FROTHING DURING ATMOSPHERIC LEACHING OF METAL
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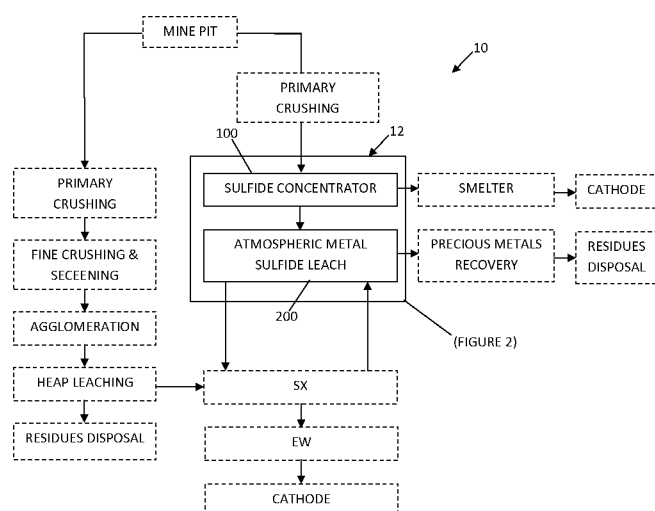


FIGURE 1

(57) Abstract: A method of controlling frothing during atmospheric or substantially atmospheric leaching of a metal sulfide is disclosed. In some embodiments, the method may comprise the steps of (a) producing a metal sulfide concentrate via flotation; (b) producing a tailings stream via flotation; and, (c) diverting a portion or all of said produced tailings stream to an atmospheric or substantially atmospheric sulfide leach circuit. A metal recovery flowsheet is also disclosed. In some embodiments, the metal recovery flowsheet may comprise a unit operation comprising: (a) a sulfide concentrator comprising a flotation circuit, the flotation circuit producing a metal sulfide concentrate stream, and a tailings stream; and, (b) an atmospheric or substantially atmospheric metal sulfide leach circuit. The sulfide concentrator may be operatively connected to the atmospheric or substantially atmospheric metal sulfide leach circuit via both of said metal sulfide concentrate stream, and said tailings stream.

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SYSTEM AND METHOD FOR CONTROLLING FROTHING DURING ATMOSPHERIC LEACHING OF METAL SULPHIDES USING SILICATES

CROSS-REFERENCE TO RELATED APPLICATIONS

This application claims priority to co-pending United States Provisional Patent Application No. 62/042,414, filed on 27 August 2014, which is titled: "SYSTEM AND METHOD FOR CONTROLLING FROTHING DURING ATMOSPHERIC LEACHING OF METAL SULPHIDES USING SILICATES" and which is hereby incorporated by reference in its entirety for any and all purposes as if fully set forth herein.

FIELD OF THE INVENTION

Embodiments of the invention relate to equipment and/or processes for improving metal value extraction from metal sulfide ores. In particular, systems and methods for mitigating and/or controlling frothing using silicates are disclosed. Systems and methods for increasing recovery within an atmospheric or substantially atmospheric leach circuit during the leaching of metal sulfide concentrates are also disclosed.

BACKGROUND OF THE INVENTION

Current and past methods of atmospheric metal sulfide leaching can be hindered by the formation or build-up of froth over time within a leach circuit. The froth may, for instance, build

up near top portions of a leach reactor, and accordingly, portions of a metal sulfide concentrate which are to be leached, may be displaced from and therefore may leave contact with lixiviant. Accordingly, some ground sulfide particles within a metal sulfide concentrate may not be exposed to lixiviant for the predetermined residence time necessary for complete leaching to occur. It is not uncommon for froth contents, which are displaced from lixiviant, to contain un-leached or partially un-leached particles. Such effects reduce overall leach recovery, and/or may decrease actual leach residence times for floated particles contained within the froth, to below that which is required to achieve complete metal dissolution (e.g., for complete copper dissolution). In short, conventional atmospheric metal sulfide leaching may be impeded by froth formation. Without limiting the scope of this disclosure, it will be understood by those skilled in the art, that the term “atmospheric” or “substantially atmospheric” where used herein may include systems or apparatus within a leach circuit which may negligibly contribute to the overall use of above ambient pressures. For example, without limitation, open-top stirred reactors and pressurizable enclosed stirred-reactors may be present within an atmospheric or substantially atmospheric leach circuit according to some embodiments, without limitation. Without departing from the intent of the invention, the reactor head space may be atmospheric or alternatively pressurized to above ambient pressure to control the head-space gas composition. The pressure may be controlled by temperature or by an applied gas pressure that is above ambient pressure. As will be described hereinafter, in some preferred embodiments, most leaching may occur at atmospheric pressure conditions, and a much smaller amount of leaching may occur at above atmospheric conditions. In some preferred embodiments, a majority of leaching residence time of a metal sulphide particle may occur at atmospheric pressure conditions, and a minimal amount of leaching residence time of a metal sulphide particle may occur above atmospheric conditions.

For example, in some non-limiting embodiments, a leach reactor 202, such as the one shown in FIG. 2, may comprise one or more open-top conventional stirred tank reactors (CSTRs), and an optional attrition scrubber (212), such as the one shown in FIG. 2, may comprise one or more enclosed stirred media reactors configured to be pressurized, receive oxygen, and/or contain grinding media, without limitation. In some embodiments, the optional attrition scrubber (212), such as the one shown in FIG. 2, may comprise one or more enclosed high shear stirred reactors configured to be pressurized, receive oxygen, and/or impart shear between particles of a concentrate to be leached using one or more high shear impellers, without limitation. In some embodiments, the one or more high shear impellers may be selected from the group consisting of: a Cowles disperser blade, a sawblade mixing impeller, a dispersion blade, a saw tooth dispersion blade, an angled tooth blade, an ultra-shear dispersion blade, a high flow dispersion blade, and a combination thereof, without limitation.

The processing and purification of metal sulfide-containing ores involves various unit operations, including, without limitations, crushing, grinding, and froth flotation. In the flotation process, surface-active reagents are generally used to selectively alter the wetting characteristics of sulfide mineral surfaces to promote their separation from gangue minerals. The surfactant-modified particles are separated and recovered by virtue of their selective partitioning from the mineral slurry to froth. When the mineral-containing pulp within a flotation cell is aerated, the surface-modified particles have a tendency to attach to the air bubbles, and rise by buoyancy to produce a mineralized froth which is concentrated atop the surface of the agitated, mineral pulp. Various types of froth flotation reagents are commonly used in mineral separations, including collectors, frothers, activators, and depressants.

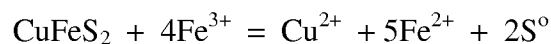
The appearance of a stable froth is generally the end result of interfacial activity, and involves the action of surface-active species such as surfactants (i.e., amphiphilic molecules) and additionally, or alternatively, fine particles whose surfaces are amphiphilic. Conditions or phenomena which favor the adsorption of amphiphilic species at the liquid/gas interface will generally promote foam stability and frothing. Consequently, electrolyte solutions composed of ions with strong water-structure influence (i.e., positive hydration) such as SO_4^{2-} would likely promote frothing, while ions which weakly influence water structure (i.e., negative hydration) such as HSO_4^- and SO_3^- , would likely be less likely to promote frothing. Additionally, high pressures suppress frothing, while atmospheric pressures or below atmospheric pressures favor its formation.

While the generation of a stable froth is used to an advantage in the selective separation and recovery of mineral particles from gangue during froth flotation processes, the appearance of a stable froth in atmospheric leach processes remains problematic. Prior art systems and methods have been proposed to deal with this problem, yet they have produced unintended problems of their own. Accordingly, new improved systems and methods are needed to overcome these problems.

In the hydrometallurgical processing of copper sulfide concentrates, a copper concentrate is typically dispersed in an acidic ferric sulfate leach liquor to bring about dissolution of copper contained in the mineral particles. The leach process produces a pregnant leach solution (PLS) which is then typically treated by a solvent extraction (SX) process to separate and recover the dissolved copper therein. The SX process is followed by electrowinning, in order to produce high-purity copper cathodes.

In some prior art leach processes (US-5,993,635 for example), the flotation concentrate is initially subjected to ultra-fine grinding, followed directly by oxidative leaching under atmospheric conditions. In these methods, the copper is dissolved from the copper-bearing minerals at temperatures below the boiling point of water. Although there may be localized, transient heating to temperatures of 100°C or slightly higher (due to exothermic chemical reactions), the pulp temperature is inherently limited due to the fact that the system is at atmospheric pressure. Moreover, large amounts of energy must be consumed during pre-leach ultra-fine grinding, in order to reduce particle size distributions within the flotation concentrate to a P80 of less than 20 microns, down to 5 microns.

An oxidizing agent, such as ferric ion, is commonly used to facilitate the copper dissolution reaction. During the course of this chemical reaction, the oxidizing agent (i.e., ferric ion) is reduced from the ferric oxidation state to the ferrous oxidation state. To continue the process until the majority of the copper is recovered from the mineral particles, oxygen or air is sparged into a stirred reactor to continuously oxidize the product ferrous ion back to the +3 ferric oxidation state. In the case of chalcopyrite dissolution, ferric ions are believed to enable the leaching of copper via the following reaction:



Simultaneous regeneration of the ferric oxidant and maintenance of electroneutrality is believed to proceed via the following reaction:



Consequently, acid is consumed during the leaching of chalcopyrite. Similar reactions in which ferric ion acts as an oxidant are known for the leaching of other metal sulfides, including copper, zinc, iron, manganese, nickel, cobalt, etc.

During the course of the atmospheric leach process, crystalline and/or solid phase elemental sulfur (S^0) is produced as a reaction product by virtue of the temperatures and oxygen pressures employed. Because the temperatures involved are below the melting temperature of elemental sulfur, the sulfur appears as a crystalline and/or solid phase on the surface of the copper-bearing mineral particles. During the initial stages of the leach process, surfaces of the copper-bearing mineral particles become amphiphilic due to the appearance of the hydrophobic sulfur product. As the leach process progresses, the continued accumulation of elemental sulfur causes surfaces of the copper-bearing particles to become hydrophobic. During the early stages of the leach process, the combination of ultra-fine particle sizes, high surface areas, and the amphiphilic nature of the particle surfaces within the concentrate leads to the formation of a stable, highly mineralized froth. As a result, mineral particles trapped in the froth are significantly less likely to completely leach. During the later stages of the leach process, the accumulated elemental sulfur can also act as a physical barrier (i.e., the mineral particles passivate), thereby inhibiting continued copper dissolution from the mineral particles.

In prior art methods, the presence of flotation reagents has contributed to the problem of excessive frothing during atmospheric leaching processes of metal sulfides. This phenomenon results in metal-containing particles (for instance, copper-containing particles) becoming segregated from the leach liquor and becoming concentrated within the froth layer. This physical segregation can lead to the removal of the particles from the leach solution thereby

slowing or inhibiting the copper dissolution process. In extreme cases, especially where the dissolution rate requires rapid oxygenation, frothing can be so vigorous that it becomes difficult to retain the particles within a stirred leach reactor. This leads to reduced actual residence times experienced by mineral particles residing within the leach reactor, and ultimately negatively impacts leach rates and metal (e.g., copper) recovery.

A prior art method to deal with excessive frothing includes the use of a draft tube to encourage remixing of the froth within the leach liquor. Other prior art methods focus on the use of a wetting agent within the initial stages of an atmospheric leach process, for example, Lignosol to inhibit froth stability (as described in US-5,993,635), or calcium lignosulfonate (as described in WO 97/127070). In particular, prior art methods that teach the use of adding an attriting agent (i.e., silica sand), to enhance metal sulfide dissolution within an atmospheric leach reactor, have also necessarily required the addition of an organic defoaming agent in order to control frothing. From these prior art teachings, particulate SiO₂, such as quartz and sand, are not effective defoaming agents.

Other prior art methods have similarly used wetting agents (e.g., ammonium lignin sulfonate) to mitigate the effects of sulfur passivation during elevated temperature autoclave leaching of metal sulfides where the elemental sulfur is present in a “*liquid*” state, rather than in a solid state (see, for example, US-4,192,851). From prior art teachings, it can be reasoned that wetting agents such as lignin sulfonates do not effectively mitigate the effects of sulfur passivation during atmospheric leaching of metal sulfides.

Surfactants that have been found to be useful in dispersing “*liquid*” elemental sulfur, include, but are not limited to, lignin sulfonates, lignins, tannin compounds such as quebracho, and alkylaryl sulfonates (US-3,867,268). In addition to surfactants, still other prior art methods

which aim to promote the dispersion of liquid elemental sulfur, include ground sand, and mineral processing tailings (e.g., US-6,497,745 and US-7,041,152). None of these prior teachings suggest apparatus or methods for defoaming or mitigating frothing in the presence of a crystalline and/or “*solid*” phase sulfur product (e.g., elemental sulfur product).

A problem with prior art methods, which entail the use of surfactants to solve the problem of sulfur passivation, is the difficulty caused when these surfactants migrate to downstream unit operations, such as solvent extraction (SX) processes. For example, the contamination of an SX circuit by these surfactants can lead to the formation of oil/water emulsions that are difficult to separate, or they may lead to the formation of interfacial cruds that inhibit the interfacial mass transfer of copper. Surfactants, by their ability to adsorb at interfaces, can also interfere with the very copper dissolution reactions they are employed to aid.

OBJECTS OF THE INVENTION

It is, therefore, an object of some embodiments of the present invention, to minimize, mitigate, and/or control frothing within a sulfide leach circuit using silicates, in particular, an atmospheric or substantially atmospheric metal sulfide leach.

It is also an object of some embodiments of the present invention, to reduce and/or eliminate the need for the addition of a superfluous reagent or reagents, into the leach circuit, which might cost money to purchase, ship, and dose, and/or which might compromise downstream processes (e.g., solvent extraction) or negatively impact leach times and/or overall metal recovery.

It is also an object of some embodiments of the present invention, to minimize, mitigate, and/or control frothing within a sulfide leach circuit using silicates which may be readily obtained from an upstream concentrator, thereby obviating the need to purchase, ship, and introduce separate or foreign materials into the leaching circuit or other portions of a metal recovery flowsheet.

It is also an object of some embodiments of the present invention, to utilize portions of otherwise disposed of tailings from an upstream concentrator (e.g., tailings originating from rougher circuit flotation tails), in an atmospheric or substantially atmospheric metal sulfide leach circuit which is downstream from said upstream concentrator, in order to reduce frothing within said metal sulfide leach circuit and/or its negative effects on leach kinetics or recovery.

It is also an object of some embodiments of the present invention, to utilize portions of run-of-mine (ROM) material, which preferably comprises silicates, from upstream of a concentrator (e.g., before froth flotation), in an atmospheric or substantially atmospheric metal sulfide leach circuit which is downstream from said upstream concentrator, in order to reduce frothing within said metal sulfide leach circuit and/or its negative effects on leach kinetics or recovery.

It is also an object of some embodiments of the present invention, to utilize portions of run-of-mine (ROM) material, which preferably comprises silicates, from an upstream concentrator (e.g., before froth flotation, but after grinding), in an atmospheric or substantially atmospheric metal sulfide leach circuit which is downstream from said upstream concentrator, in order to reduce frothing within said metal sulfide leach circuit and/or its negative effects on leach kinetics or recovery.

These and other objects of the present invention will be apparent from the drawings and description herein. Although every object of the invention is believed to be attained by at least one embodiment of the invention, there is not necessarily any one embodiment of the invention that achieves all of the objects of the invention.

SUMMARY OF THE INVENTION

A method of controlling frothing during atmospheric or substantially atmospheric leaching of a metal sulfide is disclosed. According to some embodiments, the method may comprise the steps of: (a) producing a metal sulfide concentrate via flotation; (b) producing a tailings stream via flotation; and, (c) diverting a portion or all of said produced tailings stream to an atmospheric or substantially atmospheric sulfide leach circuit. According to some embodiments, the step of diverting a portion or all of said produced tailings stream to an atmospheric or substantially atmospheric sulfide leach circuit may comprise the step of dosing at least one leach reactor and/or at least one attrition scrubber provided within the atmospheric or substantially atmospheric sulfide leach circuit. According to most preferred embodiments, the atmospheric or substantially atmospheric sulfide leach circuit may be maintained at a temperature below the melting point of elemental sulfur (S°). According to some preferred embodiments, the at least one attrition scrubber may be configured with oxygen introduction means (e.g., an O_2 feed port with control valve). According to some preferred embodiments, the at least one attrition scrubber may comprise a stirred media reactor or a high shear stirred reactor comprising one or a plurality of high shear impellers, without limitation. According to some preferred embodiments, the at least one attrition scrubber may be maintained between 50% and

99% solids, such as between 60% and 90% solids, for example, between 70% and 80% solids, without limitation. According to some embodiments, the tailings stream may comprise one or more of the following: quartz, aluminosilicates, phyllosilicates (including but not limited to chlorite, kaolinite, montmorillonite, palygorskite, talc, vermiculite), micas (including but not limited to biotite, muscovite, phlogopite), feldspars, zeolites, diatomaceous earth, and various combinations thereof, without limitation. The method may further comprise the step of (d) reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit. In some embodiments, the step of reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit may comprise providing a leach time (e.g., metal sulfide concentrate average residence time) of less than approximately 6 hours to accomplish greater than approximately 95% recovery of a metal from the metal sulfide concentrate. In some embodiments, the step of reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit may comprise providing a leach time between approximately 2.5 and approximately 4 hours to accomplish greater than approximately 95% recovery of a metal from the metal sulfide concentrate.

A metal recovery flowsheet is also disclosed. The metal recovery flowsheet may comprise a unit operation comprising: (a) a sulfide concentrator comprising a flotation circuit, the flotation circuit producing a stream of metal sulfide concentrate, and a tailings stream; and, (b) an atmospheric or substantially atmospheric metal sulfide leach circuit. According to some embodiments, the sulfide concentrator may be operatively connected to the atmospheric or substantially atmospheric metal sulfide leach circuit via both of said metal sulfide concentrate stream, and said tailings stream. According to some embodiments, the atmospheric or

substantially atmospheric metal sulfide leach circuit may comprise one or more leach reactors, and silicates contained within said tailings stream may be provided to one or more leach reactors. According to some embodiments, the atmospheric or substantially atmospheric metal sulfide leach circuit may comprise one or more attrition scrubbers, and silicates contained within said tailings stream may be provided to the one or more attrition scrubbers. According to some embodiments, silicates contained within said tailings stream may be provided to the both of said one or more leach reactors and said one or more attrition scrubbers. According to some embodiments, silicates contained within said tailings stream may be provided to either of said one or more leach reactors or said one or more attrition scrubbers. In some embodiments, one or more attrition scrubbers may be provided in series with said one or more leach reactors (i.e., an “inter-stage” configuration), without limitation. In some embodiments, one or more attrition scrubbers may be provided in parallel with said one or more leach reactors (i.e., an “inter-stage” configuration), without limitation. In some embodiments, one or more attrition scrubbers may be provided both in parallel with said one or more leach reactors (i.e., an “inter-stage” configuration), and in series with said one or more leach reactors, without limitation. In some embodiments, at least one attrition scrubber may be shared by at least two leach reactors. In some embodiments, silicates contained within said tailings stream which are delivered to the atmospheric metal sulfide leach circuit may comprise one or more of the following: quartz, aluminosilicates, phyllosilicates (including but not limited to chlorite, kaolinite, montmorillonite, palygorskite, talc, vermiculite), micas (including but not limited to biotite, muscovite, phlogopite), feldspars, zeolites, diatomaceous earth and various combinations thereof, without limitation.

A method of controlling frothing during atmospheric or substantially atmospheric leaching of a metal sulfide, may, according to some embodiments, comprise the steps of: (a) producing a metal sulfide concentrate via flotation; (b) producing a stream of run-of-mine (ROM) material; and, (c) diverting a portion of said stream of run-of-mine (ROM) material to an atmospheric or substantially atmospheric sulfide leach circuit being fed with said metal sulfide concentrate. In some embodiments, the step of diverting a portion of said stream of run-of-mine (ROM) material to an atmospheric or substantially atmospheric sulfide leach circuit may comprise: the step of dosing at least one leach reactor and/or at least one attrition scrubber provided within the atmospheric or substantially atmospheric sulfide leach circuit with run-of-mine (ROM) material, and/or the step of controlling said dosing of run-of-mine (ROM) material, without limitation. In some embodiments, the stream of run-of-mine (ROM) material may comprise one or more of the following: quartz, aluminosilicates, phyllosilicates (including chlorite, kaolinite, montmorillonite, palygorskite, talc, vermiculite), micas (including biotite, muscovite, phlogopite), feldspars, zeolites, diatomaceous earth, and various combinations thereof, without limitation. In some embodiments, the method may further comprise the step of: (d) reducing a leach time (e.g., metal sulfide concentrate average residence time) of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit. In some embodiments, the step of reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit may comprise a leach time of less than approximately 5 hours to accomplish greater than approximately 95% recovery of a metal from the metal sulfide concentrate. In some embodiments, the step of reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit may comprise a leach time between approximately 2.5 and approximately 4 hours to

accomplish greater than approximately 95% recovery of a metal from the metal sulfide concentrate. In some embodiments, the method may comprise the step of (d) grinding and/or screening the run-of-mine (ROM) material, prior to the diverting step (c).

A method of controlling frothing during atmospheric or substantially atmospheric leaching of a metal sulfide, may, in some embodiments, comprise the steps of: (a) producing a metal sulfide concentrate via flotation; (b) producing a stream of run-of-mine (ROM) material; (c) grinding the stream of run-of-mine (ROM) material, for example, using a grinding apparatus such as a mill (e.g., ball mill, SAG mill, fine-grinding mill, roller mill, etc.) to produce a stream of ground run-of-mine (ROM) material (e.g., prior to froth flotation); and, (d) diverting a portion of said stream of ground run-of-mine (ROM) material to an atmospheric or substantially atmospheric sulfide leach circuit being fed with said metal sulfide concentrate. According to some embodiments, the step of diverting a portion of said stream of ground run-of-mine (ROM) material to an atmospheric or substantially atmospheric sulfide leach circuit may comprise the step of dosing at least one leach reactor and/or at least one attrition scrubber provided within the atmospheric or substantially atmospheric sulfide leach circuit with run-of-mine (ROM) material, and/or the step of controlling said dosing of run-of-mine (ROM) material, without limitation. In some embodiments, the stream of ground run-of-mine (ROM) material may comprise one or more of the following: quartz, aluminosilicates, phyllosilicates (including chlorite, kaolinite, montmorillonite, palygorskite, talc, vermiculite), micas (including biotite, muscovite, phlogopite), feldspars, zeolites, diatomaceous earth, and various combinations thereof, without limitation. In some embodiments, the method may further comprise the step of: (d) reducing a leach time (e.g., metal sulfide concentrate average residence time) of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit. In some

embodiments, the step of reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit may comprise a leach time of less than approximately 5 hours to accomplish greater than approximately 95% recovery of a metal from the metal sulfide concentrate. In some embodiments, the step of reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit may comprise a leach time between approximately 2.5 and approximately 4 hours to accomplish greater than approximately 95% recovery of a metal from the metal sulfide concentrate. In some embodiments, the method may comprise the step of: (e) screening the stream of ground run-of-mine (ROM) material, prior to the step (d) of reducing a leach time.

In some embodiments, a metal recovery flowsheet may comprise a unit operation having: (a) a sulfide concentrator comprising a flotation circuit, the flotation circuit producing a metal sulfide concentrate stream; (b) at least one of: a stream of run-of-mine (ROM) material originating from a mine site, a stream of ground run-of-mine (ROM) material originating from a grinding circuit of a sulfide concentrator, and a stream of tailings from said sulfide concentrator; and, (c) an atmospheric or substantially atmospheric metal sulfide leach circuit; wherein the atmospheric or substantially atmospheric metal sulfide leach circuit may be operatively connected to said at least one of a stream of run-of-mine (ROM) material originating from a mine site, a stream of ground run-of-mine (ROM) material originating from a grinding circuit of a sulfide concentrator, and a stream of tailings from said sulfide concentrator. In preferred embodiments, a sulfide concentrator may comprise a copper sulfide concentrator, and a metal sulfide concentrate stream may comprise copper sulfide particles or copper sulfide concentrate.

BRIEF DESCRIPTION OF THE DRAWINGS

To complement the description which is being made, and for the purpose of aiding to better understand the features of the invention, a set of drawings illustrating preferred apparatus and methods of using the same is attached to the present specification as an integral part thereof, in which the following has been depicted with an illustrative and non-limiting character. It should be understood that like reference numbers used in the drawings (if any are used) may identify like components.

FIG. 1 is a schematic diagram illustrating a non-limiting, exemplary flowsheet according to some embodiments of the invention.

FIG. 2 is a schematic diagram illustrating, in more detail, a unit operation portion of the non-limiting, exemplary flowsheet shown in FIG. 1, wherein dewatered silicates, including clays, may be taken from tailings, and used in an atmospheric or substantially atmospheric metal sulfide leach, according to some embodiments, and/or silicates, including clays, may be taken from run-of-mine (ROM) material or ground run-of-mine (ROM) material, and used in an atmospheric or substantially atmospheric metal sulfide leach circuit, according to some embodiments. The ROM material may be selected or prepared in some way (e.g., via screening, sorting, chemical pre-treating, mechanical pre-treating, and/or isolating low-grade, high-silicate feed), prior to distribution to the atmospheric or substantially atmospheric metal sulfide leach circuit.

FIG. 3 is a schematic diagram illustrating a system and method of providing silicates (which may include clays), to an atmospheric or substantially atmospheric metal sulfide leach, according to some embodiments.

FIG. 4 is a schematic diagram illustrating a system and method of providing silicates (which may include clays), to one or more portions of an atmospheric or substantially atmospheric metal sulfide leach, which may contain one or more attriting devices, according to some embodiments.

FIG. 5 is a non-limiting graph, illustrating leach results according to some embodiments, which highlights advantages of the system and methods disclosed herein over more conventional practices. In particular, leach results for copper sulfide concentrates are shown in FIG. 5.

In the following, the invention will be described in more detail with reference to drawings in conjunction with exemplary embodiments.

DETAILED DESCRIPTION OF THE INVENTION

The following description of the non-limiting embodiments shown in the drawings is merely exemplary in nature and is in no way intended to limit the inventions disclosed herein, their applications, or uses.

As schematically shown in FIG. 1, embodiments of the invention may comprise a metal recovery flowsheet 10 comprising a unit operation 12 having an atmospheric or substantially atmospheric metal sulfide leach circuit 200 downstream of a sulfide concentrator circuit 100, without limitation. Peripheral flowsheet operations (depicted by boxes with dotted lines) may differ from what is shown.

As schematically shown in FIG. 2, according to some embodiments, the sulfide concentrator circuit 100 portion of the unit operation 12 may comprise a grinding stage 102,

where run-of-mine (ROM) material may be ground and then floated in a flotation circuit 104. Preferably, the run-of-mine (ROM) material may be selected from a substantially tannin-free material, for example, a material lacking organics including, but not limited to top soils, which might contain tannic or humic acids. The flotation circuit 104 may comprise a number of rougher and/or scavenger float cells and may optionally comprise a regrind circuit (not shown), without limitation. Tailings 106 from the flotation circuit 104 may be dewatered, e.g., in a thickener or filter 108, and the dewatered tailings 109 (e.g., thickener underflow and/or filter cake) may be sent to a pond 110 and/or may optionally be sent to an atmospheric or substantially atmospheric metal sulfide leach process 200 as suggested by FIGS. 1 and 2. In some embodiments, the dewatered tailings 109 may comprise silicates of one or more types. A valve, diverter, separation device, splitter, sorter, and/or conveying means 112 may be provided within the sulfide concentrator 100, so that a bleed stream/slipstream 114 may be taken from the dewatered tailings stream 109. A portion of the silicates in the bleed stream/slipstream 114 may be sent to the atmospheric or substantially atmospheric metal sulfide leach circuit 200. For example, silicates may be delivered to a leach reactor 202 (or to multiple leach reactors as suggested in FIG. 4) via a first silicate stream 208, and/or silicates may be delivered to an attrition scrubber 212 (or to multiple attrition scrubbing devices as suggested in FIG. 4) via a second silicate stream 210. Amounts by weight or volume of silicates in each of the first 208 and/or second 210 silicate streams may vary, may differ, or may be similar, for example, according to a process control algorithm. In some embodiments, a leach reactor 202 may be operatively coupled to a attrition scrubber 212 as shown. In some embodiments (not shown), the leach reactor 202 and the attrition scrubber 212 may be combined into one device, without limitation. In some embodiments (not shown), the attrition scrubber 212 may be omitted from

the atmospheric or substantially atmospheric metal sulfide leach circuit 200 altogether. If a separate attrition scrubber 212 is utilized in combination with a leach reactor 202, then silicates and metal sulfide particles (e.g., particles to be leached or being leached) may pass back and forth between the leach reactor 202 and the attrition scrubber 212 during leach. An attrition scrubber 212 may be placed in series between two adjacent leach reactors 202 (i.e., in an “inter-stage” circuit arrangement), and/or an attrition scrubber 212 may be placed in parallel being fed from, and discharging leach concentrate into, the same leach reactor 202 (i.e., in an “intra-stage” circuit arrangement), without limitation.

As shown in FIG. 2 (and suggested in FIG. 4), raw ore, for example in the form of a stream 118 of excavated run-of-mine (ROM) material, which may or may not be sized, screened, or sorted for silicates content, may be provided. Moreover, a stream 120 of ground run-of-mine (ROM) material (e.g., ROM material which has been pulverized by, for example, a ball mill or High Pressure Grinding Roller - HPGR located within a grind circuit 102), may also be provided. The stream 120 of ground run-of-mine (ROM) material may, or may not be sized, screened, or sorted for silicates content. The raw ore in the stream 120 may comprise any one or more of the silicates listed herein. One or more bleed streams/slipstreams 122 of the raw ore containing silicates may be sent to one or more leach reactors 202 in the atmospheric or substantially atmospheric metal sulfide leach circuit 200. In addition to, or instead of the one or more leach reactors 202, the one or more bleed streams/slipstreams 122 of the raw ore containing silicates may be sent to one or more attrition scrubbers 212 in the atmospheric or substantially atmospheric metal sulfide leach circuit 200 (e.g., via optional stream 218). A valve, diverter, separation device, splitter, sorter, or conveying means 126 may be provided to take a bleed stream/slipstream 122 of raw ore containing silicates, and blend it, mix it, or combine it (via

connecting stream 124) with a dewatered tailings solids slipstream 114. It should be realized that the inventors anticipate various combinations and permutations of the bleed stream/slipstream configurations shown, in order to provide silicates to one or more portions of an atmospheric or substantially atmospheric metal sulfide leach circuit, without limitation.

As schematically shown in FIG. 3, a flotation circuit 104 may send its overflow froth 116, which is comprised of a metal sulfide concentrate, to an optional pre-grind step 216, prior to entering an atmospheric or substantially atmospheric metal sulfide leaching circuit 200. Tailings 106 from the flotation circuit 104 may be dewatered in a thickener or filter 108, wherein liquids (i.e., the thickener overflow or filtrate) from the thickener or filter 108 may be recycled, and wherein some or all of the solids associated with a dewatered tailings stream 109 (e.g., thickener underflow or filter cake) may be diverted, via a valve, diverter, separation device, splitter, sorter, or conveying means 112, to one or more components within the atmospheric or substantially atmospheric metal sulfide leaching circuit 200, such as to one or more leach reactors 202 and/or to one or more optional attrition scrubber devices 212. Silicates contained within the dewatered tailings bleed stream/slipstream 114 extending to the atmospheric or substantially atmospheric metal sulfide leaching circuit 200 may be used as a froth control agent. It will be understood by those skilled in the art that the flotation tailings may contain additional minerals, such as pyrite and metal-bearing sulfides.

Froth overflow 116, produced from the flotation circuit 104, may comprise a metal sulfide concentrate. The metal sulfide concentrate 116 may be optionally ground in an optional pre-grind step 216, before entering the atmospheric or substantially atmospheric, metal-sulfide leach circuit 200. Pregnant leach solution 204 created during atmospheric or substantially

atmospheric leaching of the metal sulfide concentrate 116 may be sent from at least one leach reactor 202 and/or from at least one attrition scrubber 212, from within the leaching circuit 200, to a downstream solvent extraction/electrowinning (SX/EW) circuit as shown. Barren liquor/raffinate 206 may be sent back to the at least one leach reactor 202 and/or to the at least one attrition scrubber 212, from the downstream solvent extraction/electrowinning (SX/EW) circuit as shown. Leach residue from the atmospheric or substantially atmospheric metal sulfide leach circuit 200 may be sent to a precious metals recovery circuit and/or ultimately to a leach residues disposal area as suggested by FIG. 1. Alternatively, sulfur contained within leach residue from the atmospheric or substantially atmospheric metal sulfide leach circuit 200 may be processed to supply sulfuric acid to the leach process .

FIG. 4 suggests another non-limiting embodiment showing how silicates from froth flotation tailings can be directed from a tailings stream and/or run-of-mine (ROM) material stream, to one or more pieces of equipment within an atmospheric or substantially atmospheric sulfide leach circuit 200. As shown, silicates (including clays) may be added to one or more leach reactors 202 and/or added to one or more optional attrition scrubbers 212, which may be interposed in series between said one or more leach reactors 202 (i.e., “inter-stage”), or which may be disposed in parallel (i.e., “intra-stage”) with the one or more leach reactors 202, individually, or collectively, in various combinations, and/or permutations, without limitation. Attrition scrubbing devices 212 shown in FIG. 4 may comprise one or more enclosed high shear stirred reactors configured to be pressurized, receive oxygen, and/or impart shear between particles of a concentrate to be leached using one or more high shear impellers, without limitation. In some embodiments, the one or more high shear impellers may be selected from the group consisting of: a Cowles disperser blade, a sawblade mixing impeller, a dispersion blade, a

saw tooth dispersion blade, an angled tooth blade, an ultra-shear dispersion blade, a high flow dispersion blade, and a combination thereof, without limitation. According to some preferred embodiments, the at least one attrition scrubber may be maintained between 50% and 99% solids, such as between 60% and 90% solids, for example, between 70% and 80% solids, without limitation.

Silicates, where described herein, may comprise mineral compounds including one or more of the following, without limitation: quartz, aluminosilicates, phyllosilicates (including but not limited to chlorite, kaolinite, montmorillonite, palygorskite, talc, vermiculite), micas (including but not limited to biotite, muscovite, phlogopite), feldspars, zeolites, diatomaceous earth, and various combinations thereof, without limitation.

In some embodiments, the metal sulfide concentrate (e.g., copper sulfide concentrate) may comprise residual flotation reagents. In some preferred embodiments, the metal sulfide may comprise copper in the form of Chalcopyrite CuFeS_2 . However, it should be known that other metal-bearing minerals occurring in combination with metal sulfides (e.g., including Acanthite Ag_2S , Chalcocite Cu_2S , Bornite Cu_5FeS_4 , Enargite Cu_3AsS_4 , Tennantite $\text{Cu}_{12}\text{As}_4\text{S}_{13}$, Tetrahedrite $\text{Cu}_3\text{SbS}_3 \cdot x(\text{Fe}, \text{Zn})_6\text{Sb}_2\text{S}_9$, Galena PbS , Sphalerite ZnS , Chalcopyrite CuFeS_2 , Pyrrhotite Fe_{1-x}S , Millerite NiS , Pentlandite $(\text{Fe}, \text{Ni})_9\text{S}_8$, Covellite CuS , Cinnabar HgS , Realgar AsS , Orpiment As_2S_3 , Stibnite Sb_2S_3 , Pyrite FeS_2 , Marcasite FeS_2 , Molybdenite MoS_2 , Malachite $\text{CuCO}_3 \cdot \text{Cu}(\text{OH})_2$, Azurite $2\text{CuCO}_3 \cdot \text{Cu}(\text{OH})_2$, Cuprite Cu_2O , Chrysocolla $\text{CuO} \cdot \text{SiO}_2 \cdot 2\text{H}_2\text{O}$) may be used with the disclosed systems and methods.

In some embodiments, the atmospheric or substantially atmospheric metal sulfide leach may be maintained below a pH of about 1.3 (e.g., between a pH of about 1 and a pH of about

1.2). Those skilled in the art will know that certain phyllosilicates (e.g., montmorillonite) may be susceptible to rapid attack by strong acid. Accordingly, in instances where a bleed stream/slipstream containing an amount of such clays high enough to become problematic, it may be beneficial to maintain the pH of the leach liquor above about 1 (e.g., between about 1.5 and about 2.5). In some preferred embodiments, the atmospheric or substantially atmospheric metal sulfide leach may be maintained at a temperature which is below the melting point of elemental sulfur, in order to control frothing which might be caused by elemental sulfur. In some preferred embodiments, the atmospheric or substantially atmospheric metal sulfide leach may be maintained at a temperature which is not hot enough to disperse liquid elemental sulfur.

EXAMPLE 1

A preliminary, experimental test of the effect of recycling silicates for the benefit of reducing frothing and improving leach kinetics and copper recovery during the acid ferric sulfate leaching of chalcopyrite was conducted. The leach tests were conducted at 80°C under atmospheric pressure. The results of the test are shown in FIG. 5. For the purposes of illustration only, the silicates used in the leach tests were flotation rougher tailings. The rougher tailings material was comprised primarily of pyrite, orthoclase, muscovite, quartz, and albite. This is considered an extreme test of the inventive concept, as the material, by virtue of being a flotation tailings product, would contain residual amounts of flotation reagents (i.e., froth promoting agents) which could possibly hamper leaching. Those skilled in the art will appreciate from the appended drawings and this disclosure, that the silicates could have been alternatively or additionally obtained as a slip stream from the run-of-mine material prior to

entering the flotation circuit, thus avoiding any prior exposure to, or contamination by, surface-active froth flotation reagents.

If acid-sensitive clays are determined to be substantially present in the silicates added to a leach vessel 202 or high shear device 212, the use of high acid concentrations during the metal sulfide leaching can lead to dissolution of the clays. The dissolution of aluminosilicates can have a negative impact on metal recovery from a metal sulfide concentrate and acid control may be necessary to achieve metal recoveries of 95% or greater within about 6 hours, and preferably, under about 5 hours, and even more preferably, between about 2.5 hours and about 4 hours, without limitation.

EXAMPLE 2

A comparative test was conducted in which there was no addition of silicates to the leach feed. The leach data associated with no addition of silicates is depicted by the (Δ) symbols in FIG. 5. The P95 particle size distribution of the chalcopyrite concentrate was 35 μm and the test was conducted at 7.5 wt.% suspended solids. The addition of oxygen during the leach process resulted in the production of a large amount of highly mineralized, stable froth within the leach reactor. This resulted in the transfer of a significant amount of solids from the leach liquor to the froth, with the consequence of limiting the copper recovery to between 90-95% at 6 hours (e.g., ~94% at 6 hours as shown on the graph of FIG. 5).

Comparison of the comparative reference test data with the enabled results represented by the ($\circ$) symbols shows that the addition the silicates to the leach system increased the copper

leach rate significantly (i.e. the initial copper leach rate was approximately 1.83 times faster than the comparative test). In the particular leach test conducted, the volume of froth was also visually significantly less than in the comparative example, and 100% copper recovery was achieved within 6 hrs. The ratio of added silicate tailings to chalcopyrite concentrate was approximately 1.9 to 1.

EXAMPLE 3

A third copper leach test was conducted under identical conditions to the test outlined in Example 2, except that the chalcopyrite concentrate had a P95 of 104 μm . Again, frothing was significantly reduced in relation to the comparative test, and 100% copper recovery was achieved within 6 hours. The reduced frothing meant that the oxygen flow to the reactor could be continuously maintained at a higher rate with the result that the initial copper leach rate was approximately 1.98 times faster than the comparative example.

It should be known that the particular features, processes, and benefits which are shown and described herein in detail are purely exemplary in nature and should not limit the scope of the invention. Although the invention has been described in terms of particular embodiments and applications, one of ordinary skill in the art, in light of this teaching, can generate additional embodiments and modifications without departing from the spirit of or exceeding the scope of the claimed invention. For example, while the inventive concepts, features, and method steps described herein could be advantageously practiced in purely atmospheric leach processes, it is envisaged that the same may be practiced with substantially atmospheric leach circuits comprising equipment (e.g., an attrition scrubber) which may be slightly pressurized (e.g.,

between 0.01 bar and 10 bar, for example, pressurized around 1-7 bar). For example, and without limitation, the leach reactor 202 shown in FIG. 2 may comprise one or more open-top stirred tank reactors operating under ambient pressure, and the optional attrition scrubber (212) may comprise one or more enclosed stirred media reactors and/or one or more high-shear stirred reactors – each which may comprise oxygen input means and which may be configured to be pressurized (e.g., pressurized to approximately 5 bar) so as to increase oxygen partial pressure therein. In such embodiments, a substantially atmospheric leach circuit may comprise a flowsheet wherein greater than approximately 90% of the residence time of a metal sulfide leach particle occurs in an atmospheric leach reactor 202 (e.g., an open conventional stirred tank reactor) and approximately 10% or less of the residence time of the same metal sulfide leach particle occurs in an above-atmospheric attrition scrubber 212 (e.g., an enclosed stirred media reactor or high shear stirred reactor configured with oxygen introduction means), without limitation.

Accordingly, it is to be understood that the drawings and descriptions herein are offered by way of example to facilitate comprehension of the invention and should not be construed to limit the scope thereof.

CLAIMS

What is claimed is:

1. A method of controlling frothing during atmospheric or substantially atmospheric leaching of a metal sulfide, the method comprising:
 - (a) producing a metal sulfide concentrate via flotation;
 - (b) producing a tailings stream via flotation; and,
 - (c) diverting a portion of said produced tailings stream to an atmospheric or substantially atmospheric sulfide leach circuit being fed with said metal sulfide concentrate; wherein the atmospheric or substantially atmospheric sulfide leach circuit is maintained at a temperature which is below the melting point of elemental sulfur (S^0).
2. The method of claim 1, wherein the step of diverting a portion of said produced tailings stream to an atmospheric or substantially atmospheric sulfide leach circuit comprises the step of dosing at least one leach reactor and/or at least one attrition scrubber provided within the atmospheric or substantially atmospheric sulfide leach circuit.
3. The method of claim 2, wherein the tailings stream comprises one or more of the following: quartz, aluminosilicates, phyllosilicates (including chlorite, kaolinite, montmorillonite, palygorskite, talc, vermiculite), micas (including biotite, muscovite, phlogopite), feldspars, zeolites, diatomaceous earth, and various combinations thereof.

4. The method of claim 1, further comprising the step of:

(d) reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit, without adversely affecting metal recovery from the metal sulfide concentrate.

5. The method of claim 4, wherein the step of reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit comprises a leach time of less than 5 hours to accomplish a greater than 95% recovery of a metal from the metal sulfide concentrate.

6. The method of claim 5, wherein the step of reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit comprises a leach time between 2.5 and 4 hours to accomplish a greater than 95% recovery of a metal from the metal sulfide concentrate.

7. A metal recovery flowsheet comprising a unit operation comprising:

(a) a sulfide concentrator comprising a flotation circuit, the flotation circuit producing a metal sulfide concentrate stream, and a tailings stream; and,

(b) an atmospheric or substantially atmospheric metal sulfide leach circuit operated at a temperature below the melting point of elemental sulfur (S^0);

wherein the sulfide concentrator is operatively connected to the atmospheric or substantially atmospheric metal sulfide leach circuit via both of said metal sulfide concentrate stream, and said tailings stream; and

wherein the tailings stream is provided as a froth mitigant.

8. A metal recovery flowsheet of claim 7, wherein the atmospheric or substantially atmospheric metal sulfide leach circuit comprises one or more leach reactors, and silicates contained within said tailings stream are provided to the one or more leach reactors.

9. A metal recovery flowsheet of claim 8, wherein the atmospheric or substantially atmospheric metal sulfide leach circuit comprises one or more attrition scrubbers, and silicates contained within said tailings stream are provided to the one or more attrition scrubbers.

10. A metal recovery flowsheet of claim 9, wherein the one or more attrition scrubbers are provided in series with said one or more leach reactors.

11. A metal recovery flowsheet of claim 9, wherein the one or more attrition scrubbers are provided in parallel with said one or more leach reactors.

12. A metal recovery flowsheet of claim 9, wherein at least one attrition scrubber is shared by at least two leach reactors.

13. A metal recovery flowsheet of claim 8, wherein said silicates contained within said tailings stream comprises one or more of the following: quartz, aluminosilicates, phyllosilicates (including chlorite, kaolinite, montmorillonite, palygorskite, talc, vermiculite), micas (including biotite, muscovite, phlogopite), feldspars, zeolites, diatomaceous earth, and various combinations thereof.

14. A method of controlling frothing during atmospheric or substantially atmospheric leaching of a metal sulfide, the method comprising:

- (a) producing a metal sulfide concentrate via flotation;
- (b) producing a stream of run-of-mine (ROM) material; and,
- (c) diverting a portion of said stream of run-of-mine (ROM) material to an atmospheric or substantially atmospheric sulfide leach circuit being fed with said metal sulfide concentrate.

15. The method of claim 14, wherein the step of diverting a portion of said stream of run-of-mine (ROM) material to an atmospheric or substantially atmospheric sulfide leach circuit to an atmospheric or substantially atmospheric sulfide leach circuit comprises the step of dosing at least one leach reactor and/or at least one attrition scrubber provided within the atmospheric or substantially atmospheric sulfide leach circuit.

16. The method of claim 15, wherein the stream of run-of-mine (ROM) material comprises one or more of the following: quartz, aluminosilicates, phyllosilicates (including chlorite, kaolinite, montmorillonite, palygorskite, talc, vermiculite), micas (including biotite, muscovite, phlogopite), feldspars, zeolites, diatomaceous earth, and various combinations thereof.

17. The method of claim 14, further comprising the step of:

- (d) reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit, without adversely affecting metal recovery from the metal sulfide concentrate.

18. The method of claim 17, wherein the step of reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit comprises a

leach time of less than 5 hours to accomplish a greater than 95% recovery of a metal from the metal sulfide concentrate.

19. The method of claim 18, wherein the step of reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit comprises a leach time between 2.5 and 4 hours to accomplish a greater than 95% recovery of a metal from the metal sulfide concentrate.

20. The method of claim 14, further comprising grinding or screening the run-of-mine (ROM) material prior to step (c).

21. A method of controlling frothing during atmospheric or substantially atmospheric leaching of a metal sulfide, the method comprising:

- (a) producing a metal sulfide concentrate via flotation;
- (b) producing a stream of run-of-mine (ROM) material;
- (c) grinding the stream of run-of-mine (ROM) material with a mill to produce a stream of ground run-of-mine (ROM) material; and,
- (d) diverting a portion of said stream of ground run-of-mine (ROM) material to an atmospheric or substantially atmospheric sulfide leach circuit being fed with said metal sulfide concentrate.

22. The method of claim 21, wherein the step of diverting a portion of said stream of ground run-of-mine (ROM) material to an atmospheric or substantially atmospheric sulfide leach circuit

to an atmospheric or substantially atmospheric sulfide leach circuit comprises the step of dosing at least one leach reactor and/or at least one attrition scrubber provided within the atmospheric or substantially atmospheric sulfide leach circuit.

23. The method of claim 22, wherein the stream of ground run-of-mine (ROM) material comprises one or more of the following: quartz, aluminosilicates, phyllosilicates (including chlorite, kaolinite, montmorillonite, palygorskite, talc, vermiculite), micas (including biotite, muscovite, phlogopite), feldspars, zeolites, diatomaceous earth, and various combinations thereof.

24. The method of claim 21, further comprising the step of:

(e) reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit.

25. The method of claim 24, wherein the step of reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit comprises a leach time of less than 5 hours to accomplish a greater than 95% recovery of a metal from the metal sulfide concentrate.

26. The method of claim 25, wherein the step of reducing a leach time of said metal sulfide concentrate in the atmospheric or substantially atmospheric sulfide leach circuit comprises a leach time between 2.5 and 4 hours to accomplish a greater than 95% recovery of a metal from the metal sulfide concentrate.

27. The method of claim 21, further comprising (e) screening the stream of ground run-of-mine (ROM) material prior to step (d).

28. A metal recovery flowsheet comprising a unit operation comprising:

(a) a sulfide concentrator comprising a flotation circuit, the flotation circuit producing a metal sulfide concentrate stream;

(b) at least one of: a stream of run-of-mine (ROM) material originating from a mine site, and a stream of ground run-of-mine (ROM) material originating from a grinding circuit of a sulfide concentrator; and,

(c) an atmospheric or substantially atmospheric metal sulfide leach circuit;

wherein the atmospheric or substantially atmospheric metal sulfide leach circuit is operatively connected to said at least one of a stream of run-of-mine (ROM) material originating from a mine site, and a stream of ground run-of-mine (ROM) material originating from a grinding circuit of a sulfide concentrator.

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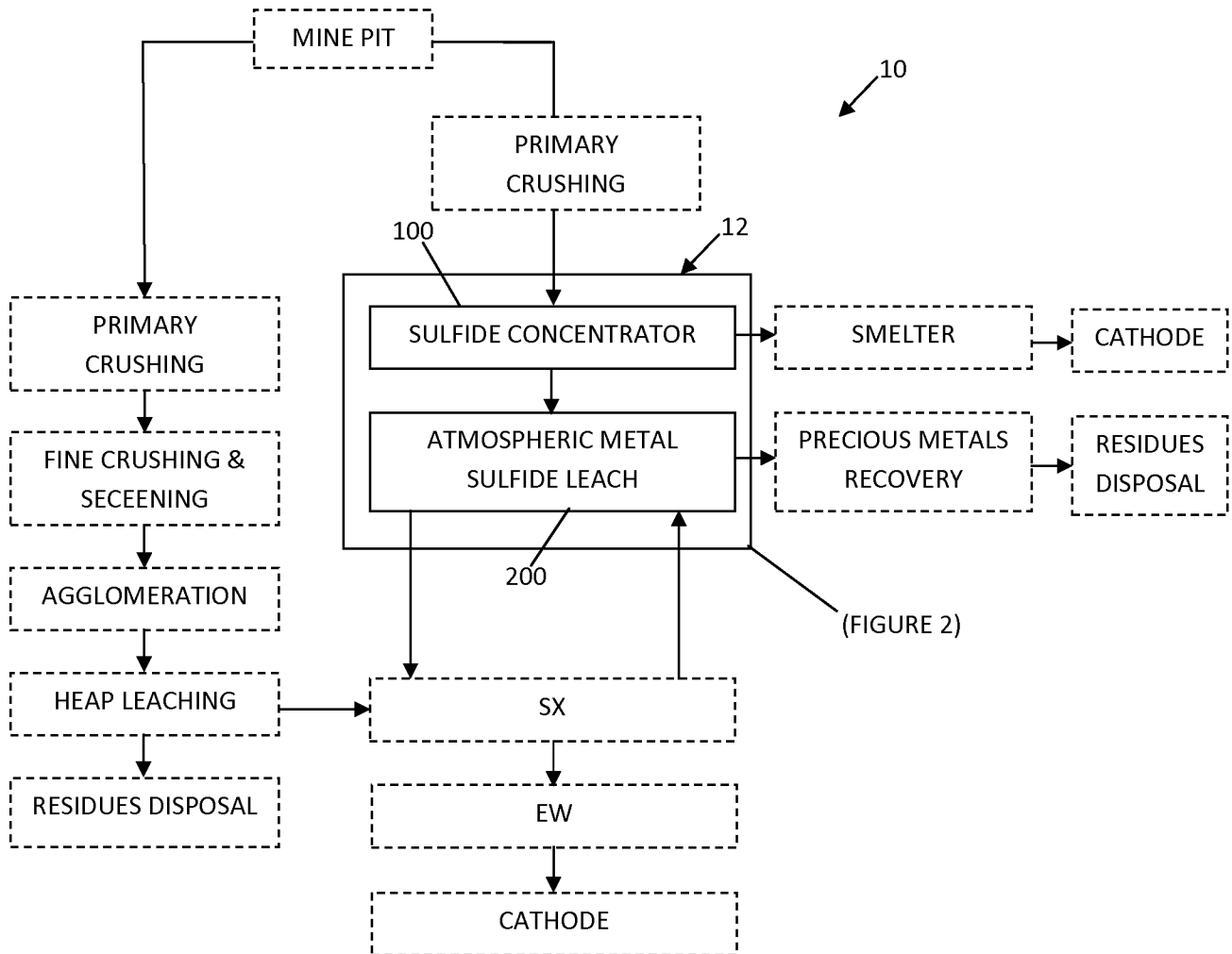


FIGURE 1

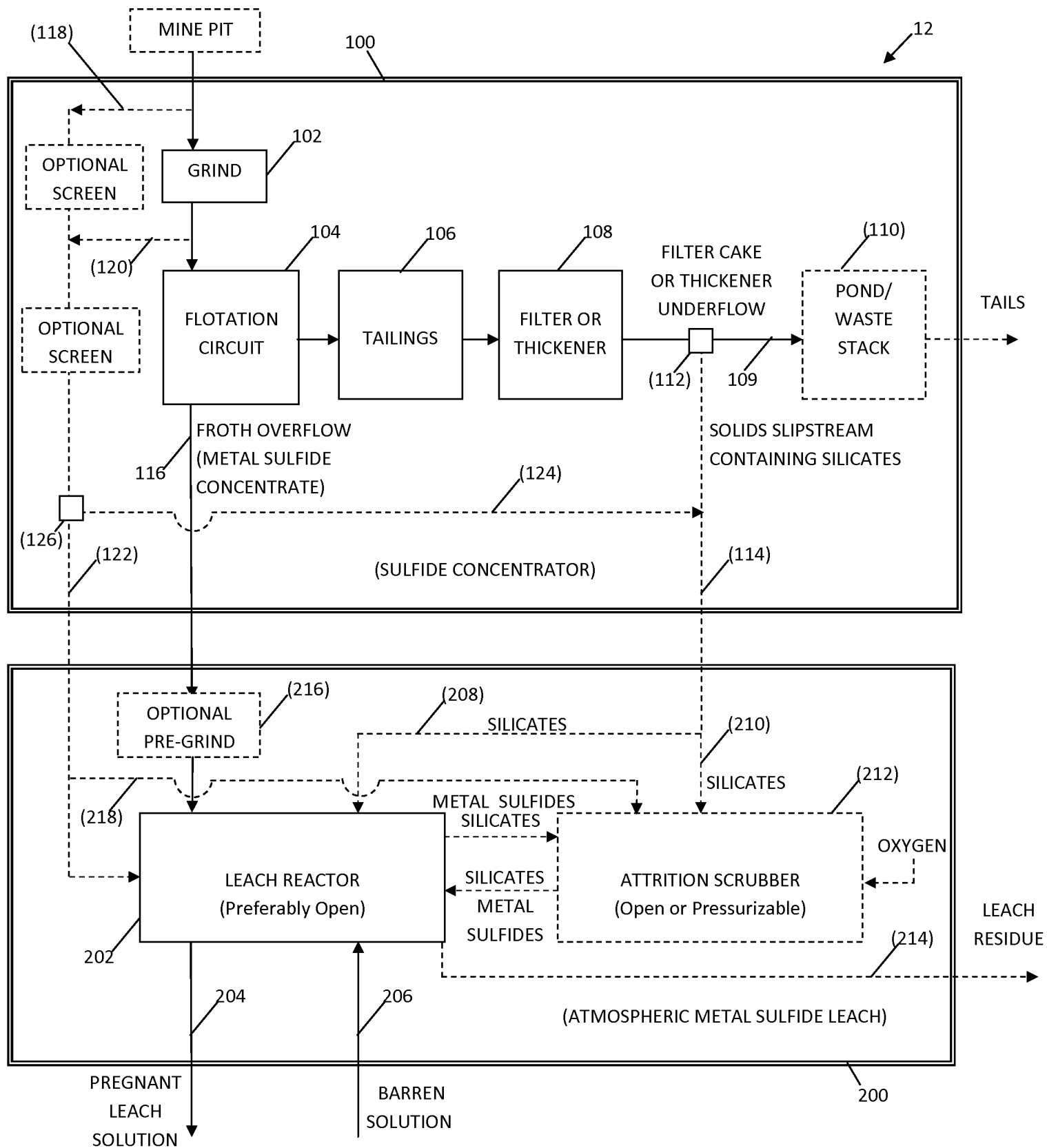


FIGURE 2

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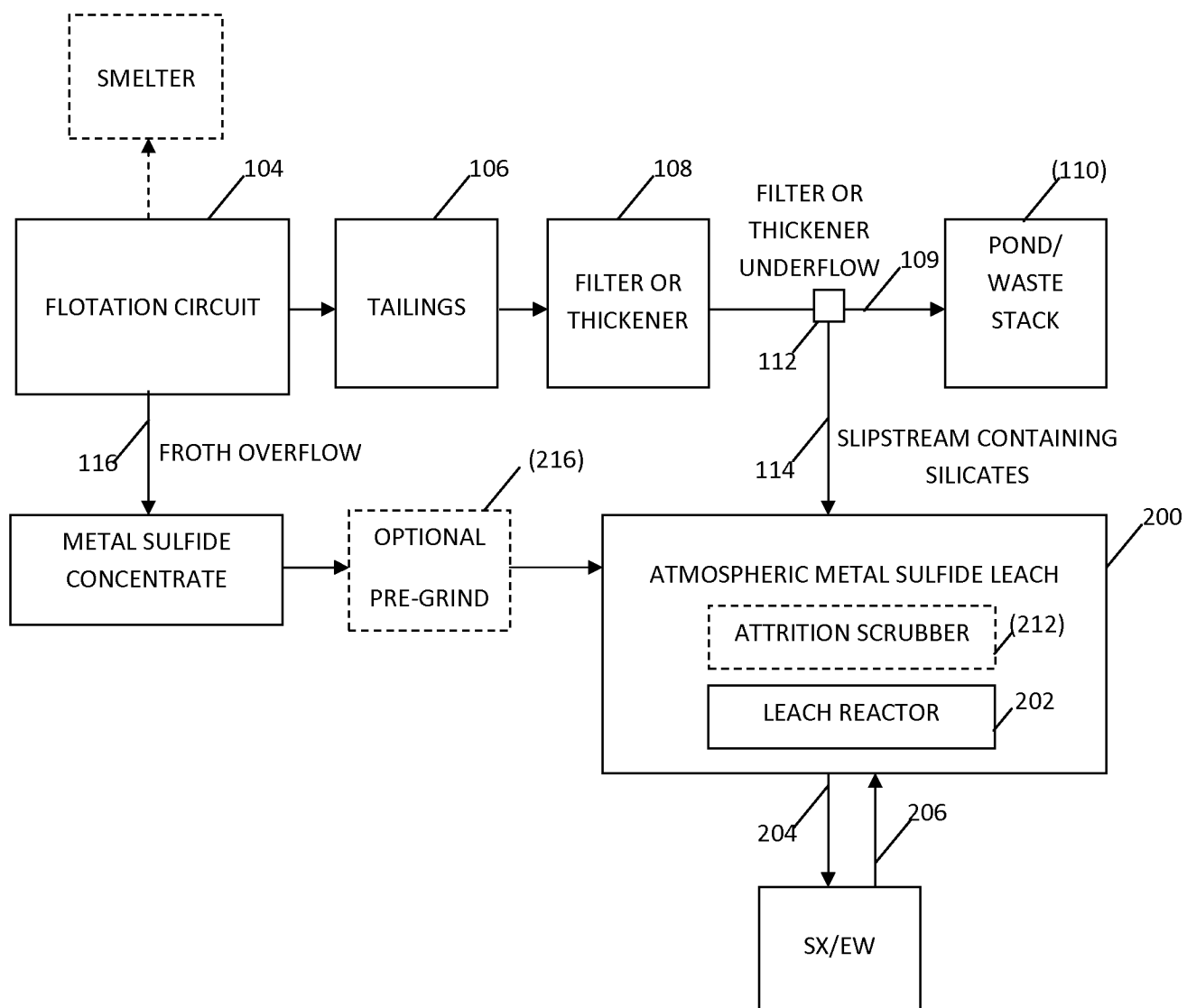


FIGURE 3

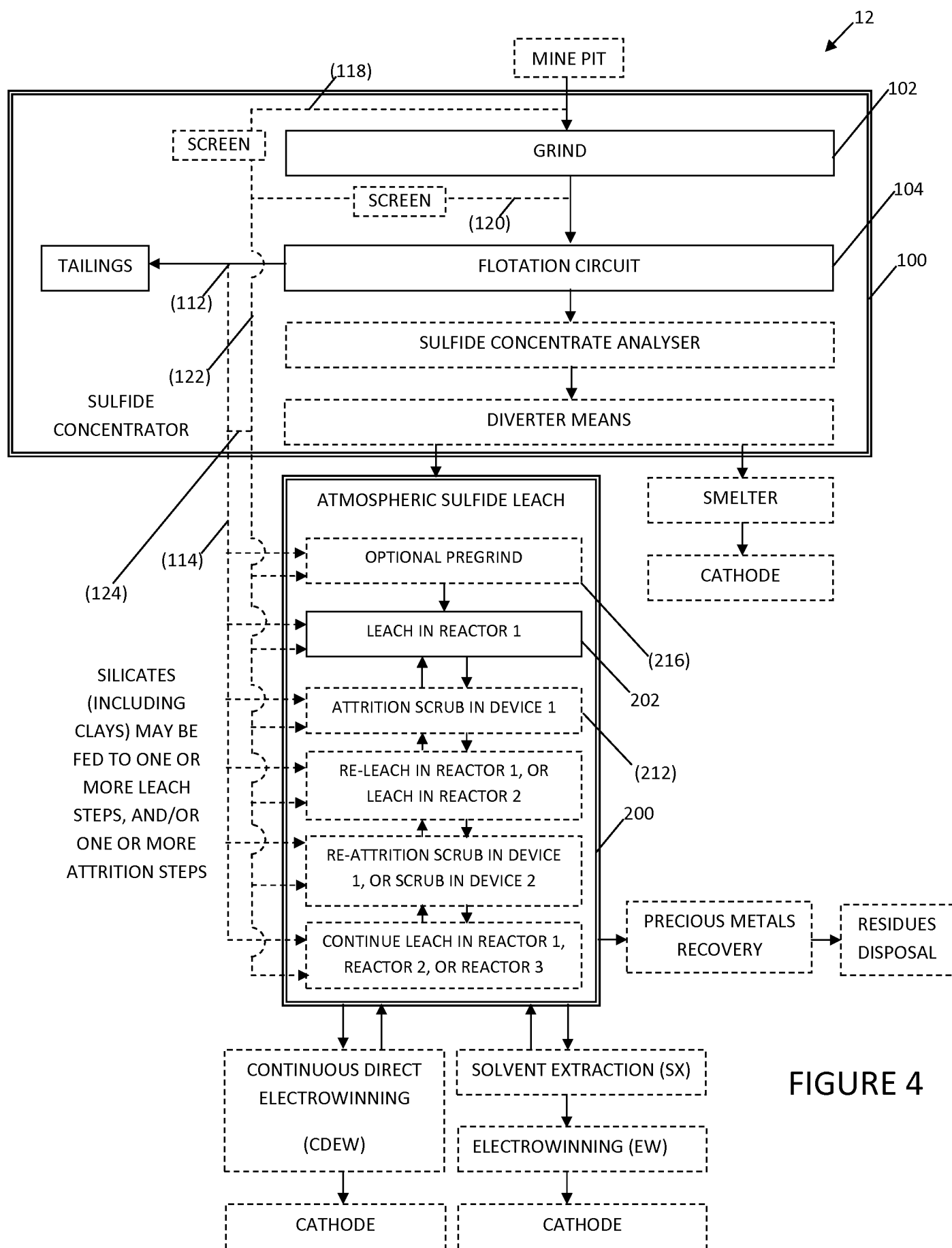


FIGURE 4

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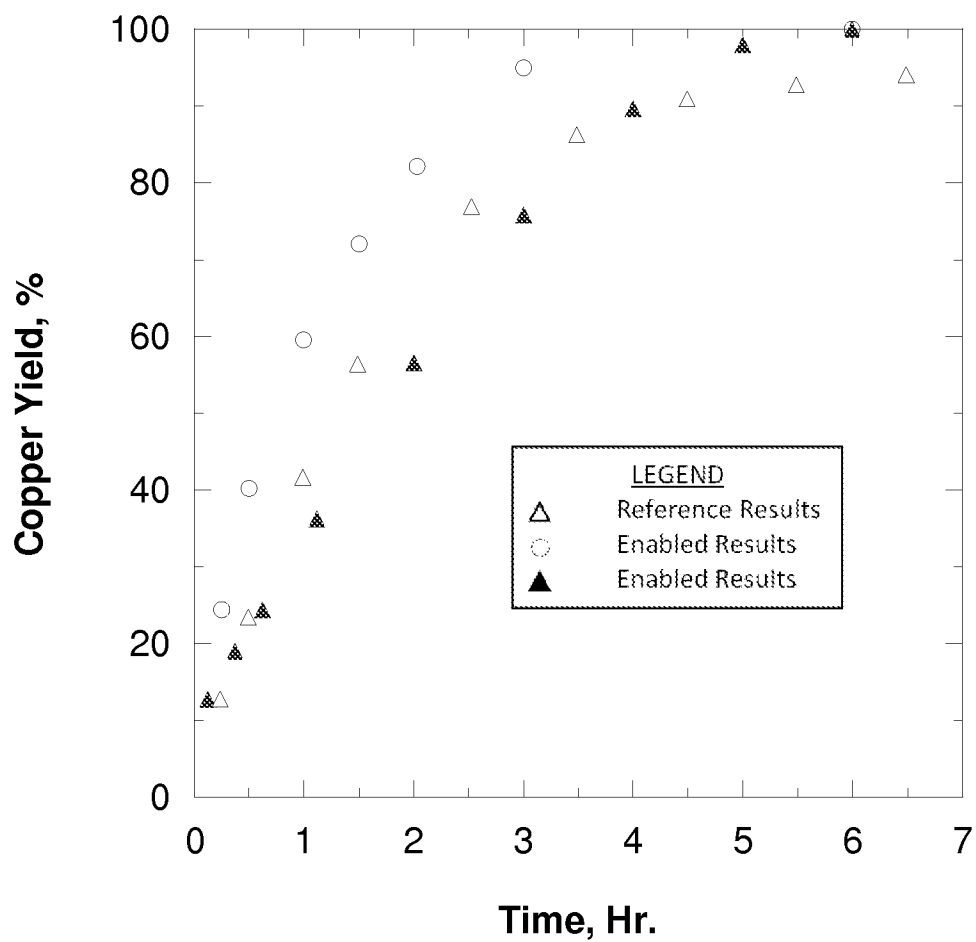


FIGURE 5

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 15/47259

A. CLASSIFICATION OF SUBJECT MATTER

IPC(8) - C01B 17/20, C22B 1/11, C22B 3/08, C22B 5/08, F17D 3/01 (2015.01)

CPC - C01B 17/0226, C01B 17/20, C22B 1/11, C22B 3/08, C22B 5/08, F17D 3/01

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC(8)- C01B 17/20, C22B 1/11, C22B 3/08, C22B 5/08, F17D 3/01 (2015.01);

CPC- C01B 17/0226, C01B 17/20, C22B 1/11, C22B 3/08, C22B 5/08, F17D 3/01

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched
USPC- 75/743, 75/746, 75/753, 210/121, 210/456, 210/702, 210/738, 423/24, 423/33, 423/48, 423/578.2;
Patents and NPL (classification, keyword; search terms below)

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)
Pub West (US EP JP WO), Pat Base (AU BE BR CA CH CN DE DK EP ES FI FR GB IN JP KR SE TH TW US WO), Google Patent, Google Scholar, Free Patents Online; search terms: run, mine, tailings, effluent, byproduct, extract, sulfide, sulphide, float, floc, flocculate, froth, leach, divert, circuit, atmospheric

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 2009/0071296 A1 (HILLIER et al.) 19 March 2009 (19.03.2009), Figs. 1A, 1B; para [0043], [0056], [0057]	1-6
A	US 2005/0045528 A1 (SIMMONS et al.) 03 March 2005 (03.03.2005), Fig. 3; para [0014], [0019], [0042], [0043]	1-6
A	US 5,993,635 A (HOURN et al.) 30 November 1999 (30.11.1999), col 3, ln 46 to col 12, ln 10	1-6
A	US 5,316,567 A (JONES) 31 May 1994 (31.05.1994), Fig. 3; col 16, ln 44-58; col 15, ln 20-27	1-6
A	US 2,471,384 A (BOOTH et al.) 16 May 1946 (16.05.1946), col 5, ln 1-13	1-6

☐ Further documents are listed in the continuation of Box C.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

10 December 2015

Date of mailing of the international search report

06 JAN 2016

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Authorized officer:

Lee W. Young

PCT Helpdesk: 571-272-4300

PCT OSP: 571-272-7774

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 15/47259

Box No. II Observations where certain claims were found unsearchable (Continuation of item 2 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:

2. ☐ Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:

3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box No. III Observations where unity of invention is lacking (Continuation of item 3 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:
This application contains the following inventions or groups of inventions which are not so linked as to form a single general inventive concept under PCT Rule 13.1. In order for all inventions to be examined, the appropriate additional examination fees must be paid.

Group I: Claims 1-6, drawn to a method of controlling frothing during atmospheric or substantially atmospheric leaching of a metal sulfide with tailings.

Group II: Claims 7-13 and 28, drawn to metal recovery flowsheets comprising a unit operation.

Group III: Claims 14-27, drawn to methods of controlling frothing during atmospheric or substantially atmospheric leaching of a metal sulfide with run-of-mine (ROM) material.

-- Please See Supplemental Box --

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying additional fees, this Authority did not invite payment of additional fees.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:

4. ☒ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:
1-6

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest and, where applicable, the payment of a protest fee.
- ☐ The additional search fees were accompanied by the applicant's protest but the applicable protest fee was not paid within the time limit specified in the invitation.
- ☐ No protest accompanied the payment of additional search fees.

Continued from Box No. III, Observations where unity of invention is lacking.

Special Technical Features

The inventions listed as Groups I, II, and III do not relate to a single general inventive concept under PCT Rule 13.1 because, under PCT Rule 13.2, they lack the same or corresponding special technical features for the following reasons:

Groups II and III do not require a method of controlling frothing during atmospheric or substantially atmospheric leaching of a metal sulfide, the method comprising: (b) producing a tailings stream via flotation; and (c) diverting a portion of said produced tailings stream, as required by Group I.

Groups I and III do not require a metal recovery flowsheet comprising a unit operation comprising:

(a) a sulfide concentrator comprising a flotation circuit, the flotation circuit producing a metal sulfide concentrate stream, and a tailings stream; wherein the sulfide concentrator is operatively connected; and wherein the tailings stream is provided as a froth mitigant; or a metal recovery flowsheet comprising a unit operation comprising: (a) a sulfide concentrator comprising a flotation circuit; (b) at least one of: a stream of run-of-mine (ROM) material originating from a mine site, and a stream of ground run-of-mine (ROM) material originating from a grinding circuit of a sulfide concentrator; and, (c) an atmospheric or substantially atmospheric metal sulfide leach circuit; wherein the atmospheric or substantially atmospheric metal sulfide leach circuit is operatively connected to said at least one of a stream of run-of-mine (ROM) material originating from a mine site, and a stream of ground run-of-mine (ROM) material originating from a grinding circuit of a sulfide concentrator, as required by Group II.

Groups I and II do not require a method of controlling frothing during atmospheric or substantially atmospheric leaching of a metal sulfide, the method comprising: (b) producing a stream of run-of-mine (ROM) material; (c) grinding the stream of run-of-mine (ROM) material with a mill to produce a stream of ground run-of-mine (ROM) material; and, (d) diverting a portion of said stream of ground run-of-mine (ROM) material, as required by Group III.

Shared Common Features

The only feature shared by Groups I, II, and III that would otherwise unify the groups is a metal sulfide concentrate via flotation; an atmospheric or substantially atmospheric sulfide leach circuit being fed with said metal sulfide concentrate. However, this shared technical feature does not represent a contribution over prior art, because the shared technical feature is anticipated by US 2003/0033906 A1 to Kerfoot (hereinafter 'Kerfoot'). Kerfoot discloses a metal sulfide concentrate via flotation (para [0015]); and an atmospheric or substantially atmospheric sulfide leach circuit being fed with said metal sulfide concentrate (para [0015], [0020]).

The only feature shared by Groups I and III that would otherwise unify the groups is the diverting a portion of said stream. However, this shared technical feature does not represent a contribution over prior art, because the shared technical feature is anticipated by Kerfoot. Kerfoot discloses diverting a portion of said stream (Fig. 1; para [0033], from nickel electrowinning, a stream comprising oxygen + chlorine and another stream comprising solution bleed from Ni Anolyte.).

The only feature shared by Groups I and II that would otherwise unify the groups is a leach circuit is maintained/operated at a temperature which is below the melting point of elemental sulfur; and a tailings stream. However, this shared technical feature does not represent a contribution over prior art, because the shared technical feature is anticipated by Kerfoot. Kerfoot discloses a leach circuit is maintained/operated at a temperature which is below the melting point of elemental sulfur (S_{sup.o}) (para [0006], [0033], leaching at a temperature of 40 to 90 degrees Centigrade... wherein the melting temperature is above 150 degrees Centigrade.); and a tailings stream (Fig. 2; para [0033], "leach residue," "copper byproduct," and "waste solution.").

The only feature shared by Groups II and III that would otherwise unify the groups is a stream of run-of-mine (ROM) material; and diverting a portion of said stream of ground run-of-mine (ROM) material. However, this shared technical feature does not represent a contribution over prior art, because the shared technical feature is anticipated by US 5,316,751 A Kingsley, et al. (hereinafter 'Kingsley'). Kingsley discloses a stream of run-of-mine (ROM) material (col 1, ln 64 to col 2, ln 12, complex sulfide mine tailings.; Claim 1) diverting a portion of said stream of ground run-of-mine (ROM) material (col 4, ln 10-28; heavies from mesh are ground in bar mill, 28, and returned to wash basin for classification... overflow from screen and discharge water piped to a thickener or decanting pond, 29.).

As the technical features were known in the art at the time of the invention, this cannot be considered a special technical feature that would otherwise unify the groups.

Groups I, II, and III therefore lack unity under PCT Rule 13 because they do not share a same or corresponding special technical feature.