



(86) Date de dépôt PCT/PCT Filing Date: 2011/05/31
(87) Date publication PCT/PCT Publication Date: 2011/12/08
(45) Date de délivrance/Issue Date: 2015/12/08
(85) Entrée phase nationale/National Entry: 2012/11/28
(86) N° demande PCT/PCT Application No.: JP 2011/062868
(87) N° publication PCT/PCT Publication No.: 2011/152548
(30) Priorité/Priority: 2010/05/31 (JP2010-125392)

(51) Cl.Int./Int.Cl. *B01D 53/62* (2006.01),
B01D 53/14 (2006.01), *B01D 53/50* (2006.01),
B01D 53/77 (2006.01), *B01D 53/81* (2006.01),
B03C 3/16 (2006.01), *C01B 31/20* (2006.01)

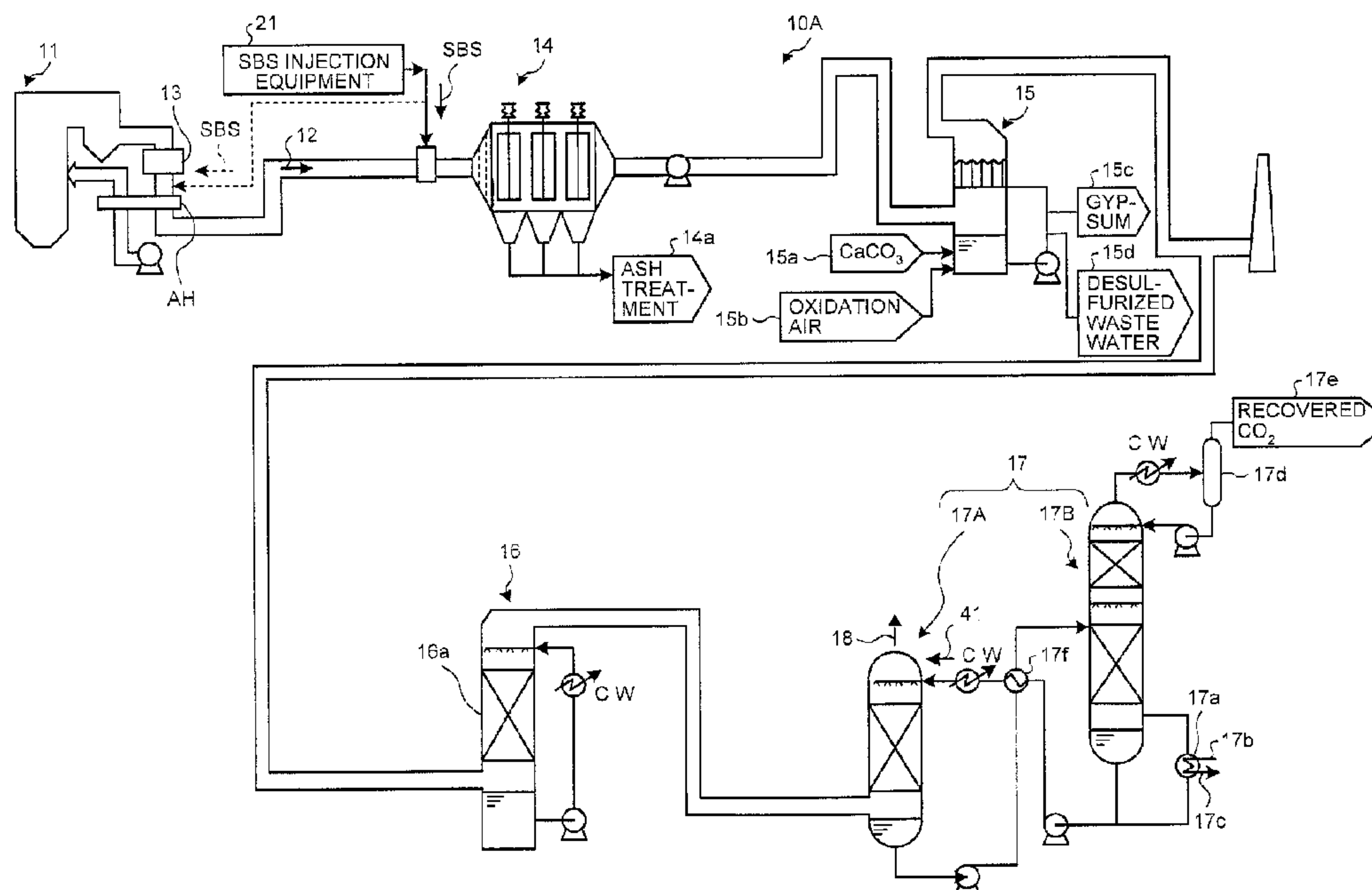
(72) Inventeurs/Inventors:
NAGAYASU, TATSUTO, JP;
KAMIJO, TAKASHI, JP;
INUI, MASAYUKI, JP;
OISHI, TSUYOSHI, JP;
NAGAYASU, HIROMITSU, JP;
...

(73) Propriétaire/Owner:
MITSUBISHI HEAVY INDUSTRIES, LTD., JP

(74) Agent: SMART & BIGGAR

(54) Titre : SYSTEME ET METHODE DE REDUCTION DE LA POLLUTION ATMOSPHERIQUE

(54) Title: AIR POLLUTION CONTROL SYSTEM AND METHOD



(57) Abrégé/Abstract:

SO_x removal equipment (15) for reducing sulfur oxides from flue gas (12) from a boiler (11), a cooler (16) which is provided on a downstream side of the SO_x removal equipment (15), for reducing the sulfur oxides that remain in the flue gas (12) and for decreasing a gas temperature, CO₂ recovery equipment (17) which includes a CO₂ absorber (17A), and an absorption liquid regenerator (17B), and mist generation material reduction equipment (20) for reducing a mist generation material which is a generation source of mist that is generated in the CO₂ absorber of the CO₂ recovery equipment (17) before introducing the flue gas (12) to the CO₂ recovery equipment (17) are included.



(72) **Inventeurs(suite)/Inventors(continued):** TANAKA, HIROSHI, JP; HIRATA, TAKUYA, JP; TSUJIUCHI, TATSUYA, JP; OKINO, SUSUMU, JP; KAMIYAMA, NAOYUKI, JP; YOSHIHARA, SEIJI, JP

53609-46

ABSTRACT

SO_x removal equipment (15) for reducing sulfur oxides from flue gas (12) from a boiler (11), a cooler (16) which is provided on a downstream side of the SO_x removal equipment (15), for reducing the sulfur oxides that remain in the flue gas (12) and for decreasing a gas temperature, CO₂ recovery equipment (17) which includes a CO₂ absorber (17A), and an absorption liquid regenerator (17B), and mist generation material reduction equipment (20) for reducing a mist generation material which is a generation source of mist that is generated in the CO₂ absorber of the CO₂ recovery equipment (17) before introducing the flue gas (12) to the CO₂ recovery equipment (17) are included.

DESCRIPTION

AIR POLLUTION CONTROL SYSTEM AND METHOD

Field

[0001] The present invention relates to an air pollution
5 control system and method that reduce CO₂ from flue gas.

Background

[0002] In recent years, the greenhouse effect due to CO₂
is indicated as one of causes of the global warming
phenomenon, and the countermeasures thereof become an
10 internationally urgent matter to protect the global
environment. CO₂ generation sources reach all human
activity fields in which fossil fuels are burned, and there
is a tendency to further strengthen the demand for
suppression of the discharge thereof. For this, for a
15 power generation facility such as a thermal power plant
that uses a large amount of fossil fuels, a method of
bringing combustion flue gas of an industrial facility such
as a boiler or a gas turbine into contact with an amine-
based CO₂ absorption liquid to reduce and recover CO₂ from
20 the combustion flue gas and an air pollution control system
which stores the recovered CO₂ without emission to air has
been energetically researched.

[0003] CO₂ recovery equipment which has, as the process
of reducing and recovering CO₂ from the combustion flue gas
25 using a CO₂ absorption liquid as described above, a process
of bringing the combustion flue gas into contact with the
CO₂ absorption liquid in a CO₂ absorber (hereinafter, also
simply referred to as "absorber"), and a process of heating
the CO₂ absorption liquid that absorbs CO₂ in an absorption
30 liquid regenerator (hereinafter, also simply referred to as
"regenerator") to emit CO₂ and regenerate the CO₂
absorption liquid so as to be circulated through the CO₂
absorber to be reused, is proposed (for example, Patent

53609-46

2

Literature 1).

[0004] In the CO₂ absorber, through countercurrent contact using an amine-based CO₂ absorption liquid such as alkanolamine, CO₂ in the flue gas is absorbed by the CO₂ absorption liquid in a chemical reaction (exothermic reaction), and the flue gas from which CO₂ is reduced is emitted to the outside of the system. The CO₂ absorption liquid that absorbs CO₂ is also called a "rich solution". The rich solution is pressurized by a pump, is heated in a heat exchanger by a high-temperature CO₂ absorption liquid (lean solution) regenerated as CO₂ is emitted in the regenerator, and is supplied to the regenerator.

Citation List

Patent Literature

15 [0005] Patent Literature 1: Japanese Laid-open Patent Publication No. 3-193116

Summary

[0006] However, in the air pollution control system, in a case where a mist generation material that is a generation source of mist generated in the absorber of the CO₂ recovery equipment is included in the flue gas introduced to the CO₂ absorber that absorbs CO₂ in the CO₂ recovery equipment, there is a problem in that the CO₂ absorption liquid is entrained by the mist generation material and thus the amount of CO₂ absorption liquid that scatters to the outside of the system is increased.

Such a case, where the scattering of the CO₂ absorption liquid to the outside of the system occurs, is connected to a significant loss of the CO₂ absorption liquid, and an unnecessary amount of the CO₂ absorption liquid has to be replenished. Therefore, the scattering of the CO₂ absorption liquid to the outside of the system

53609-46

3

needs to be suppressed.

[0007] Here, the establishment of an air pollution control system which suppresses the scattering of a CO₂ absorption liquid from a CO₂ absorber is desired.

5 [0008] In order to solve the problem, some embodiments of the present disclosure may provide an air pollution control system and method capable of significantly reducing entraining of a CO₂ absorption liquid when flue gas from which CO₂ is reduced is discharged to the outside of a system, and performing an
10 appropriate air pollution control.

[0009] According to a first aspect of the present invention, there is provided an air pollution control system including: SO_x removal equipment for reducing sulfur oxides from flue gas from a boiler; a cooler which is provided on a downstream side of the SO_x
15 removal equipment for reducing the sulfur oxides that remain in the flue gas and for decreasing a gas temperature; CO₂ recovery equipment including a CO₂ absorber for bringing CO₂ in the flue gas into contact with a CO₂ absorption liquid so as to be reduced, and an absorption liquid regenerator for causing the CO₂
20 absorption liquid to emit CO₂ so as to recover CO₂ and regenerate the CO₂ absorption liquid; and mist generation material reduction equipment for reducing a mist generation material which is a generation source of mist that is generated in the CO₂ absorber of the CO₂ recovery equipment before introducing the flue gas to the
25 CO₂ recovery equipment.

[0010] In some embodiments, according to a second aspect, there is provided the air pollution control system according to the first aspect, further including: NO_x removal equipment which reduces nitrogen oxides from the flue gas; and a dry type
30 electric dust collector which reduces particulates.

53609-46

4

[0011] In some embodiments, according to a third aspect, there is provided the air pollution control system according to the second aspect, wherein the mist generation material reduction equipment is a sodium bisulfite injection equipment which injects sodium bisulfite between the NO_x removal equipment and the electric dust collector for reducing the mist generation material in a gas state from the flue gas.

[0012] In some embodiments, according to a fourth aspect, there is provided the air pollution control system according to the second aspect, wherein the mist generation material reduction equipment is an ammonia injection equipment which injects ammonia to an upstream side of the electric dust collector for reducing the mist generation material in a gas state from the flue gas.

[0013] In some embodiments, according to a fifth aspect, there is provided the air pollution control system according to the second aspect, wherein the mist generation material reduction equipment is a dissolved salt spraying equipment which sprays a dissolved salt between the electric dust collector and the SO_x removal equipment for reducing the mist generation material in a gas state from the flue gas.

[0014] In some embodiments, according to a sixth aspect, there is provided the air pollution control system according to the first or second aspect, wherein the mist generation material reduction equipment is a wet type electric dust collector which is provided on any of an upstream side and a downstream side of the cooler for reducing particulates that remain in the flue gas and reducing the mist generation material in a mist state from the flue gas.

53609-46

5

[0015] In some embodiments, according to a seventh aspect, there is provided the air pollution control system according to the first or second aspect, wherein the mist generation material reduction equipment is a wet type electric dust collector-

5 integrated cooler which has a wet type electric dust collection unit for reducing particulates that remain in the flue gas therein so as to reduce the mist generation material in a mist state from the flue gas.

[0016] In some embodiments, according to an eighth aspect,

10 there is provided the air pollution control system according to the first or second aspect, wherein the mist generation material reduction equipment is a demister which is provided at a top portion of the cooler to reduce particulates that remain in the flue gas therein and reduce the mist generation material in a
15 mist state from the flue gas.

[0017] In some embodiments, according to a ninth aspect, there is provided the air pollution control system according to the first or second aspect, wherein the mist generation material reduction equipment includes a first heat exchanger which is

20 provided on an upstream side of the SO_x removal equipment to decrease a temperature of the flue gas and calcium carbonate spraying equipment which sprays calcium carbonate between the first heat exchanger and the electric dust collector for converting the mist generation material in the flue gas from a
25 gas state to a mist state and neutralizing the mist generation material in the mist state using calcium carbonate so as to be reduced.

[0018] In some embodiments, according to a tenth aspect, there is provided the air pollution control system according to the

30 second aspect, wherein the mist generation material reduction equipment includes a second heat exchanger which is provided on an upstream side of the electric dust collector to decrease a temperature of the flue gas for converting the mist generation

53609-46

6

material in the flue gas from a gas state to a mist state and causing the mist generation material in the mist state to adhere to the particulates so as to be reduced by the dry type electric dust collector.

- 5 [0019] According to another aspect of the present invention, there is provided an air pollution control method including: on an upstream side of CO₂ recovery equipment for bringing CO₂ in flue gas into contact with a CO₂ absorption liquid so as to be absorbed and reduced,
- 10 reducing a mist generation material in any of a gas state and a mist state from the flue gas generated in a boiler; and decreasing an amount of the mist generation material in the flue gas introduced to the CO₂ recovery equipment to a predetermined amount or less.
- 15 [0020] According to the air pollution control system of some embodiments, since the mist generation material reduction equipment is provided before the introduction to the CO₂ recovery equipment, the amount of mist generation material in the flue gas when being introduced to the CO₂ absorber is
- 20 significantly decreased. As a result, the amount of CO₂ absorption liquid that is entrained by mist and scatters to the outside of the system is decreased. Therefore, the loss of the CO₂ absorption liquid that scatters to the outside of the system may be significantly decreased, and an increase in
- 25 running cost during the air pollution control may be suppressed.

53609-46

6a

[0020a] According to one aspect of the present invention, there is provided an air pollution control system comprising: SO_x removal equipment for reducing sulfur oxides from flue gas from a boiler; a cooler which is provided on a downstream side of the SO_x removal equipment, for reducing the sulfur oxides that remain in the flue gas and decrease a gas temperature; CO₂ recovery equipment including: a CO₂ absorber for bringing CO₂ in the flue gas into contact with a CO₂ absorption liquid so as to be reduced, and an absorption liquid regenerator for causing the CO₂ absorption liquid to emit CO₂ so as to recover CO₂ and regenerate the CO₂ absorption liquid; mist generation material reduction equipment which reduces a mist generation material which is a generation source of mist that is generated in the CO₂ absorber of the CO₂ recovery equipment before introducing the flue gas to the CO₂ recovery equipment; NO_x removal equipment for reducing nitrogen oxides from the flue gas; and a dry type electric dust collector for reducing particulates, wherein the mist generation material reduction equipment is a sodium bisulfite injection equipment for injecting sodium bisulfite between the NO_x removal equipment and the electric dust collector so as to reduce SO₃ as the mist generation material in a gas state from the flue gas.

[0020b] According to another aspect of the present invention, there is provided an air pollution control method comprising: on an upstream side of CO₂ recovery equipment which brings CO₂ in flue gas into contact with a CO₂ absorption liquid so as to be absorbed and reduced, injecting sodium bisulfite into the flue gas generated from a boiler so as to reduce SO₃ as a mist generation material in a gas state, and to decrease an amount of SO₃ mist in the flue gas to be introduced to the CO₂ recovery equipment to 3ppm or less.

Brief Description of Drawings

[0021] FIG. 1 is a schematic diagram of an air pollution

control system of an embodiment according to the present invention.

FIG. 2 is a conceptual diagram of a mechanism of mist generation.

5 FIG. 3-1 is a photograph illustrating a state where white smoke is decreased in a CO₂ absorber.

FIG. 3-2 is a photograph illustrating a state where white smoke is generated in the CO₂ absorber.

10 FIG. 4-1 is a schematic diagram of an air pollution control system according to Embodiment 1.

FIG. 4-2 is a schematic diagram of another air pollution control system according to Embodiment 1.

FIG. 5 is a schematic diagram of an air pollution control system according to Embodiment 2.

15 FIG. 6 is a schematic diagram of an air pollution control system according to Embodiment 3.

FIG. 7 is a schematic diagram of an air pollution control system according to Embodiment 4.

20 FIG. 8 is a schematic diagram of an air pollution control system according to Embodiment 5.

FIG. 9 is a schematic diagram of an air pollution control system according to Embodiment 6.

FIG. 10 is a schematic diagram of an air pollution control system according to Embodiment 7.

25 FIG. 11 is a schematic diagram of an air pollution control system according to Embodiment 8.

Description of Embodiments

[0022] Hereinafter, the present invention will be described in detail with reference to the drawings. Note
30 that, the present invention is not limited by embodiments and examples. In addition, components in the embodiments and the examples include those that may be easily assumed by those skilled in the art or are practically the same.

[0023] FIG. 1 is a schematic diagram of an air pollution control system of an embodiment according to the present invention.

As illustrated in FIG. 1, in an air pollution control system 10 of the embodiment according to the present invention, flue gas 12 from a boiler 11 is subjected to a reduction in nitrogen oxides (NO_x) from the flue gas 12 by NO_x removal equipment 13, and thereafter is first guided to an air heater AH to heat air supplied to the boiler 11. Thereafter, the flue gas 12 is introduced to a dry type electric dust collector 14 which is dust reduction equipment so as to reduce particulates. Next, the flue gas 12 is introduced to SO_x removal equipment 15 to reduce sulfur oxides (SO_x). Then, the flue gas 12 is cooled by a cooler 16, is thereafter introduced to CO_2 recovery equipment 17 to reduce carbon dioxide, and purified gas 18 is emitted from the top portion of a CO_2 absorber to the air which is outside the system. Note that, the particulates reduced by the electric dust collector 14 are subjected to an additional ash treatment 14a.

[0024] In the present invention, before introducing the flue gas 12 to the CO_2 recovery equipment 17, mist generation material reduction equipment 20 which reduces a mist generation material that is a generation source of mist generated in the CO_2 absorber of the CO_2 recovery equipment 17 is provided.

[0025] According to the air pollution control system 10 according to the present invention, since the mist generation material reduction equipment 20 is provided before the introduction to the CO_2 recovery equipment 17, the amount of mist generation material in the flue gas 12 when being introduced to the CO_2 absorber of the CO_2 recovery equipment 17 is significantly decreased. As a

result, the amount of CO₂ absorption liquid (hereinafter, also referred to as "absorption liquid") entrained by mist and dispersed to the outside may be significantly decreased. As a result, the loss of the absorption liquid that
5 scatters to the outside of the system is significantly decreased, and thus an unnecessary replenishment is eliminated, thereby suppressing an increase in running cost during the air pollution control.

[0026] The mist generation material reduced by the mist
10 generation material reduction equipment 20 according to the present invention is SO₃ mist, nitric acid mist, hydrochloric acid mist, water vapor mist, or the like and is referred to as a material that becomes a mist generation factor in the CO₂ absorber. Note that, equipment that
15 performs a reduction in a gas state before becoming mist is also included in the mist generation material reduction equipment 20 according to the present invention.

[0027] Since the flue gas 12 from the boiler 11 is in a high-temperature state, the mist generation material is
20 present in a gas state at first. Thereafter, in a process of passing through the electric dust collector and the SO_x removal equipment, the flue gas is cooled, and thus the mist generation material changes from the gas state to a mist state.

25 The particle size of the mist of the mist generation material in the present invention is referred to as a size of equal to or smaller than 3.0 μm.

[0028] The form of mist generation and entraining of the absorption liquid in the CO₂ absorber of the CO₂ recovery
30 equipment 17 will be described using FIGS. 2, 3-1, and 3-2.

FIG. 2 is a conceptual diagram of a mechanism of entraining of the absorption liquid by mist generation. FIG. 3-1 is a photograph illustrating a state where white

smoke is decreased in the CO₂ absorber, and FIG. 3-2 is a photograph illustrating a state where white smoke is generated in the CO₂ absorber. Although, SO₃ mist is exemplified as the mist generation material in the description, descriptions with other kinds of mist will be the same. The flue gas 12 from the boiler 11 is subjected to a gas purifying treatment such as NO_x removal, a reduction in particulates, and SO_x removal, and the flue gas 12 is cooled by the cooler 16, resulting in a gas temperature of about 50°C. Since this temperature state is equal to or less than the acid dew point, there is SO₃ mist (for example, 0.1 to 1.0 μm).

A SO₃ mist 50 has SO₃ as a nucleus 51 and water vapor 52 that is incorporated into the periphery thereof.

[0029] In the CO₂ absorber, the absorption liquid is sprayed from nozzles and falls, and the falling absorption liquid and the flue gas are subjected to countercurrent contact such that CO₂ is absorbed by the absorption liquid. On the other hand, the flue gas 12 is introduced from the lower side of the CO₂ absorber and is discharged to the upper side. Here, the SO₃ mist 50 is not absorbed by the absorption liquid and ascends along with the gas stream of the flue gas 12.

[0030] Here, in the CO₂ absorber, when the absorption liquid is supplied from the nozzles, the absorption liquid falls and a part of the absorption liquid and moisture evaporates, and thus a gaseous absorption liquid 41G and water vapor 42 are generated.

In addition, the amount of gaseous absorption liquid 41G and the water vapor 42 further increases as the temperature of the absorption liquid is increased due to, for example, the exothermic reaction of the absorption liquid when CO₂ is absorbed.

[0031] Then, the gaseous absorption liquid 41G and the water vapor 42 are incorporated into the SO₃ mist 50, resulting in a SO₃ mist (bloated mist) 53 including a bloated (for example, about 0.5 to 2.0 μm) absorption liquid.

[0032] As described above, the SO₃ mist 50 in the flue gas 12, before being introduced to the CO₂ recovery equipment 17, incorporates the gaseous absorption liquid 41G and the water vapor 42 in the CO₂ absorber, becomes the SO₃ mist 53 including the absorption liquid, and scatters from the top portion of the CO₂ absorber while being entrained by the flue gas 12. Therefore, the loss of the absorption liquid occurs.

[0033] The form of white smoke generation in the CO₂ absorber is illustrated in FIGS. 3-1 and 3-2.

FIG. 3-1 illustrates a case where the amount of mist generation material is decreased to a predetermined amount or less by providing the mist generation material reduction equipment 20 for the flue gas 12 introduced to the CO₂ absorber and a state where the scattering of the SO₃ mist (bloated mist) 53 including the absorption liquid in the CO₂ absorber is significantly reduced and thus generation of white smoke is suppressed. FIG. 3-2 illustrates a case where the flue gas 12 is introduced as it is without providing the mist generation material reduction equipment 20 for the flue gas 12 introduced to the CO₂ absorber and a state where the scattering of the SO₃ mist (bloated mist) 53 including the absorption liquid in the CO₂ absorber occurs and thus white smoke is generated.

[0034] That is, in the present invention, the mist generated in the CO₂ absorber is referred to as the SO₃ mist (bloated mist) 53 including the absorption liquid. Confirming the presence or absence of the generation of

bloated mist is referred to as the presence or absence of generation of white smoke, and by suppressing the bloated mist in the CO₂ absorber, generation of white smoke is eliminated. Furthermore, the scattering of the absorption liquid is prevented.

[0035] In addition, regarding the bloated mist, as illustrated in FIG. 2, there may be cases where the gaseous absorption liquid 41G and the gaseous water vapor 42 are separately incorporated into the SO₃ mist 50 in the flue gas 12 in the CO₂ absorber to respectively form a SO₃ mist (bloated mist) 53A including the absorption liquid and a SO₃ mist (bloated mist) 53B including the water vapor.

Here, in the case of the mist (bloated mist) 53B including the water vapor, there is no loss of the absorption liquid. However, since generation of white smoke of the purified gas 18 to be discharged to the outside of a system occurs, a reduction in the mist generation material is also needed.

Therefore, according to the present invention, by providing the mist generation material reduction equipment 20 before introduction to the CO₂ recovery equipment 17, entraining of the CO₂ absorption liquid may be significantly reduced when the flue gas 12 from which CO₂ is reduced is discharged to the outside of the system, and an appropriate air pollution control may be performed.

[0036] Therefore, in the present invention, by providing the mist generation material reduction equipment 20 that reduces the mist generation material which is the generation source of the mist (the SO₃ mist including the absorption liquid which is the bloated mist) generated in the CO₂ absorber of the CO₂ recovery equipment 17 before introducing the flue gas 12 to the CO₂ recovery equipment 17, the loss of the absorption liquid that scatters to the

53609-46

13

outside of the system from the CO₂ absorber may be significantly decreased.

[0037] The mist generation material reduction equipment 20 may be provided on the upstream side of the dry type electric
5 dust collector 14, between the dry type electric dust collector 14 and the SO_x removal equipment 15, or in either of the front and the rear of the cooler 16, or to be integrated into the cooler 16.

Here, before introducing the flue gas 12 to the CO₂
10 recovery equipment 17, it is preferable that the amount of SO₃ mist 50 be decreased to 3 ppm or less for prevention of white smoke and prevention of scattering of the absorption liquid in the CO₂ absorber. This is because when the amount of SO₃ mist 50 is decreased to 3 ppm or less, scattering is suppressed, and
15 deterioration of, for example, an amine-based absorption liquid due to SO₃ is prevented.

[0038] According to the present invention, since the scattering of the absorption liquid is prevented and the deterioration of the absorption liquid is prevented, a decrease
20 in the number of regeneration treatments performed in the regeneration equipment (reclaiming equipment) for the absorption liquid may be achieved, and the loss of the absorption liquid is further significantly decreased, so that a decrease in the amount of the replenished absorption liquid may
25 be achieved. Therefore, the system efficiency of the air pollution control system may be significantly enhanced.

[0039] Note that, in this embodiment, the electric dust collector is exemplified as the dust reduction equipment in the description. However, the present invention is not limited to
30 this as long as particulates are reduced from the flue gas 12, and besides the electric dust collector,

for example, a bag filter or a venturi scrubber may be exemplified.

[0040] In the following embodiment, specific embodiments of the mist generation material reduction equipment that reduces the mist generation material will be described.
Embodiment 1

[0041] The air pollution control system including the CO₂ recovery equipment according to an embodiment of the present invention will be described with reference to the drawings. FIG. 4-1 is a schematic diagram of the air pollution control system according to Embodiment 1. FIG. 4-2 is a schematic diagram of another air pollution control system according to Embodiment 1. Note that, in the following embodiments, SO₃ is exemplified as the mist generation material in the description, but the present invention is not limited thereto.

As illustrated in FIG. 4-1, an air pollution control system 10A according to Embodiment 1 includes the NO_x removal equipment 13 which reduces nitrogen oxides from the flue gas 12 from the boiler (for example, coal-fired boiler) 11, the electric dust collector 14 which is provided on the downstream side of the NO_x removal equipment 13 and reduces particulates from the flue gas 12, the SO_x removal equipment 15 which is provided on the downstream side of the electric dust collector 14 and reduces sulfur oxides from the flue gas 12, the cooler 16 which is provided on the downstream side of the SO_x removal equipment 15 and has a cooling unit 16a that decreases the gas temperature, and the CO₂ recovery equipment 17 which includes an CO₂ absorber 17A that brings CO₂ in the flue gas 12 into contact with the absorption liquid so as to be reduced and an absorption liquid regenerator 17B that causes the absorption liquid to emit CO₂ to recover the CO₂

53609-46

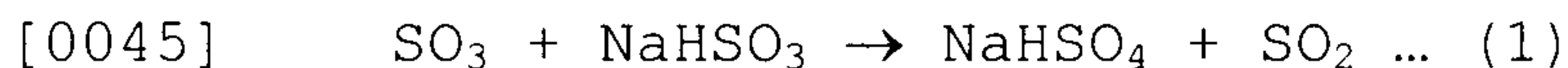
15

and regenerate the absorption liquid.

[0042] In this embodiment, before introducing the SO₃ mist 50 to the CO₂ recovery equipment 17, as a countermeasure for a reduction, sodium bisulfite injection equipment 21 which injects sodium bisulfite (SBS; Sodium bisulfite) between the NO_x removal equipment 13 and the electric dust collector 14 is provided. The sodium bisulfite injection equipment 21 according to this embodiment functions as the mist generation material reduction equipment 20.

[0043] As a result, by supplying SBS into the flue gas 12 having a gas temperature of about 120°C to 160°C on the downstream side of the air heater AH, SO₃ in the gas state is reduced. As a result, the amount of the SO₃ mist 50 introduced to the CO₂ recovery equipment 17 is decreased.

[0044] That is, in this embodiment, SBS is sprayed from the sodium bisulfite injection equipment 21 to convert SO₃ in the gas state to NaHSO₄ or Na₂SO₄ solids so as to be arrested thereafter by the dry type electric dust collector 14 along with particulates in the flue gas 12. The form of this reaction is shown as follows.



[0046] Note that, the particulates arrested by the electric dust collector 14 are subjected to an ash treatment 14a.

[0047] Injection of sodium bisulfite (SBS) may be performed anywhere on the upstream side of the electric dust collector 14, and for example, sodium bisulfite (SBS) may be supplied between the NO_x removal equipment 13 and the air heater AH (broken line in FIG. 4-1).

[0048] In addition, the flue gas 12 from which

particulates are reduced in the electric dust collector 14 is subjected to a reduction in sulfur oxides from the flue gas 12 in the SO_x removal equipment 15, limestone (CaCO₃) 15a and oxidation air 15b are supplied to cause the reduced sulfur oxides to become gypsum 15c through a limestone-gypsum method, and desulfurized waste water 15d is additionally treated. Note that, in the figures, reference numerals 17a, 17b, 17c, 17d, 17e, and 17f denote a reboiler, saturated water vapor, condensed water, a separation drum, recovered CO₂, and an absorption liquid heat exchanger, respectively.

[0049] The flue gas 12 desulfurized by the SO_x removal equipment 15 is cooled by the cooler 16 to cause the flue gas temperature to be 50°C or less, and is introduced to the CO₂ recovery equipment 17 including the CO₂ absorber 17A and the absorption liquid regenerator 17B. Here, CO₂ in the flue gas 12 is reduced by, for example, the amine-based absorption liquid 41. At this time, in this embodiment, as a result of reducing SO₃ in the gas state which is the mist generation material in the flue gas 12, a decrease in the amount of the SO₃ mist 50 introduced to the CO₂ recovery equipment 17 is achieved. Therefore, the generation of white smoke of the purified gas 18 discharged from the CO₂ absorber 17A, which is caused by the mist, is suppressed, and the entraining of the absorption liquid 41 is suppressed.

As a result, an air pollution control system in which the loss of the absorption liquid 41 is significantly decreased may be provided.

[0050] Here, in this embodiment, the amine-based absorption liquid is exemplified as the absorption liquid 41. However, the absorption liquid of the present invention is not limited to the amine-based absorption

liquid. As the absorption liquid, besides the amine-based absorption liquid, for example, an amino acid-based absorption liquid, an ionic liquid absorption liquid, a hot potassium carbonate absorption liquid made of potassium carbonate and amines, and the like may be exemplified.

[0051] FIG. 4-2 is a schematic diagram of an air pollution control system of a modified embodiment of Embodiment 1. In the cooler 16 illustrated in FIG. 4-1, the flue gas 12 is cooled. However, as illustrated in FIG. 4-2, a finishing SO_x removal unit 16b is provided on the lower side of the cooler 16, and the limestone (CaCO₃) 15a and the oxidation air 15b are supplied to form the gypsum 15c through the limestone-gypsum method. Accordingly, sulfur oxides that remain in the flue gas 12 from the SO_x removal equipment 15 are reduced to further enhance the SO_x removal efficiency, and thus most of the residual sulfur oxides may be reduced. Note that, a strong alkaline agent such as sodium hydroxide (NaOH) may be added instead of the limestone.

20 In this embodiment, in the finishing SO_x removal unit 16b, a liquid column type is used as a method of supplying a SO_x removal absorption liquid. However, the present invention is not limited thereto, and any of sprinkling type, jet type, and filling type may also be used.

25 [0052] Here, as the SO_x removal absorption liquid used in the finishing SO_x removal unit 16b, besides the limestone (CaCO₃), a strong alkaline agent such as NaOH, Na₂CO₃, NaHCO₃, Ca(OH)₂, or Mg(OH)₂ may be exemplified. By using the strong alkaline agent, further enhancement of the SO_x removal performance may be achieved, and this is particularly effective in a case where the flue gas 12 having a high sulfur oxide concentration is introduced, thereby decreasing the concentration of sulfur oxides in

the flue gas 12 introduced to the CO₂ recovery equipment 17 to an extremely low concentration. The SO_x removal performance is increased compared to the limestone-gypsum method. Therefore, even in a case where the concentration of sulfur oxides in the introduced flue gas 12 is high, favorable SO_x removal performance is exhibited, which is preferable.

Embodiment 2

[0053] An air pollution control system including the CO₂ recovery equipment according to an embodiment of the present invention will be described with reference to the drawings.

FIG. 5 is a schematic diagram of an air pollution control system according to Embodiment 2. As illustrated in FIG. 5, the air pollution control system 10B according to Embodiment 2 is provided with ammonia injection equipment 22 on the upstream side of the dry type electric dust collector 14 instead of the sodium bisulfite injection equipment 21 used in Embodiment 1 so as to spray ammonia into the flue gas 12. The ammonia injection equipment 22 according to this embodiment functions as the mist generation material reduction equipment 20.

[0054] On the upstream side of the electric dust collector 14, ammonia (NH₃) gas is sprayed to form ammonium sulfate (NH)₄SO₄ and this is arrested by the dry type electric dust collector 14 along with particulates. In this embodiment, as a result of reducing SO₃ in the gas state which is the mist generation material from the flue gas 12, a decrease in the amount of the SO₃ mist introduced to the CO₂ recovery equipment 17 is achieved. Therefore, the generation of white smoke of the purified gas 18 discharged from the CO₂ absorber 17A, which is caused by the mist, is suppressed, and the entraining of the

absorption liquid 41 is suppressed. As a result, an air pollution control system in which there is no loss of the absorption liquid 41 may be provided.

In a case where the NO_x removal equipment 13 is
5 present on the upstream side of the air pollution control system, by increasing a supply amount of ammonia (NH₃) used in the NO_x removal equipment 13, an ammonia (NH₃) injection equipment does not need to be newly provided and may be replaced.

10 Embodiment 3

[0055] An air pollution control system including the CO₂ recovery equipment according to an embodiment of the present invention will be described with reference to the drawings.

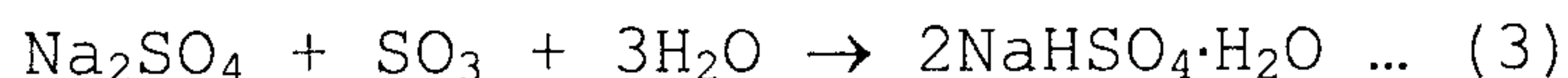
15 FIG. 6 is a schematic diagram of an air pollution control system according to Embodiment 3. As illustrated in FIG. 6, the air pollution control system 10C according to Embodiment 3 is provided with dissolved salt spraying equipment 23 between the dry type electric dust collector
20 14 and the SO_x removal equipment 15 instead of the sodium bisulfite injection equipment 21 used in Embodiment 1 so as to spray a dissolved salt 24 into the flue gas 12. The dissolved salt spraying equipment 23 according to this embodiment functions as the mist generation material
25 reduction equipment 20.

[0056] In this embodiment, an aqueous solution of the dissolved salt 24, which is soluble, such as Na₂SO₄ and MgSO₄ is sprayed on the upstream side of the SO_x removal equipment 15. As the dissolved salt solution is sprayed
30 into the flue gas 12 having a gas temperature of, for example, about 130°C to 150°C on the downstream side of the dry type electric dust collector 14, fine dry dissolved salt particles are formed, and SO₃ in the gas state is

adsorbed and fixed onto the dissolved salt particles, thereby reducing the SO₃ in the gas state from the flue gas 12. As a result, the amount of the SO₃ mist 50 introduced to the CO₂ recovery equipment 17 is decreased.

5 [0057] As the dissolved salt 24, for example, there are NaCl, NaOH, Na₂SO₄, Na₂CO₃, KCl, KOH, K₂SO₄, K₂CO₃, KHCO₃, MgCl₂, MgSO₄, CaCl₂, and the like.

[0058] Here, when Na₂SO₄ is used as the dissolved salt 24, a reaction between dissolved salt particles (Na₂SO₄) and SO₃ as in Expression (3) below proceeds. As a result, NaHSO₄·H₂O (solid) is formed.



[0059] Both Na₂SO₄ and NaHSO₄·H₂O are soluble and thus are dissolved in the SO_x removal equipment 15 on the downstream side. Therefore, compared to a case of Embodiment 2 in which ammonia is injected, a solid material treatment including ammonia of the dry type electric dust collector 14 is unnecessary. In this embodiment, as a result of reducing SO₃ in the gas state which is the mist generation material from the flue gas 12, a decrease in the amount of the SO₃ mist 50 introduced to the CO₂ recovery equipment 17 is achieved. Therefore, the generation of white smoke of the purified gas 18 discharged from the CO₂ absorber 17A, which is caused by the mist, is suppressed, and the entraining of the absorption liquid 41 is suppressed. As a result, an air pollution control system in which the loss of the absorption liquid 41 is significantly decreased may be provided.

Embodiment 4

30 [0060] An air pollution control system including the CO₂ recovery equipment according to an embodiment of the present invention will be described with reference to the drawings.

FIG. 7 is a schematic diagram of an air pollution control system according to Embodiment 4. As illustrated in FIG. 7, the air pollution control system 10D according to Embodiment 4 is provided with a wet type electric dust collector 25 between the SO_x removal equipment 15 and the cooler 16 instead of the sodium bisulfite injection equipment 21 used in Embodiment 1. The wet type electric dust collector 25 according to this embodiment functions as the mist generation material reduction equipment 20. The wet type electric dust collector 25 may be provided on the downstream side of the SO_x removal equipment 15 to charge and reduce the SO₃ mist 50 from the flue gas 12. In this embodiment, the wet type electric dust collector 25 is provided on the upstream side of the cooler 16 (between the SO_x removal equipment 15 and the cooler 16). However, the present invention is not limited thereto, and the wet type electric dust collector 25 may also be provided on the downstream side of the cooler 16 (between the cooler 16 and the CO₂ recovery equipment 17).

[0061] In this embodiment, as a result of reducing SO₃ in the mist state which is the mist generation material in the flue gas 12, a decrease in the amount of the SO₃ mist 50 introduced to the CO₂ recovery equipment 17 is achieved. Therefore, the generation of white smoke of the purified gas 18 discharged from the CO₂ absorber 17A, which is caused by the mist, is suppressed, and the entraining of the absorption liquid 41 is suppressed. As a result, an air pollution control system in which the loss of the absorption liquid 41 is significantly decreased may be provided.

Embodiment 5

[0062] An air pollution control system including the CO₂ recovery equipment according to an embodiment of the

53609-46

22

present invention will be described with reference to the drawings.

FIG. 8 is a schematic diagram of an air pollution control system according to Embodiment 5. As illustrated in FIG. 8, the air pollution control system 10E according to Embodiment 5 is provided with a wet type electric dust collection unit 25a between the SO_x removal unit 16b and the cooling unit 16a inside the cooler 16 of Embodiment 5 so as to configure a wet type electric dust collector-integrated cooler 27. Accordingly, finishing SO_x removal equipment that performs a finish of SO_x removal is constructed. The wet type electric dust collection unit 25a of the cooling unit 16a according to this embodiment functions as the mist generation material reduction equipment 20. Compared to the system of Embodiment 4, it is unnecessary to separately install the wet type electric dust collector 25, and thus there is no need to secure the installation space thereof.

[0063] In this embodiment, by configuring the wet type electric dust collector-integrated cooler 27, the SO₃ mist 50 may be reduced from the flue gas 12. In this embodiment, as a result of reducing SO₃ in the mist state which is the mist generation material from the flue gas 12, a decrease in the amount of the SO₃ mist 50 introduced to the CO₂ recovery equipment 17 is achieved. Therefore, the generation of white smoke of the purified gas 18 discharged from the CO₂ absorber 17A, which is caused by the mist, is suppressed, and the entraining of the absorption liquid 41 is suppressed. As a result, an air pollution control system in which the loss of the absorption liquid 41 is significantly decreased may be provided.

Embodiment 6

[0064] An air pollution control system including the CO₂

53609-46

23

recovery equipment according to an embodiment of the present invention will be described with reference to the drawings.

FIG. 9 is a schematic diagram of an air pollution control system according to Embodiment 6. As illustrated in FIG. 9, the air pollution control system 10F according to Embodiment 6 is provided with a demister 26 inside the cooler 16 instead of the sodium bisulfite injection equipment 21 used in Embodiment 1. The demister 26 according to this embodiment functions as the mist generation material reduction equipment 20.

[0065] By providing the demister 26 at the top portion on the upper side of the downstream of the cooling unit 16a of the cooler 16, the SO₃ mist 50 may be reduced from the flue gas 12. In this embodiment, as a result of reducing SO₃ in the mist state which is the mist generation material from the flue gas 12, a decrease in the amount of the SO₃ mist 50 introduced to the CO₂ recovery equipment 17 is achieved. Therefore, the generation of white smoke of the purified gas 18 discharged from the CO₂ absorber 17A, which is caused by the mist, is suppressed, and the entraining of the absorption liquid 41 is suppressed. As a result, an air pollution control system in which the loss of the absorption liquid 41 is significantly decreased may be provided.

[0066] In this embodiment, the wire diameter of the wire mesh that constitutes the demister 26 may be 1 to 20 μm , and more preferably 3 to 10 μm , but the present invention is not limited thereto. In addition, it is preferable that the void fraction of the demister 26 be about 90 to 97%, but the present invention is not limited thereto.

Embodiment 7

[0067] An air pollution control system including the CO₂

recovery equipment according to an embodiment of the present invention will be described with reference to the drawings.

FIG. 10 is a schematic diagram of an air pollution control system according to Embodiment 7. As illustrated in FIG. 10, the air pollution control system 10G according to Embodiment 7 is provided with calcium carbonate spraying equipment 31 between the electric dust collector 14 and the SO_x removal equipment 15 instead of the sodium bisulfite injection equipment 21 used in Embodiment 1 so as to spray calcium carbonate (CaCO₃) into the flue gas 12. In addition, on the upstream side of the SO_x removal equipment 15 which is on the downstream side where spraying is performed, a first heat exchanger 32 which decreases the flue gas temperature is provided. The calcium carbonate spraying equipment 31 and the first heat exchanger 32 according to this embodiment function as the mist generation material reduction equipment 20.

[0068] On the upstream side of the SO_x removal equipment 15, as the temperature of the flue gas 12 is decreased to a sulfuric acid dew point or less by the first heat exchanger 32, gaseous SO₃ is converted to mist-like SO₃, and the mist-like SO₃ is neutralized by CaCO₃ (limestone) sprayed into the flue gas 12, thereby reducing the mist-like SO₃ from the flue gas 12.

[0069] In this embodiment, as a result of converting SO₃ which is the mist generation material in the flue gas 12 from the gas state to the mist state and reducing the mist-like mist generation material, a decrease in the amount of the SO₃ mist 50 introduced to the CO₂ recovery equipment 17 is achieved. Therefore, the generation of white smoke of the purified gas 18 discharged from the CO₂ absorber 17A, which is caused by the mist, is suppressed, and the

entraining of the absorption liquid 41 is suppressed. As a result, an air pollution control system in which the loss of the absorption liquid 41 is significantly decreased may be provided.

5 Embodiment 8

[0070] An air pollution control system including the CO₂ recovery equipment according to an embodiment of the present invention will be described with reference to the drawings.

10 FIG. 11 is a schematic diagram of an air pollution control system according to Embodiment 8. As illustrated in FIG. 11, the air pollution control system 10H according to Embodiment 8 is provided with a second heat exchanger 33 which decreases the gas temperature of the flue gas 12, on
15 the upstream side of the dry type electric dust collector 14 instead of the first heat exchanger 32 provided in Embodiment 7. The second heat exchanger 33 according to this embodiment functions as the mist generation material reduction equipment 20.

20 [0071] In this embodiment, by providing the second heat exchanger 33, the flue gas 12 is decreased to about, for example, 80 to 110°C, and thus the SO₃ gas is decreased to a sulfuric acid dew point or less and becomes mist-like SO₃. The mist-like SO₃ adheres to particulates in the flue gas
25 12, and this is arrested by the electric dust collector 14 so as to reduce SO₃.

[0072] In this embodiment, as a result of converting SO₃ which is the mist generation material in the flue gas 12 from the gas state to the mist state and reducing the mist
30 generation material in the mist state, a decrease in the amount of the SO₃ mist 50 introduced to the CO₂ recovery equipment 17 is achieved. Therefore, the generation of white smoke of the purified gas 18 discharged from the CO₂

absorber 17A, which is caused by the mist, is suppressed, and the entraining of the absorption liquid 41 is suppressed. As a result, an air pollution control system in which the loss of the absorption liquid 41 is significantly decreased may be provided.

[0073] As described above in the embodiments, according to the present invention, since various forms of mist generation material reduction equipment 20 are provided, an air pollution control system in which the entraining of the absorption liquid 41 is significantly reduced when the flue gas 12 from which CO₂ is reduced is discharged to the outside of the system may be provided.

[0074] Even in various combinations of Embodiments 1 to 8, the effect of the present invention may be exhibited. Specifically, a combination of any one of the sodium bisulfite injection equipment 21 of Embodiment 1, the ammonia injection equipment 22 of Embodiment 2, and the dissolved salt spraying equipment 23 of Embodiment 3, and the wet type electric dust collector 25 of Embodiment 4 and/or the demister 26 of Embodiment 6 may be achieved.

[0075] In addition, a combination of any one of the sodium bisulfite injection equipment 21 of Embodiment 1, the ammonia injection equipment 22 of Embodiment 2, and the dissolved salt spraying equipment 23 of Embodiment 3 and the first heat exchanger 32 of Embodiment 7, and moreover, a combination of the former combination and the wet type electric dust collector 25 of Embodiment 4 and/or the demister 26 of Embodiment 6 may be achieved.

[0076] In addition, a combination of the second heat exchanger 33 of Embodiment 8 and the wet type electric dust collector 25 of Embodiment 4 and/or the demister 26 of Embodiment 6 may be achieved.

[0077] Here, it is preferable that the first and second

heat exchangers 32 and 33 not be general heat exchange members made of steel but be made of a corrosion-resistant material. This is because when SO_3 which is the mist generation material is changed from the gas state to the mist state, resistance to corrosion due to sulfurous acid or sulfuric acid is necessary for long-term stable operation.

[0078] Here, as the corrosion-resistant material in the present invention, an acid-resistant organic material or inorganic material may be used. For example, as the organic material, "Teflon (registered trademark)" such as polytetrafluoroethylene (PTFE) may be exemplified.

In this case, the constituent member of the heat exchanger may be treated by coating with the corrosion-resistant material, or the constituent member itself may be manufactured of a corrosion-resistant material.

Reference Signs List

[0079] 10, 10A to 10H AIR POLLUTION CONTROL SYSTEM

20	11	BOILER
	12	FLUE GAS
	13	NO_x REMOVAL EQUIPMENT
	14	ELECTRIC DUST COLLECTOR
	15	SO_x REMOVAL EQUIPMENT
25	16	COOLER
	16a	COOLING UNIT
	16b	FINISHING SO_x REMOVAL UNIT
	17	CO_2 RECOVERY EQUIPMENT
	17A	CO_2 ABSORBER
30	17B	ABSORPTION LIQUID REGENERATOR
	18	PURIFIED GAS
	20	MIST GENERATION MATERIAL REDUCTION EQUIPMENT
	21	SODIUM BISULFITE INJECTION EQUIPMENT

	22	AMMONIA INJECTION EQUIPMENT
	23	DISSOLVED SALT SPRAYING EQUIPMENT
	24	DISSOLVED SALT
	25	WET TYPE ELECTRIC DUST COLLECTOR
5	25a	WET TYPE ELECTRIC DUST COLLECTION UNIT
	26	DEMISTER
	31	CALCIUM CARBONATE SPRAYING EQUIPMENT
	32	FIRST HEAT EXCHANGER
	33	SECOND HEAT EXCHANGER
10	41	ABSORPTION LIQUID

53609-46

29

CLAIMS:

1. An air pollution control system comprising:

SO_x removal equipment for reducing sulfur oxides from flue gas from a boiler;

5 a cooler which is provided on a downstream side of the SO_x removal equipment, for reducing the sulfur oxides that remain in the flue gas and decrease a gas temperature;

CO₂ recovery equipment including:

10 a CO₂ absorber for bringing CO₂ in the flue gas into contact with a CO₂ absorption liquid so as to be reduced, and

an absorption liquid regenerator for causing the CO₂ absorption liquid to emit CO₂ so as to recover CO₂ and regenerate the CO₂ absorption liquid;

15 mist generation material reduction equipment which reduces a mist generation material which is a generation source of mist that is generated in the CO₂ absorber of the CO₂ recovery equipment before introducing the flue gas to the CO₂ recovery equipment:

20 NO_x removal equipment for reducing nitrogen oxides from the flue gas; and

a dry type electric dust collector for reducing particulates,

25 wherein the mist generation material reduction equipment is a sodium bisulfite injection equipment for injecting sodium bisulfite between the NO_x removal equipment

53609-46

30

and the electric dust collector so as to reduce SO_3 as the mist generation material in a gas state from the flue gas.

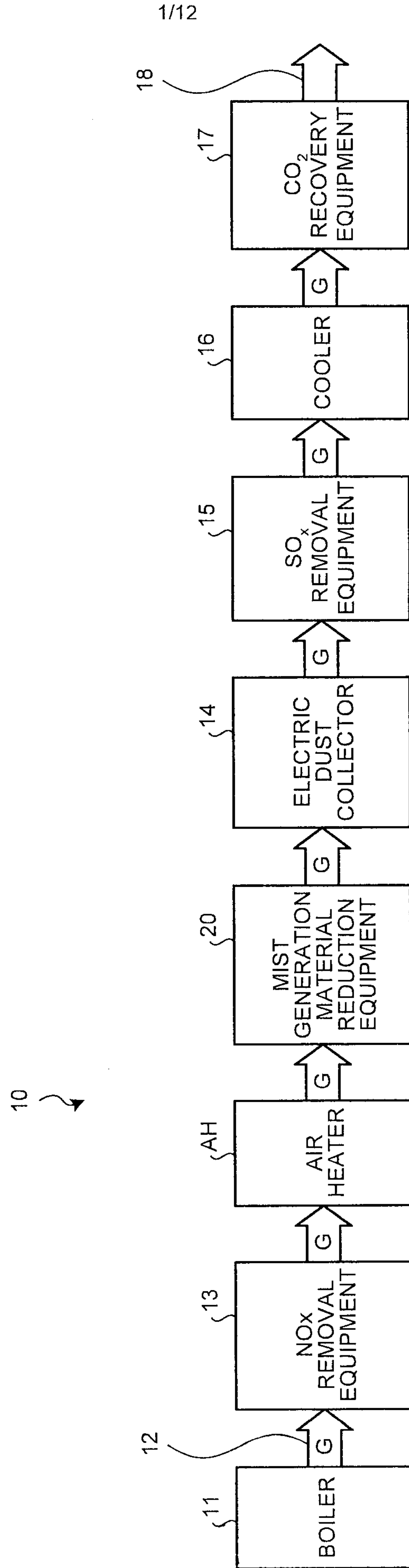
2. An air pollution control method comprising:

on an upstream side of CO_2 recovery equipment which
5 brings CO_2 in flue gas into contact with a CO_2 absorption liquid so as to be absorbed and reduced,

injecting sodium bisulfite into the flue gas generated from a boiler so as to reduce SO_3 as a mist generation material in a gas state, and to

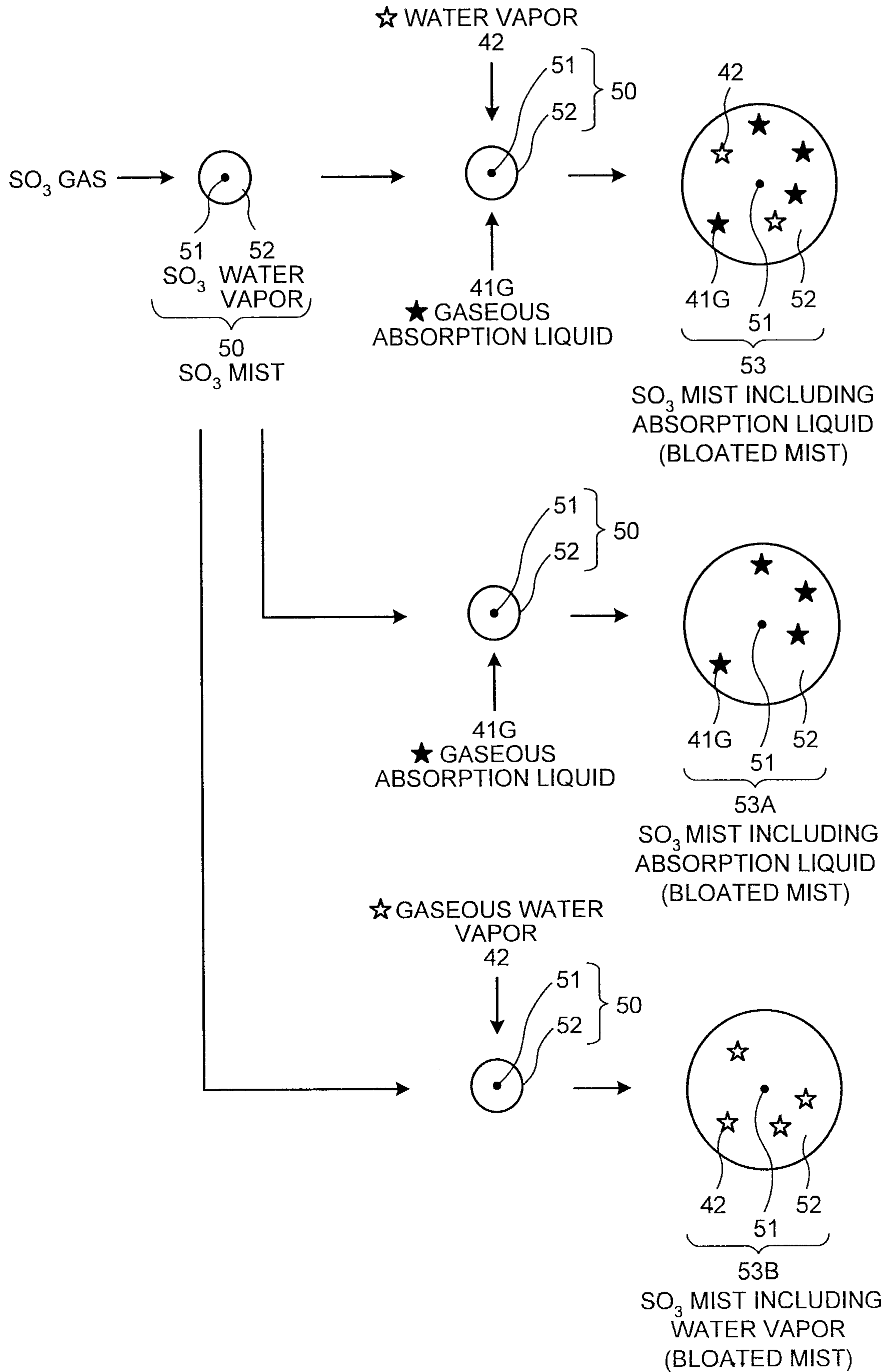
10 decrease an amount of SO_3 mist in the flue gas to be introduced to the CO_2 recovery equipment to 3ppm or less.

FIG.1



2/12

FIG.2



3/12

FIG.3-1

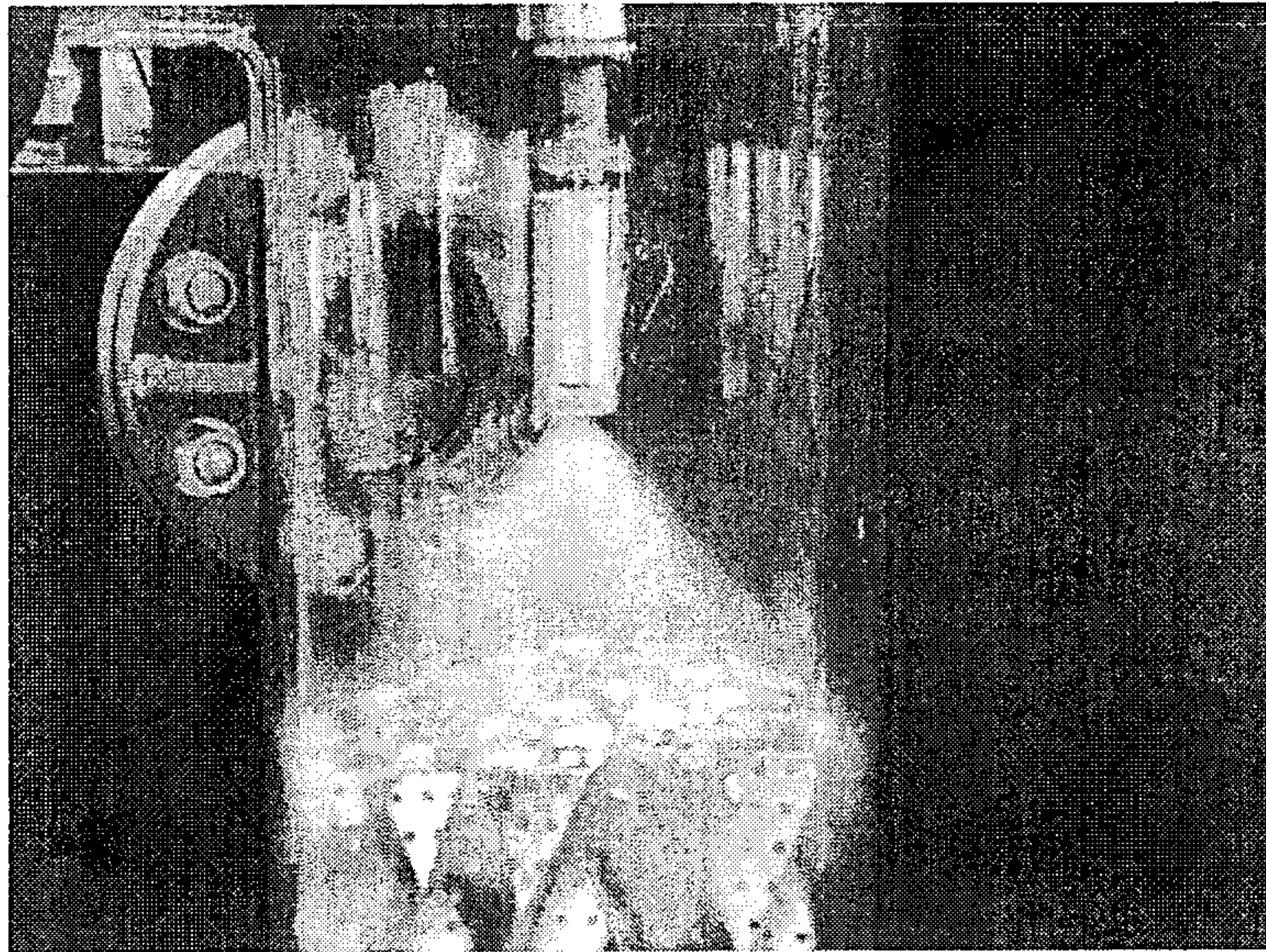


FIG.3-2

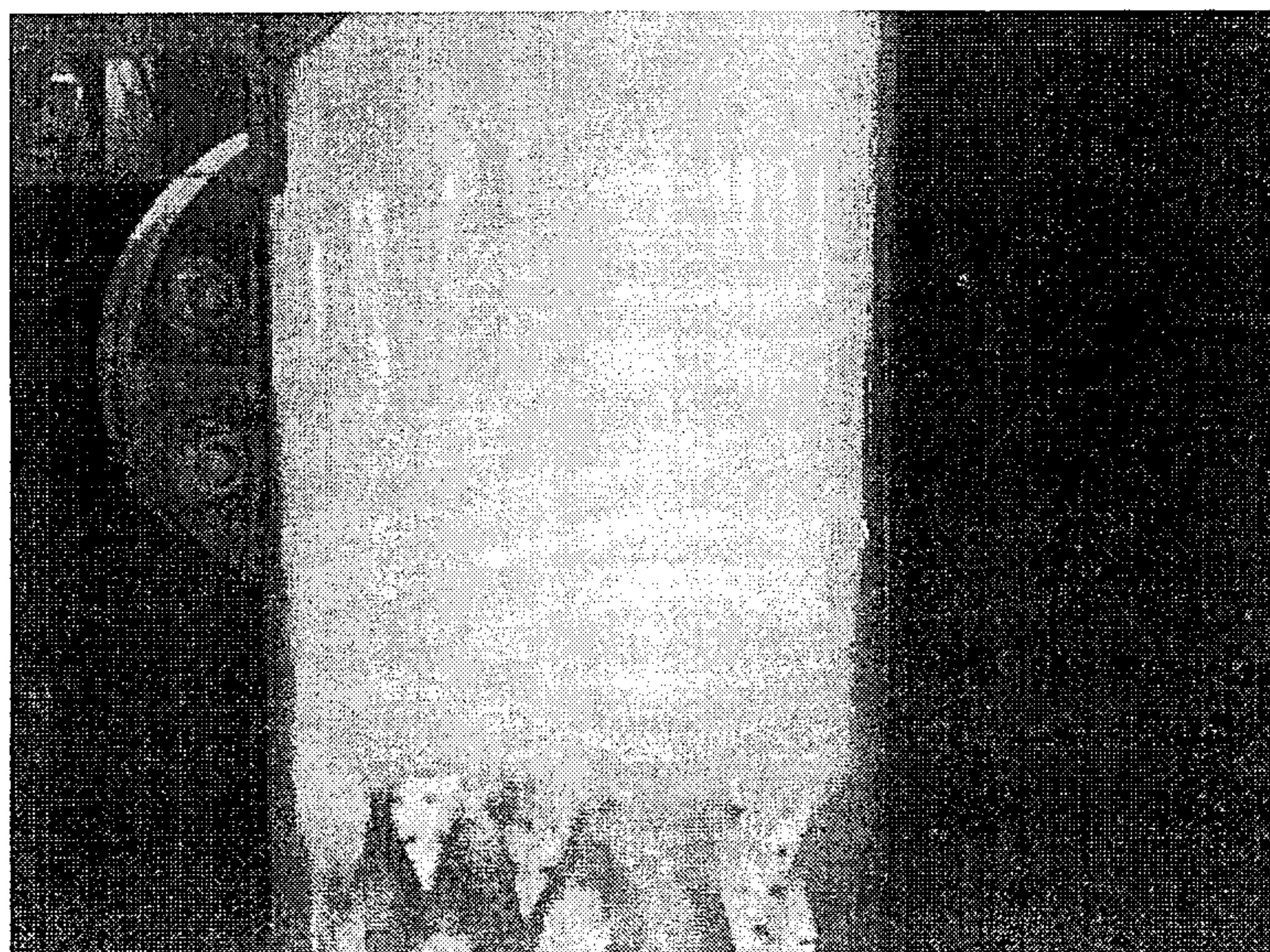


FIG. 4-1

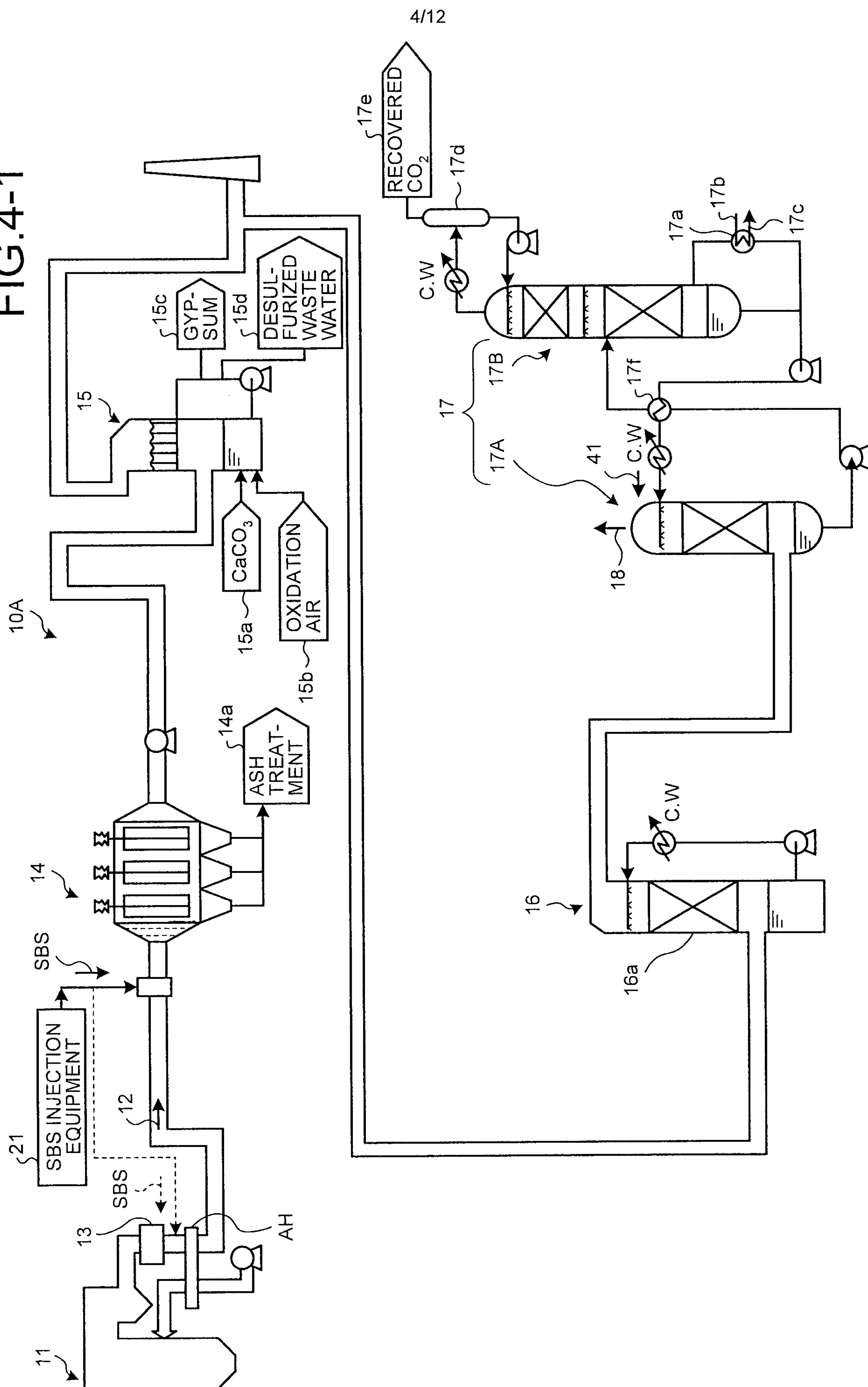


FIG. 4-2

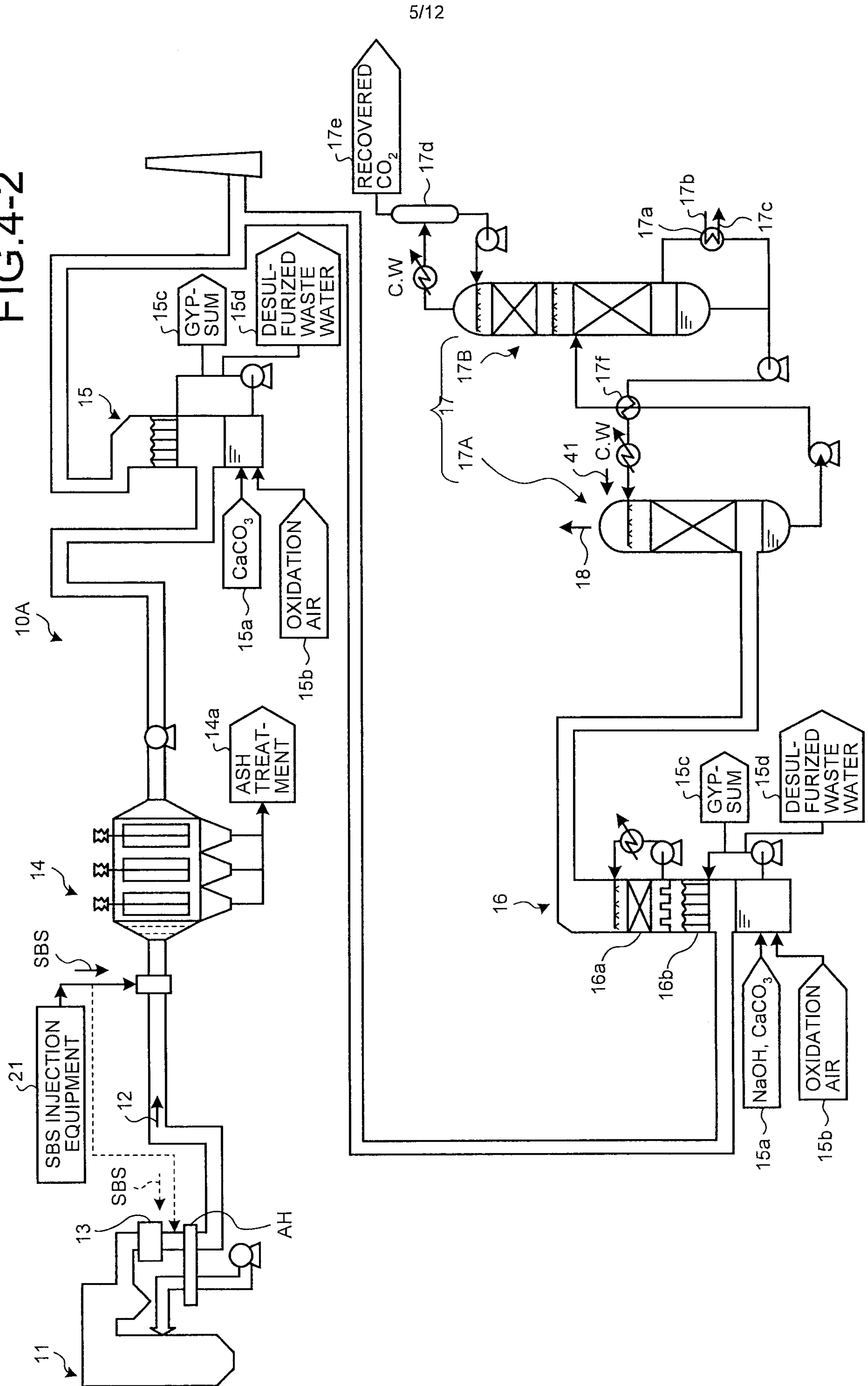


FIG. 5

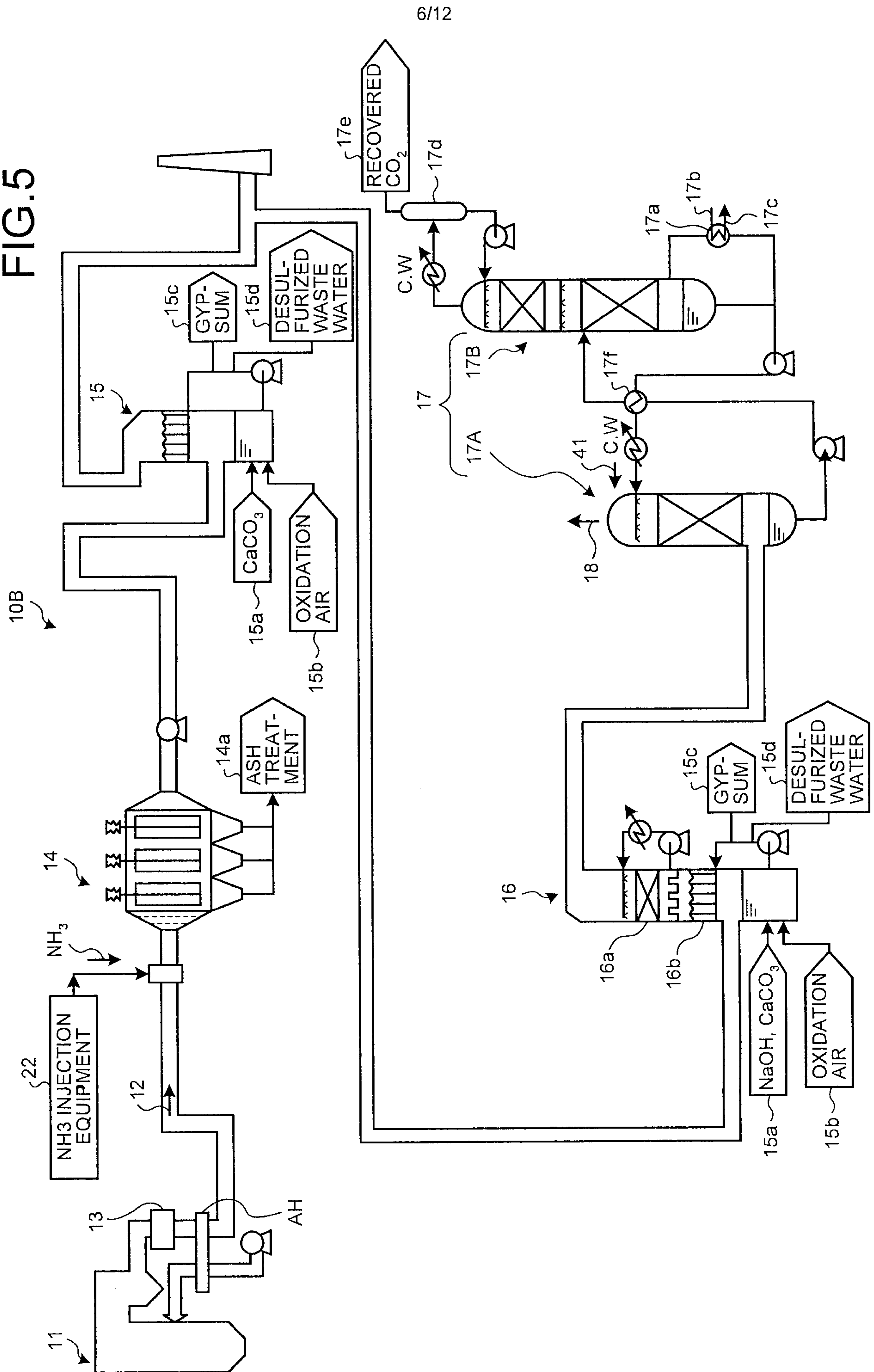


FIG. 6

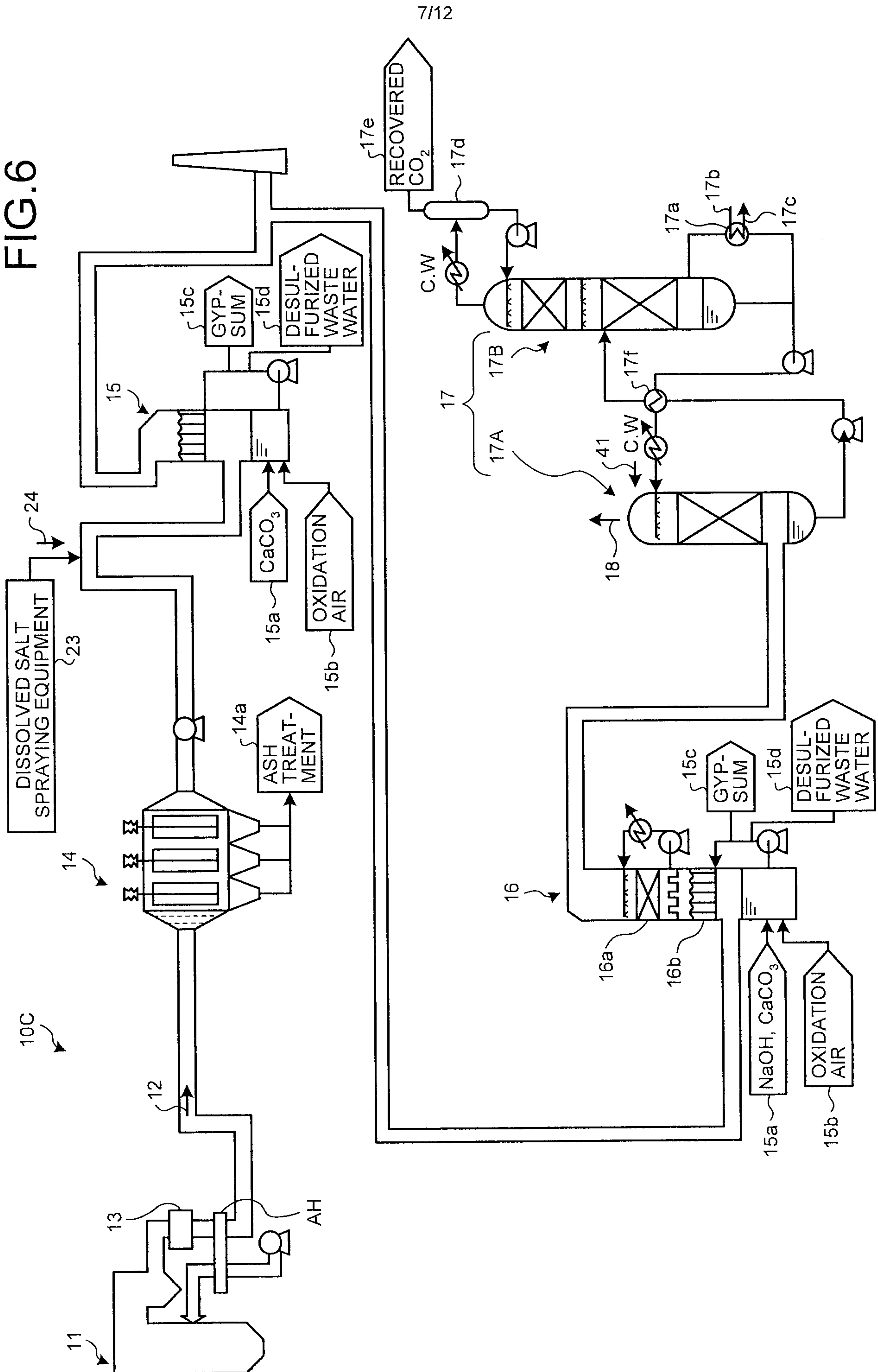
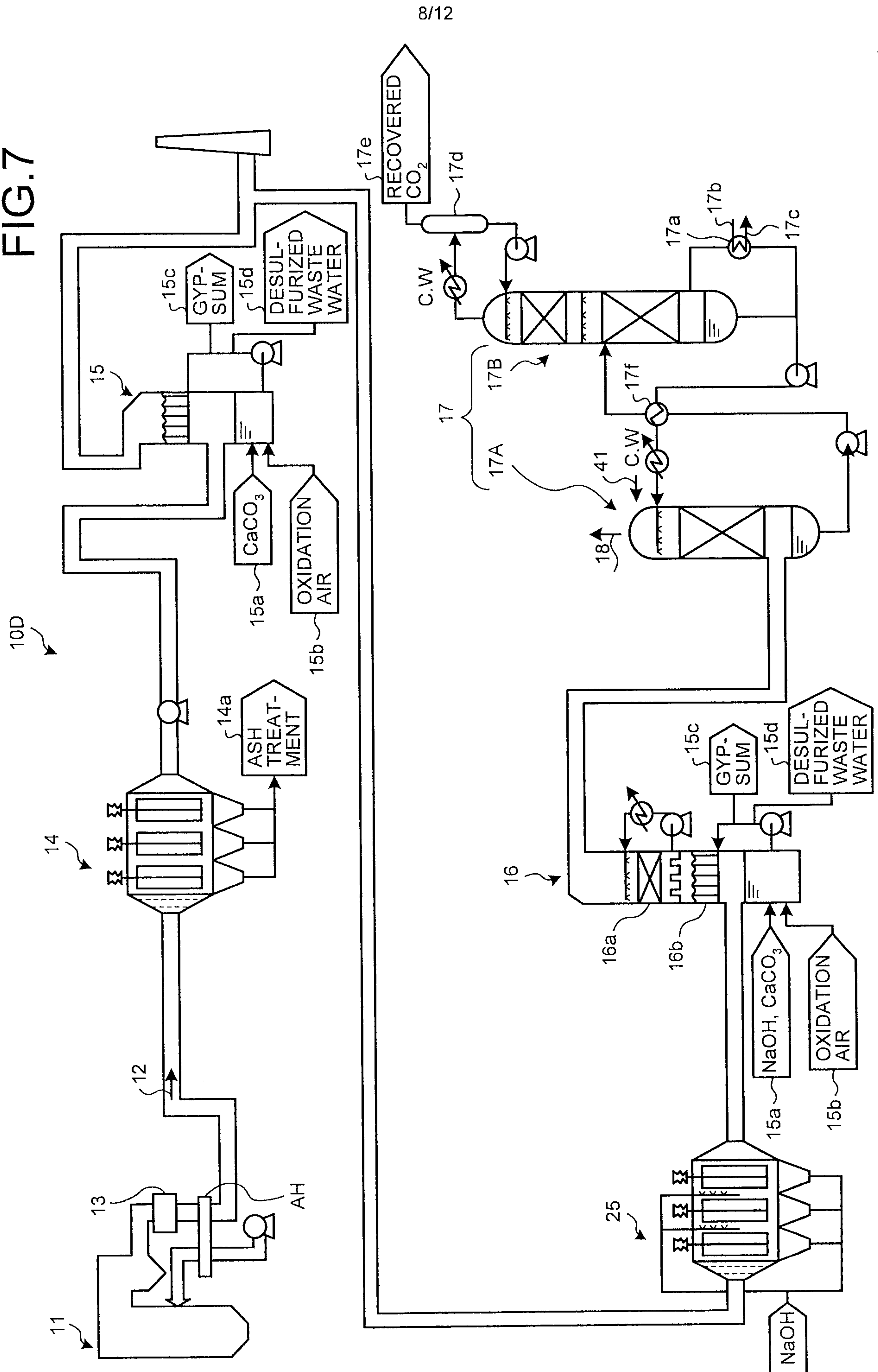


FIG. 7



10/12

FIG. 9

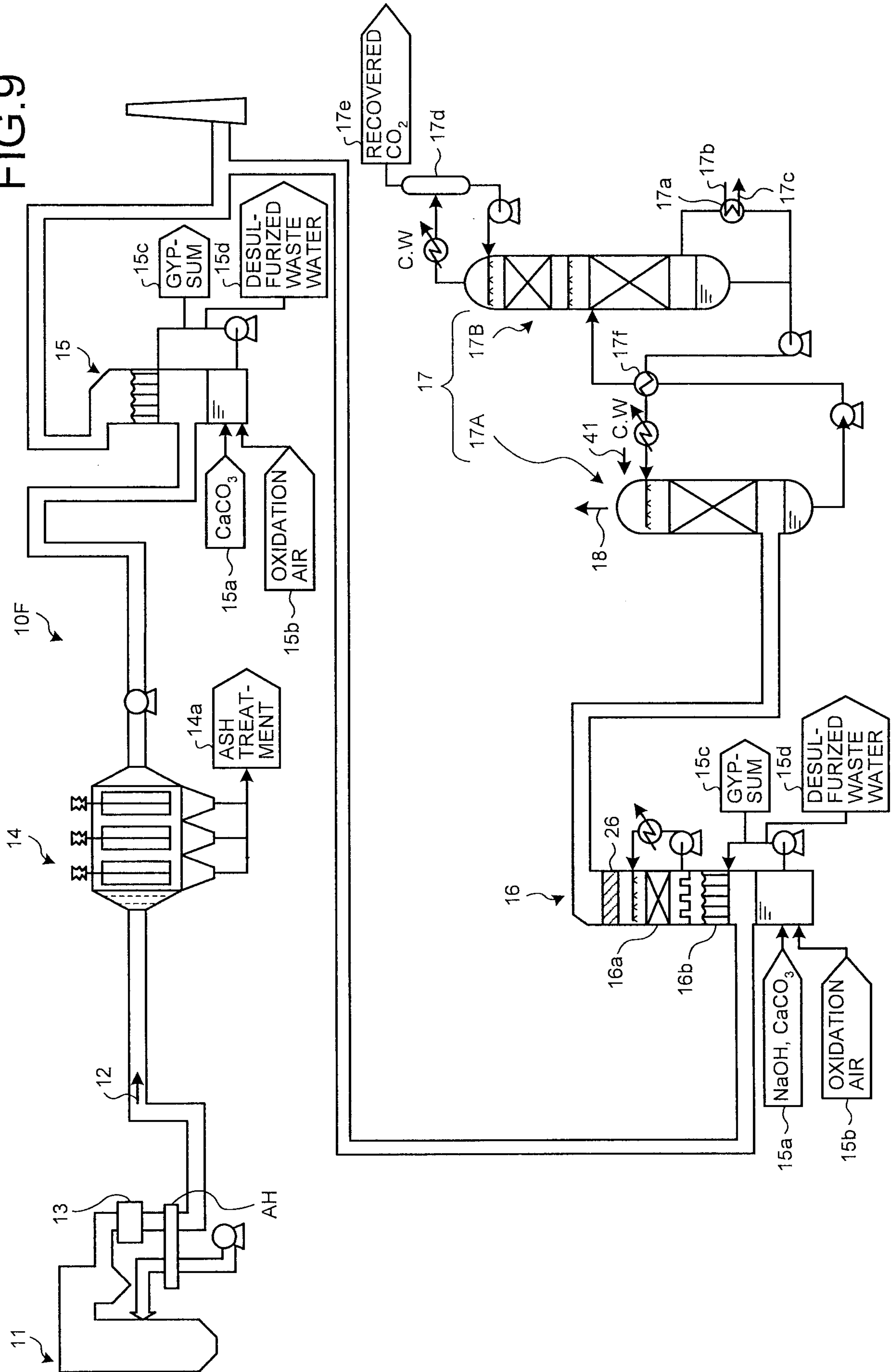


FIG. 10

