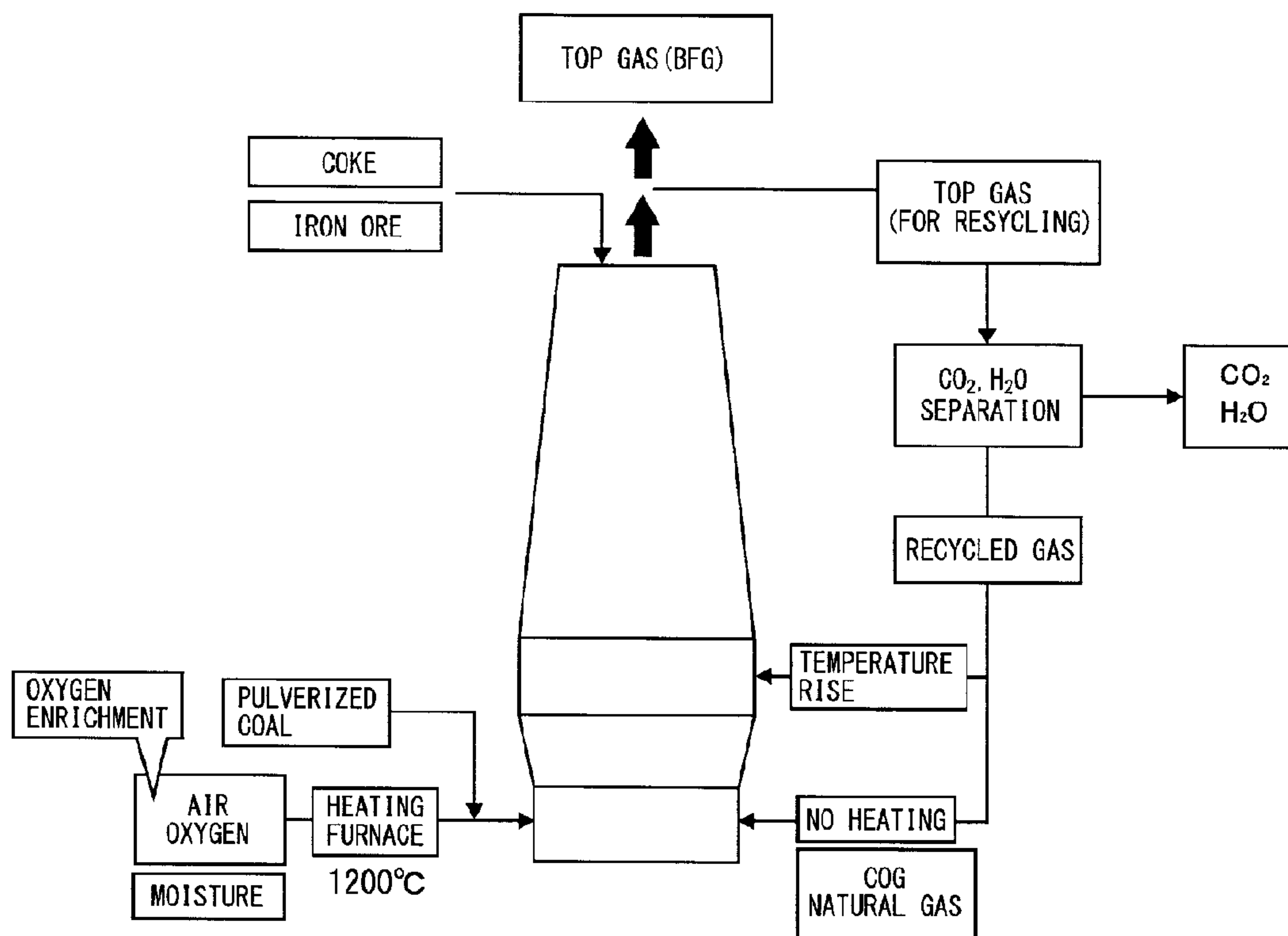




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(54) **Titre : METHODE DE FONCTIONNEMENT D'UN HAUT-FOURNEAU**
 (54) **Title: METHOD FOR OPERATION OF BLAST FURNACE**



(57) **Abrégé/Abstract:**

A method for operation of a blast furnace able to greatly reduce the CO₂ emission and enabling stable production of pig iron over a long period of time in a commercial blast furnace, that is, a method for operation of a blast furnace in which iron ore and coke are charged from a furnace top and is blown in pulverized coal from a usual tuyere, comprising blowing in a gas containing at least one of hydrogen and hydrocarbon from the usual tuyere together with the pulverized coal and blowing a gas comprised of a top gas of the blast furnace from which carbon dioxide and steam is removed from a shaft tuyere into the blast furnace.

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ABSTRACT

A method for operation of a blast furnace able to greatly reduce the CO₂ emission and enabling stable
5 production of pig iron over a long period of time in a commercial blast furnace, that is, a method for operation of a blast furnace in which iron ore and coke are charged from a furnace top and is blown in pulverized coal from a usual tuyere, comprising blowing in a gas containing at least one
10 of hydrogen and hydrocarbon from the usual tuyere together with the pulverized coal and blowing a gas comprised of a top gas of the blast furnace from which carbon dioxide and steam is removed from a shaft tuyere into the blast furnace.

METHOD FOR OPERATION OF BLAST FURNACE

Technical Field

[0001] The present invention relates to a method for
5 operation of a blast furnace. In particular, it relates to a
method for operation of a blast furnace relating to (1)
blowing a gas with a high hydrogen content from a usual
tuyere, (2) blowing a top gas from the usual tuyere or a
tuyere provided at a middle stage of the furnace, and (3)
10 blowing a gas with a high hydrogen content and a top gas
from the usual tuyere during which making an oxygen
enrichment of the blown gas 10% to 40%.

Background Art

[0002] Production of hot metal in a blast furnace
15 requires a carbonaceous material such as coke, but reduction
of the amount of consumption of the carbonaceous material
per ton of hot metal (below, called the "reducing agent
rate") is a major objective for reducing manufacturing costs
and has been pursued in the past.

[0003] For example, PLT 1 has the objective of reducing
20 costs by increasing as much as possible the amount of
consumption of small coal which was unable to be used in
conventional blast furnace operations. PLT 1 discloses a
method for operation of a blast furnace comprising blowing
25 gas with an oxygen concentration of 40% or more from a
tuyere at ordinary temperature, and the method comprises
blowing the part of the pulverized coal containing +2 mm
coarse grain coal in 5 to 30% and having a maximum grain
size of 5 mm in the pulverized coal from the tuyere or near
30 the tuyere into the furnace. Further, PLT 2 adjusts the
ratio of the top gas blown from the blast furnace shaft
tuyere and the top gas blown from the bottom tuyere to

thereby match the amount of heat demand to the amount of heat supply of the blast furnace in the optimal state and enables remarkable improvement of the coke consumption and the charging efficiency over the known values. Further, PLT 5 3 discloses a method for operation of a blast furnace blowing fuel gas together with pulverized coal from a tuyere of the blast furnace to thereby secure the combustibility of the pulverized coal and improve the productivity and reduce the fuel cost (synonymous with reducing agent rate).

10 Further, PLT 4 has the objective of stable, high productivity blast furnace operation and discloses a method for operation of a blast furnace blowing a gas with an oxygen concentration of 30% to less than 100% from the tuyere and blowing preheated gas from a shaft part at a 15 middle stage of the blast furnace so thereby enable use of a large amount of pulverized coal.

[0004] Various technical innovations such as those explained above have enabled a remarkable improvement in the operating efficiency and led to the consumption of 20 carbonaceous materials per ton of hot metal of a level below 500 kg.

[0005] In addition to such reduction of the reducing agent rate in blast furnace operation and other improvements of the manufacturing cost, in recent years, reduction of 25 emissions of carbon dioxide (CO₂), one of the hothouse gases mainly causing global warming, has become widely sought. The steel industry, one of the main industries related to CO₂ emissions, has to respond to such social demands. Further reduction at blast furnace operations, which use large 30 amounts of carbonaceous materials for iron and steel manufacture, is becoming urgent. The Japanese steel industry has established voluntary action targets to tackle reduction

of CO₂ emissions, but is being pressed to develop new technologies with eye to the future.

[0006] However, none of PLTs 1 to 4 has reduction of CO₂ emissions as their main objectives. They do not sufficiently function to fundamentally cut the amount of generation of CO₂. In this way, so long as based on existing operating methods, even if viewed in terms of heat efficiency, the situation now is that no further room can be found for major reduction in the carbon consumption.

[0007] In view of such a situation, work on developing technology aiming at a major reduction in the carbon consumption in a blast furnace operations has been proceeding in Europe. That is, in the so-called "ULCOS" project, a blast furnace process based on an oxygen blast furnace combining CO₂ separation and recovery techniques, separating CO₂ from the top gas, reheating it, and re-blowing it into the furnace from a tuyere newly provided at the side wall of the furnace body at the middle stage of the blast furnace or from the usual tuyere is being developed (NPLT 1).

[0008] FIG. 1 shows the flow of the above ULCOS blast furnace process. It is a process flow considered to be the highest for the effect of reduction of the carbon consumption of a blast furnace. The most different features from ordinary blast furnace operation are (1) the point of not using hot air for blast from the usual tuyere but blowing oxygen and pulverized coal at room temperature, (2) blowing top gas into the blast furnace after separating CO₂ from all of the top gas to create "closed gas recycling", and (3) heating recycled gas of the top gas to a high temperature at a time when blowing it from the usual tuyere. Further, in the flow of the blast furnace process of FIG. 1,

the indirect reduction degree of ore is a high 89.7%. A 28% reduction ratio of carbon is achieved for the 289 kg/tHM of the amount of carbon (C) charged per ton of hot metal (1 tHM) at the time of normal operation. Further, the CO₂ is
5 separated from the top gas by the vacuum pressure swing adsorption method. The "vol" in FIG. 1 shows the amount of gas in the standard state.

[0009] These features pose serious risks when applied to commercial blast furnaces. That is, the above (1) requires
10 that a large amount of pulverized coal is injected in so as to maintain the temperature of the combustion zone in front of the tuyere at a suitable value. According to a report of the ULCOS project, the pulverized coal rate (consumption of pulverized coal per ton of hot metal) has reached 300 kg/tHM
15 and, as a result, the coke rate has fallen to 200 kg/tHM to less. With the current level of art of blast furnace operations which are only demonstrated at a generally 270 kg/tHM or more coke rate, it is not possible to easily create a stable operating state. In addition, since the
20 oxygen is blown at room temperature, no sensible heat is input by the blown gas. Therefore, even if trouble occurs in operation causing the furnace to cool, the inside of the furnace cannot be quickly heated and it is difficult to restore operation. Further, the "closed gas recycling"
25 operation of (2) has the risk of trace elements contained in the gas phase (for example, sulfur content etc.) being recycled and concentrating in the blast furnace process. There is a question as to whether stable operation can be maintained over a long period of time.

[0010] In this way, the blast furnace process aimed at by
30 the ULCOS project would be hard to apply to a commercial blast furnace wherein hot metal production is required to be continued stably over a long period of time even if

realization were possible on a short time test operation basis.

5 **[0011]** On the other hand, there is the method for cutting the carbon consumption by assigning hydrogen the reducing capacity that is one of the roles of carbon in blast furnace operation. That is, this is an operation blowing natural gas or coke oven gas (below, called "COG") or other reducing gas containing hydrogen into the blast furnace. There are a large number of inventions relating to such an operation method, but in particular the method for modifying the mixed 10 gas of CO₂ and CO separated from the top gas to methane (CH₄) and again blowing the modified gas to the blast furnace for the purpose of reducing CO₂ emissions of blast furnaces has been disclosed (PLT 5).

15 **[0012]** This method separates and recovers CO₂ (and/or CO) from the top gas, adds H₂ to this to convert it to CH₄, then again blows this into the blast furnace, but there are issues such as the new need for a CH₄ conversion apparatus and the fact that if just blowing in CH₄, carbon consumption 20 of the blast furnace cannot be sufficiently reduced. It cannot be said that the social demand for reduction of CO₂ emissions explained at the start can be sufficiently met.

Citation List

Patent Literature

25 **[0013]** PLT 1. Japanese Patent Publication No. H05-86444B2
PLT 2. Japanese Patent Publication No. S52-32323B2
PLT 3. Japanese Patent Publication No. H05-179323A
PLT 4. Japanese Patent Publication No. S63-57704A
PLT 5. Japanese Patent Publication No. 2011-225969A

Nonpatent Literature

[0014] NPLT 1. "Final Evaluation of the Ulcos TGR-BF Pilot Tests Performed at the LKAB Experimental Blast", Pettrsson Mikael, Silkstrom Peter, Eklund Nicklas, *Proceedings of 6th ICSTI* (2012), p. 960

Summary of Invention

Technical Problem

[0015] Greatly reducing the carbon consumption of a blast furnace in the range of the existing operating technology is important. Further, provision of a method for operation of a blast furnace which can be quickly restarted even if trouble occurs causing the furnace to cool down and which enables stable production of hot metal without the risk of trace elements being recycled and condensed in the blast furnace process has become a goal. An object of the present invention is to provide a method for operation of a blast furnace able to greatly reduce CO₂ emissions and enabling production of hot metal stably over a long period in a commercial blast furnace.

Solution to Problem

[0016] The inventors etc. discovered that by blowing CH₄-containing gas with a high hydrogen content from a usual tuyere, blowing a top gas from which oxide components and H₂O have been removed from a tuyere provided at a middle stage of the furnace (below, referred to as a "shaft tuyere"), and blowing CH₄-containing gas with a high hydrogen content and top gas from which oxide components and H₂O have been removed from the usual tuyere with making an oxygen enrichment of the blast from the usual tuyere 10% to 40%, it is possible to greatly reduce CO₂ emissions and operate the blast furnace stably over a long time. Further,

the "usual tuyere" is the tuyere provided at the lower stage of the furnace at the side below the shaft tuyere to blow pulverized coal or other auxiliary fuel together with hot air into the blast furnace.

5 **[0017]** The present invention was made based on this finding so as to solve the above problem and has as its gist the following:

10 **[0018]** (1) A method for operation of a blast furnace in which iron ore and coke are charged from a furnace top and pulverized coal is injected from a usual tuyere, comprising blowing in a blast containing at least one of hydrogen and hydrocarbon from the usual tuyere together with the pulverized coal and

15 blowing a gas comprised of a top gas of the blast furnace from which carbon dioxide and steam are removed from a shaft tuyere into the blast furnace.

20 (2) The method for operation of a blast furnace according to (1) further comprising blowing blast comprised of top gas of the blast furnace from which carbon dioxide and steam are removed from the usual tuyere into the blast furnace.

25 (3) The method for operation of a blast furnace according to (1) or (2) wherein the blast from the usual tuyere is enriched with oxygen by an oxygen enrichment of not less than 10% and not more than a Y% shown in the following formula:

$$Y=0.079 \times CH_4 + 32$$

(where, CH₄ indicates a vol% of methane in the gas blown into from the usual tuyere)

30 (4) The method for operation of a blast furnace according to any one of (1) to (3) wherein a blowing rate of the gas

containing at least one of hydrogen and hydrocarbon is 30 Nm³/tHM or more.

5 (5) The method for operation of a blast furnace according to any one of (1) to (4) wherein the top gas blown into from the shaft tuyere is blown in from the shaft tuyere and a blowing rate of 400 Nm³/tHM or less at a temperature of 600°C to 1000°C.

10 (6) The method for operation of a blast furnace according to any one of (1) to (5) wherein the blowing rate of top gas blown into from the shaft tuyere is 100 Nm³/tHM or more.

(7) The method for operation of a blast furnace according to any one of (1) to (6) wherein the gas containing at least one of hydrogen and hydrocarbon blown in from the usual tuyere contains methane.

15 (8) The method for operation of a blast furnace according to (7) wherein the gas containing methane includes at least one of coke oven gas and natural gas.

[0018a] The present invention further provides a method for operation of a blast furnace in which iron ore and coke are charged from a furnace top and pulverized coal is injected from a usual tuyere at a lower stage of the furnace, comprising: blowing a blast containing at least one of hydrogen and hydrocarbon from said usual tuyere together with said pulverized coal; blowing a gas comprised of a first part of a top gas of the blast furnace from which carbon dioxide and steam are removed from a shaft tuyere into the blast furnace; blowing a second part of said top gas from the usual tuyere without heating the second part thereof; and raising an oxygen enrichment of the blast blown from the usual tuyere. The top gas blown from the

20
25
30

shaft tuyere is blown from the shaft tuyere by a blowing rate from 100 to 400 Nm³/tHM. The blast from the usual tuyere is enriched with oxygen by an oxygen enrichment of not less than 10 vol% and not more than a Y vol% shown in the following formula: $Y=0.079 \times CH_4 + 32$, where CH₄ indicates a vol% of methane in the blast blown into from the usual tuyere.

Advantageous Effects of Invention

[0019] A method for operating a blast furnace to greatly reduce CO₂ emissions and to produce hot metal stably over a long period in a commercial blast furnace is provided.

Brief Description of Drawings

[0020] FIG. 1 is a view showing a flow of a ULCOS blast furnace process.

FIG. 2 is a view showing the relationship between the consumption of gas blown from a usual tuyere (COG and natural gas) (Nm³/tHM) and the carbon consumption (kg/tHM).

FIG. 3 is a view showing a (Requirement A + Requirement B) process in brief.

FIG. 4 is a view showing the change in the carbon consumption (kg/tHM) associated with blowing a recycled gas from a shaft tuyere at the time of making COG consumption blown from a usual tuyere 95 (Nm³/tHM) in the (Requirement A + Requirement B) process.

FIG. 5 is a view showing the carbon consumption (kg/tHM) at the time of additionally blowing in any one of pulverized coal, COG, or natural gas from a usual tuyere into a blast furnace operating in a standard manner with no Requirement B and the carbon consumption (kg/tHM) at the time of additionally blowing in any one of pulverized coal, COG, or natural gas from a usual tuyere in a (Requirement A + Requirement B) process.

FIG. 6 is a view showing a summary of a (Requirement A + Requirement B + Requirement C) process.

FIGS. 7 are views showing the relationship among the operation indices of a blast furnace in the case of making the COG consumption blown from a usual tuyere a value of 95 (Nm³/tHM) in the (Requirement A + Requirement B + Requirement C) process. FIG. 7A shows the relationship between the oxygen enrichment and carbon consumption (kg/tHM). FIG. 7B shows the relationship between the oxygen enrichment and coke rate (kg/tHM) and the relationship between the oxygen enrichment (%) and blowing rate of recycled gas from a usual tuyere (Nm³/tHM). FIG. 7C shows the relationship between the oxygen enrichment and the recycled gas ratio of top gas (%).

FIGS. 8 are views showing the relationship among the operation indices of a blast furnace in the case of making the natural gas consumption blown from a usual tuyere a value of 95 (Nm³/tHM) in the (Requirement A + Requirement B + Requirement C) process. FIG. 8A shows the relationship

between the oxygen enrichment and carbon consumption (kg/tHM). FIG. 8B shows the relationship between the oxygen enrichment and coke rate (kg/tHM) and the relationship between the oxygen enrichment (%) and blowing rate of recycled gas from a usual tuyere (Nm^3/tHM). FIG. 8C shows the relationship between the oxygen enrichment and the recycled gas ratio of top gas (%).

FIG. 9 is a graph showing the relationship between the COG amount and carbon consumption in the case of changing the blowing rate of COG blown from a usual tuyere, further blowing top gas from the usual tuyere without heating the top gas in the Requirement C process, and increasing the oxygen enrichment of blast from the usual tuyere in the (Requirement A + Requirement B) process.

FIG. 10 is a graph showing the relationship between the rate of natural gas and carbon consumption in the case of changing the amount of natural gas blown from a usual tuyere, further blowing top gas from the usual tuyere without heating the top gas in the the Requirement C process, and increasing the oxygen enrichment of blast from the usual tuyere in the (Requirement A + Requirement B) process.

Description of Embodiments

[0021] In order to reduce CO_2 emissions in the process of production of hot metal, it is necessary to reduce the carbon charge required for production of hot metal in a blast furnace. As explained above, the main role of carbon in a blast furnace is the supply of the heat for reducing and melting the iron ore (below, "iron ore" used as a general term for sintered ore, pellets obtained by agglomerating iron ore, or other iron source materials). In the present invention, the carbon consumption is reduced by

replacing the carbon reducing agent with hydrogen for part of the reduction.

5 [0022] However, in blast furnace operation which reduces and melts iron ore at a high temperature field in the furnace which is autonomously formed by only charging raw materials from the top and a blast operation from a usual tuyere, with simply blowing gas having a high hydrogen content from the usual tuyere, it is not easy to maintain stable hot metal production. On top of this, it is difficult to realize a fundamental cut in the carbon consumption.

10 [0023] Therefore, the inventors focused on adding the following element technologies to existing blast furnace operation technology so as to overcome the above problems. That is, they focused on the following requirements (A) to (C):

15 (A) Blowing in gas containing at least one of hydrogen and hydrocarbon from a usual tuyere.

20 In gas reduction rate of an ore, H_2 gas is superior to even CO gas. Gas containing at least one of CH_4 or other hydrocarbons containing a large amount of hydrogen and hydrogen is blown into the blast furnace as much as possible.

25 (B) Heating top gas from which CO_2 and other oxide components and steam (H_2O) have been removed and blowing it from a shaft tuyere.

30 Top gas wherein a ratio of gas having a reduction ability is high is produced by removing the oxide components and steam from the top gas, and the produced top gas is reutilized. By heating the produced top gas to a suitable temperature and again blowing it from a shaft tuyere into the inside of the blast furnace (below, referred to as "top

gas recycling"), it is possible to improve the rate of utilization of the furnace reducing gas.

Further,

5 (C) Blowing top gas from the usual tuyere without heating the top gas and increasing the oxygen enrichment of blast from the usual tuyere.

[0024] When blowing top gas from the usual tuyere, it is important to maintain the theoretical temperature of the gas generated due to the combustion in the combustion zone in front of the tuyere (below, referred to simply as the "flame temperature") in a suitable range. For this reason, it is preferable to not heat the top gas and make the oxygen enrichment of the blast from the usual tuyere 10% to 40%. As a result, it is possible to maintain the flame temperature within a suitable range while increasing the reducing gas component in the furnace gas. Further, it is no longer necessary to increase the injecting rate of pulverized coal for adjusting the flame temperature and is possible to avoid an extreme drop in the coke rate.

20 **[0025]** Note that, the value X of the oxygen enrichment (%) indicates the concentration of oxygen enriched from the normal blast. For example, the amount of oxygen concentration enriched from usual blast (air (oxygen concentration approximately 21%)) is expressed by the following formula:

$$X(\%) = (0.21 \times V_b / 60 + V_o / 60) / (V_b + V_o / 60) \times 100 - 21$$

where V_o : oxygen flow rate (Nm^3/h)

V_b : Total blowing rate from usual tuyere including flow rate of top gas (Nm^3/min)

30 Here, productivity of a blast furnace directly depends on the rate of oxygen blown into the blast furnace (referred to as

the "rate of blown oxygen"). When making the oxygen enrichment rise under the condition that productivity is kept constant, to make the rate of blown oxygen constant, the general practice is to adjust the blowing rate downward.

5 **[0026]** Further, the upper limit value of the oxygen enrichment is restricted by the presence or absence of erosion of the lance and also changes by the composition of the gas blown. That is, the composition of the gas blown causes the upper limit (Y%) of the oxygen enrichment leading
10 to erosion of the lance due to a temperature rise to differ. The fact that this is generally proportional to the content of CH₄ with respect to the composition of gas of the cooling medium in the gas and that this relationship is expressed by the following formula was confirmed by the inventors etc.

15
$$Y=0.079\times\text{CH}_4+32$$

where, Y: upper limit of oxygen enrichment (%)

CH₄ in the formula: vol% of methane contained in the gas blown into

Further, if making the oxygen enrichment excessive, not only
20 is there the possibility of erosion of the lance liable to occur, but also the focus of combustion in the raceway excessively moves to the wall side, insufficient heat conduction to the deadman or increasing heat loss at the wall side is invited, and the effect of the charged material
25 also becomes unstable. By applying the above requirements, it is possible to achieve the object of the present invention.

Examples

30 **[0027]** Next, examples of the present invention will be explained, but the present invention is not limited to these.

[0028] The blast furnace operation was simulated based on blast furnace numerical analysis to study the effects of the present invention. For such simulation, for example, the so-called "blast furnace mathematical model" shown in K. Takatani, T. Inada, and Y. Ujisawa, *ISIJ International*, 39, (1999), p. 15 etc. was used.

[0029] Example 1

In Example 1, first, the inventors investigated in detail the above Requirement A "blowing gas containing at least one of hydrogen and a hydrocarbon from a usual tuyere".

[0030] Table 1 shows the standard parameters at the time of operation of the blast furnace (furnace volume 5300 m³) wherein pulverized coal is injected from the usual tuyere. Consider an operation of blowing CH₄-containing gas with a high hydrogen content. If making CH₄ rise in temperature to 800°C or more, it breaks down under the heat whereby hydrogen gas is generated and the hydrogen gas functions as a reducing agent, so the effect of cutting the carbon consumption is obtained.

[0031] The CH₄-containing gas contains not only hydrogen, but also a large amount of hydrogen in the state of CH₄ or other hydrocarbons, so it is possible to provide it with the function of the reducing material. At this time, the CH₄ concentration is preferably 25% or more. The reason is that if the CH₄ concentration is less than 25%, even if increasing the oxygen enrichment, combustion in the tuyere-front combustion zone causes a drop in the function of adjusting the flame temperature and the effect of the Requirements (B) and (C) on raising the rate of utilization of the furnace reducing gas becomes insufficient.

[0032] As the CH₄-containing gas, it is possible to employ COG with a high hydrogen content, natural gas with a

high CH₄ content, or city gas or shale gas and synthetic gas containing any ratio thereof and other existing gases containing CH₄. The composition of COG changes depending on the treatment of waste gas and the operating conditions of the coke oven and differs with each steel plant. The range of composition is generally CH₄: 25 to 38% and H₂: 47 to 59%.

[0033] Table 1

Production*	11350 t/d	Blast volume	7650 Nm ³ /min
Hot metal temperature*	1520°C	Blast temperature*	1200°C
Coke rate	340 kg/tHM	Oxygen enrichment	3.40%
Pulverized coal rate*	146 kg/tHM	Blast moisture	25 g/Nm ³
Reducing agent rate	486 kg/tHM	Flame temperature*	2155°C
Carbon consumption	419 kg/tHM		

(* marked items are treated as fixed values in subsequent simulation of operation)

[0034] In this regard, to reduce and melt iron ore, the inside of the blast furnace is held at a high temperature under a reducing atmosphere. If blowing COG or natural gas or other CH₄-containing gas into this, the hydrocarbon content is pyrolyzed under heat and soot dust is generated. There is a danger of the soot filling the voids among the filler particles of the lumpy coke and other carbon sources and sintered ore clumps and therefore lowering the gas permeability inside the furnace. Therefore, it is preferable to blow the above-mentioned gases into the only region where an oxidizing atmosphere is formed in the blast furnace, that is, the combustion region in front of the usual tuyere. That is, it is desirable to blow in COG or natural gas or other CH₄-containing gas from the usual tuyere along with hot gas or pulverized coal.

[0035] The composition of COG or natural gas differs somewhat depending on the starting material of coal or on the production area, but in the simulation of operation, the contents shown in Table 2-1 and Table 2-2 as typical values were used. Further, the operating parameters were predicted by calculation using the method of making the pulverized coal rate constant and adjusting the coke rate and blowing rate so as to give productivity and hot metal temperatures shown in Table 1. Further, this is based on the premise that the flame temperature, which is considered to be important experience-wise in design of operations, is maintained constant by adjusting the oxygen enrichment.

[0036] Table 2-1

	CH ₄ (vol%)	H ₂ (vol%)	CO (vol%)	N ₂ (vol%)
Composition of coke oven gas (COG)	37	48	12	3
Composition of natural gas	100	0	0	0

15 Table 2-2

	Carbon (wt%)	Hydrogen (wt%)
Composition of pulverized coal	82	4

[0037] The relationship between the consumption of gas (COG and natural gas) blown from the usual tuyere (Nm³/tHM) and the carbon consumption (kg/tHM) was obtained by simulation of blast furnace operation under the conditions of Table 2-1 and Table 2-2. This relation is shown in FIG. 2. Here, the carbon consumption (kg/tHM) means the specific consumption of the amount of carbon, that is, the amount of carbon charged or blown through coke, pulverized coal, COG,

or natural gas per ton of hot metal. It is an amount directly connected with the CO₂ emissions accompanying production of hot metal. According to this figure, it will be understood that the carbon consumption decreases in accordance with the increase in COG consumption or natural gas consumption. This is because the hydrogen contained in a large amount in COG or natural gas contributes to reduction of the iron ore and the required amount of carbon is kept down.

10 **[0038]** In Example 1, furthermore, the inventors investigated in detail operation of a blast furnace comprising the above Requirement A and further the above Requirement B "heating top gas from which the oxide components and steam have been removed and blowing it in
15 from the shaft tuyere".

[0039] FIG. 3 shows the (Requirement A + Requirement B) process in brief. The main components of the top gas exhausted from the top of the blast furnace are CO, CO₂, H₂, N₂, and H₂O (steam), but the steam is removed by the cooling
20 in the existing process of the treatment for cleaning the exhaust gas. On the other hand, CO₂ remains in the top gas, but if removing this, the reduction ability of the top gas on the ore is greatly restored. Technology for separating and recovering CO₂ from gas has already been developed, so
25 it is sufficient to introduce the existing technology for separating and removing CO₂ into the blast furnace process system to thereby perform the (Requirement A + Requirement B) process.

[0040] It is also possible to blow in high temperature gas with a high hydrogen content from the shaft tuyere in
30 addition to the top gas from which the oxide components and H₂O have been removed. COG is readily available in steel

plants, so it is preferable to use COG. However, if blowing CH₄ from the shaft tuyere, soot precipitates and reduction of the iron ore is inhibited, so it is preferable to blow COG which has been modified in CH₄ content etc. The
5 composition of the modified COG is, for example, H₂: 68%, CH₄: 5%, C₂H₄: 1%, CO: 17%, N₂: 2%, and H₂O: 7%. In order to secure the reduction ability of top gas blown from the shaft tuyere, the temperature of the gas is preferably made 750°C or more. Furthermore, in order to raise the ratio of the
10 component having the reduction ability, it is preferable to blow modified COG after removing the moisture.

[0041] In order to investigate the advantageous effect of the (Requirement A + Requirement B) process, the inventors ran a simulation predicting the effect of blowing top gas
15 after removal of CO₂ and H₂O from the shaft tuyere under conditions of injecting pulverized coal from the usual tuyere and blowing COG or natural gas. Here, it is advantageous to set the position at which the top gas after removal of CO₂ and H₂O is blown into the blast furnace to
20 the location where gas reduction progresses actively. This position was set to a position corresponding to the furnace temperature 1100°C calculated at the time of normal operation shown in Table 1. Existing blast furnaces do not have apertures which gas is blown into at such that
25 location, so a shaft tuyere is newly provided.

[0042] The above simulation was performed by recycling top gas under the conditions of Table 3. In Table 3, "recycled gas" means recycled gas in the top gas recycling that is used for simulation. The predicted values of the
30 parameters at the time of operation were made the standard parameters in the same way as the case of Table 1.

[0043] Table 3

Recycling rate of top gas from shaft tuyere	0 to 30%
Blowing rate of recycled gas from shaft tuyere	100 to 600 Nm ³ /tHM
Blowing temperature of recycled gas from shaft tuyere	400 to 1000°C
Blowing rate of COG from usual tuyere	95 Nm ³ /tHM

[0044] FIG. 4 is a graph obtained by simulation of an operation of performing the top gas recycling under the conditions of Table 3 and shows the change in the carbon consumption (kg/tHM) accompanying an increase in the blowing rate of recycled gas from the shaft tuyere when fixing COG consumption blown from the usual tuyere at 95 (kg/tHM). As will be understood from FIG. 4, by increasing the blowing rate of recycled gas from the shaft tuyere, it is possible to cut the carbon consumption (kg/tHM). That is, the carbon content recharged into the furnace through the recycled gas is not the carbon charged from outside the blast furnace system, so the recycling of the top gas based on the present invention can raise the efficiency of utilization of the reducing gas and cut the carbon consumption(kg/tHM).

[0045] However, the effect of reduction of the carbon consumption of the blast furnace by the recycled gas tends to be saturated if the blowing rate of the recycled gas from the shaft tuyere excessively increases. This is understood to be due to the fact that even if increasing gas reducing rate in the furnace more than necessary, the speed of the reduction reaction of the iron ore cannot be kept up with. On the other hand, even in terms of the flow of material in the furnace, excessive reducing gas in the furnace raises

the risk of fluidization of the packed layer in the furnace or the increase in pressure drop resulting in the phenomenon of channeling. Therefore, to reliably obtain the effect of cutting the carbon consumption of a blast furnace and to ensure stable operation under the conditions for application of the present invention, it is preferable to make the lower limit of the blowing rate of recycled gas 100 Nm³/tHM and make the upper limit of the recycled gas rate 400 Nm³/tHM.

[0046] Furthermore, FIG. 4 shows the results of investigation of the blowing temperature of the recycled gas blown from the shaft tuyere to the inside of the furnace. According to FIG. 4, the higher the temperature of the recycled gas blown from the shaft tuyere is made, the higher the effect of reduction of the carbon consumption (kg/tHM). This is due to not only the effect of reutilization of the reducing gas, but also the effect of the increase of the amount of heat input to the blast furnace through the sensible heat of the recycled gas. However, what should be noted is the point that if the temperature of the recycled gas falls below about 600°C, almost no effect of reduction of the carbon consumption (kg/tHM) appears. This phenomenon is due to the fact that if excessively lowering the blowing temperature, the detrimental effect of both the temperature distribution in the blast furnace being remarkably lowered and the progression of the reduction reaction ending up being blunted becomes remarkable.

[0047] Therefore, in recycling top gas, the temperature when blowing recycled gas from the shaft tuyere to the inside of the blast furnace is preferably at least 600°C. Further, the upper limit temperature is preferably kept down to 1000°C or less where there is no danger of the iron ore

in the furnace softening-melting and the progression of gas reduction being obstructed.

[0048] To further investigate the advantageous effect of the (Requirement A + Requirement B) process, the inventors investigated a change in the carbon consumption (kg/tHM) in the case of blowing respectively sole pulverized coal, COG and pulverized coal, and natural gas and pulverized coal from the usual tuyere in the (Requirement A + Requirement B) process. First, they operated a blast furnace operated using a standard method under the parameters shown in Table 1 so as to respectively blow in COG, natural gas, and pulverized coal from the usual tuyere under the conditions of Table 4 so that rate of the reducing matter charged from the usual tuyere (total value of carbon C and hydrogen H₂) becomes substantially constant. The inventors compared the amount of reduction of the carbon consumption (kg/tHM) when recirculating the top gas from the shaft tuyere under conditions of 400 Nm³/tHM, 800°C. At this time, the inventors investigated the oxygen enrichment of blast for blowing the COG, natural gas, and pulverized coal from the usual tuyere into the inside of the blast furnace so that the flame temperature becomes constant.

[0049] Table 4

	Blowing rate (*)	Blowing rate of reducing matter	H ₂ content in reducing matter
Pulverized coal	84 kg/tHM	7.4 kmol/tHM	23 mol%
COG	95 Nm ³ /tHM	7.3 kmol/tHM	71 mol%
Natural gas	50 Nm ³ /tHM	6.7 kmol/tHM	67 mol%

(*): Blowing rate added to pulverized coal rate of 146

25 kg/tHM of Table 1

[0050] The results of the above operation are shown in FIG. 5. FIG. 5 shows the carbon consumption (kg/tHM) when additionally blowing any one of pulverized coal, COG, or natural gas from the usual tuyere into a blast furnace which is operated in a standard manner without the Requirement B and the carbon consumption (kg/tHM) when additionally blowing any one of pulverized coal, COG, or natural gas from the usual tuyere into a blast furnace which is operated in a standard manner in the (Requirement A + Requirement B) process. In FIG. 5, by combining the operation of blowing COG or natural gas of a high hydrogen content from the usual tuyere with the top gas recycling, the effect of reduction of the carbon consumption (kg/tHM) clearly appears. This effect is due to the characteristic that with respect to the reduction of iron ore, H₂ gas has a faster reaction speed than CO gas. The Requirement B utilizing this characteristic is shown to give rise to a special effect under the Requirement A.

[0051] In this way, the top gas recycling in the present invention exhibits special effects under the (Requirement A + Requirement B). That is, in an operation of blowing COG or natural gas with a high hydrogen content from the usual tuyere, the top gas recycling from the shaft tuyere is particularly effective for reducing the carbon consumption (kg/tHM).

[0052] Example 2

Next, the inventors studied the operation of a blast furnace further adding to the above (Requirement A + Requirement B) the Requirement C of "blowing top gas from the usual tuyere without heating and increasing the oxygen enrichment of blast".

[0053] FIG. 6 shows the (Requirement A + Requirement B + Requirement C) process in brief. The Requirement C of the present invention further promotes the reduction of the carbon consumption (kg/tHM) under the (Requirement A + Requirement B). By combining the Requirement C, it is possible to maintain combustion conditions of the tuyere-front combustion location of the blast furnace at a suitable range and reach a coke rate at a level capable of actual operation by existing operating technology.

[0054] As explained above, the upper limit value of the oxygen enrichment is restricted by the presence of erosion of the lance and changes due to the composition of the blast gas. In the case of the present example of only blowing COG containing CH₄: 37% from the tuyere, if the oxygen enrichment is 35%, the temperature of the outside of the lance excessively rises and invites erosion of the lance. On the other hand, in the case of the later explained Example 3 of blowing natural gas containing CH₄: approximately 100% from the tuyere, if the oxygen enrichment is 40%, erosion of the lance occurs. In this way, the upper limit (Y%) of the oxygen enrichment leading to erosion of the lance due to a temperature rise differs depending on the composition of the gas blown into. This is proportional to the content of CH₄ in the composition of the gas of the cooling medium in the gas. The relationship is represented by the following formula:

$$Y=0.079 \times \text{CH}_4 + 32$$

where, Y: upper limit of oxygen enrichment (%)

CH₄: vol% of CH₄ contained in gas blown into

[0055] The inventors ran operations for blowing COG-containing gas from the usual tuyere under the conditions shown in Table 5 and investigated the change in the carbon

consumption (kg/tHM) relating to the oxygen enrichment (10% to 35%) under the condition that a flame temperature is fixed. Further, a shaft tuyere was provided at the middle stage of the blast furnace, the blowing rate of recycled gas from the shaft tuyere was made 200 Nm³/tHM and 400 Nm³/tHM, and the blowing temperature of the recycled gas from the shaft tuyere was made 800°C. Further, the injecting rate of pulverized coal from the usual tuyere in this example was set in the same way as the value shown in Table 1.

10 [0056] Table 5

Blowing rate of COG (usual tuyere)	COG 95 Nm ³ /tHM
Blowing rate of recycled gas (shaft tuyere)	200 Nm ³ /tHM; 400 Nm ³ /tHM
Blowing rate of recycled gas (usual tuyere)	Rate required for maintaining flame temperature at 2155°C
Blowing temperature of recycled gas (shaft tuyere)	800°C
Blowing temperature of recycled gas (usual tuyere)	Ordinary temperature (25°C)
Oxygen enrichment (usual tuyere)	15 to 40%

[0057] FIGS. 7 are views showing the relationship among the operation indices of a blast furnace in the case of making COG consumption blown from the usual tuyere 95 (Nm³/tHM) in the (Requirement A + Requirement B + Requirement C) process under the conditions of Table 5. FIG. 7A shows the relationship between the oxygen enrichment (%) and carbon consumption (kg/tHM). The ratio of the N₂ (nitrogen) gas in the furnace gas falls along with an increase in the oxygen enrichment, while the concentration of the reducing components, that is, H₂ and CO increases, so

the effect of the top gas recycling operation of the Requirement B of the present invention is amplified. FIG. 7B shows the relationship between the oxygen enrichment (%) and coke rate (kg/tHM) and the relationship between the oxygen enrichment (%) and blowing rate recycled gas from the usual tuyere (Nm³/tHM). By blowing part of the recycled gas at an ordinary temperature from the usual tuyere in a suitable amount, it is possible to maintain the flame temperature without increasing the pulverized coal rate and possible to attain a coke rate of actual range capable of stable operation of 270 kg/tHM or more while cutting the carbon consumption (kg/tHM) of the blast furnace to about 380 kg/tHM. This corresponds to a reduction of approximately 9% with respect to the time of normal operation of Table 1.

[0058] FIG. 7C shows the relationship between the oxygen enrichment (%) and the recycled gas ratio of top gas (%). The recycled gas ratio (%) of the top gas means the volume ratio (%) of the blowing rate of reduced gas from the usual tuyere and shaft tuyere with respect to the total rate of top gas. Along with the increase of the oxygen enrichment, the blowing rate of reducing gas from the usual tuyere increases and the flame temperature is maintained constant (2155°C). Here, the present invention is not restricted in the coke rate level of the blast furnace operation.

[0059] Normally, in blast furnace operation, to secure the heat generation at the bottom of the furnace, the general practice is to adjust the blowing conditions so that the combustion temperature in front of the tuyere becomes a constant approximately 2155°C. If operating under conditions where the flame temperature falls, a drop in furnace heat and hot metal temperature is caused over a long term and tapping problems, cooldown, and other serious operational

trouble will be induced. In the operation for blowing COG or natural gas from the tuyere, the gas sensible heat introduced falls due to the endothermic reaction accompanying decomposition of the main component CH₄ and blowing of cooling air into the blast furnace, and the flame temperature falls.

[0060] To compensate for this, oxygen enrichment of blast is effective. Further, the main components of the top gas are CO and H₂, so the recycled gas of the top gas does not burn in front of the tuyere and is blown in by the cooling air, so the sensible heat of the introduced gas falls and the flame temperature falls. In this case as well, it is possible to raise the oxygen enrichment in accordance with the blowing rate of recycled gas to compensate for the heat. If raising the oxygen enrichment, in order to make productivity constant, the blowing rate is decreased and the charging rate of oxygen into the furnace is adjusted to become constant. As a result, along with the increase of the oxygen enrichment, the N₂ in the furnace gas is decreased and the concentration of the CO, H₂, or other reducing gas relatively rises. This leads to amplification of the effect of the top gas recycling operation of the Requirement B.

[0061] Example 3

FIGS. 8 show the relationship among the operation indices of a blast furnace in the case of making natural gas consumption blown from the usual tuyere 95 (Nm³/tHM) in the (Requirement A + Requirement B + Requirement C) process. Here, the operating conditions in the (Requirement A + Requirement B + Requirement C) process of FIG. 8 are shown in Table 6. Except for the blown gas changing from COG to natural gas, making the blowing rate of recycled gas from the shaft tuyere 400 Nm³/tHM and making the blowing

temperature 800°C, the conditions are the same as the conditions studied in Table 5.

[0062] Table 6

Blowing rate of natural gas (usual tuyere)	95 Nm ³ /tHM
Blowing rate of recycled gas (shaft tuyere)	400 Nm ³ /tHM
Blowing rate of recycled gas (usual tuyere)	Rate required for maintaining flame temperature at 2155°C
Blowing temperature of recycled gas (shaft tuyere)	800°C
Blowing temperature of recycled gas (usual tuyere)	Ordinary temperature (25°C)
Oxygen enrichment (usual tuyere)	15 to 40%

5 **[0063]** FIG. 8A shows the relationship between the oxygen
enrichment and the carbon consumption (kg/tHM). FIG. 8B
shows the relationship between the oxygen enrichment and
coke rate (kg/tHM) and the relationship between the oxygen
enrichment (%) and blowing rate of recycled gas from the
10 usual tuyere (Nm³/tHM). FIG. 8C shows the relationship
between the oxygen enrichment and the recycled gas ratio of
top gas (%). In this case, the blast furnace has to be
operated at a coke rate level of 250 kg/tHM or less, but by
making the oxygen enrichment up to 40%, it is possible to
15 cut the carbon consumption of the blast furnace down to
about 350 kg/tHM. This corresponds to a cut of approximately
15% with respect to the time of normal operation of Table 1.

[0064] Example 4

In Example 4, the inventors investigated the effect in the
20 case of changing the amount of COG or natural gas blown from

the usual tuyere in the (Requirement A + Requirement B) process and further blowing top gas from the usual tuyere without heating and increasing the oxygen enrichment of blast from the usual tuyere in the Requirement C process.

5 **[0065]** FIG. 9 shows an example of changing the rate of
COG blown from the usual tuyere into a blast furnace
adjusted in coke rate in the (Requirement A + Requirement B)
process so that the hot metal temperature does not fall
under 1520°C by the asterisked parameters of Table 1 so as
10 to realize a stable operating state of the blast furnace. As
shown in FIG. 9, when making the blowing rate of the top gas
recycling from the shaft tuyere 400 Nm³/tHM in the
Requirement B, no large improvement was seen in the carbon
consumption with a rate of COG blown from the usual tuyere
15 of less than 30 Nm³/tHM. This is due to the fact that the
rate of COG blown from the usual tuyere is too small and the
effect of amplification of H₂ recycling could not be
sufficiently exhibited. On the other hand, if making the
blowing rate of COG from the usual tuyere 30 Nm³/tHM or
20 more, the carbon consumption was greatly improved along with
an increase in the blowing rate of COG.

25 **[0066]** When making the oxygen enrichment of blast from
the usual tuyere increase up to 35% and simultaneously
making the rate of top gas blown from the usual tuyere 225
Nm³/tHM in the Requirement C, if the rate of COG blown from
the usual tuyere is less than 30 Nm³/tHM, in the same way as
the Requirement B, no large improvement could be seen in the
carbon consumption. This is due to the blowing rate being
too small and the effect of amplification of H₂ recycling
30 not being sufficiently exhibited. On the other hand, when a
rate of COG blown from the usual tuyere is 30 Nm³/tHM or
more, the carbon consumption could be greatly improved over

the (Requirement A + Requirement B) process in accordance with the increase in the blowing rate of COG. Note that, in each requirement, the more the blowing rate is made to increase, the more the carbon consumption can be lowered.

5 **[0067]** FIG. 10 shows an example changing the blowing rate of natural gas from the usual tuyere into a blast furnace adjusted in coke rate in the (Requirement A+Requirement B) process so that the hot metal temperature does not fall under 1520°C under the asterisked parameters in Table 1 for realizing a stable operating state. As with the case of blowing COG from the usual tuyere, when making the blowing rate of top gas recycling from the shaft tuyere 400 Nm³/tHM in the Requirement B, with a rate of natural gas blown from the usual tuyere of less than 30 Nm³/tHM, no large
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20
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improvement is seen in the carbon consumption. However, when increasing the oxygen enrichment of blast from the usual tuyere up to 40% and simultaneously making the rate of top gas blown from the usual tuyere 175 Nm³/tHM in the Requirement C, if making the rate of natural gas blown from the usual tuyere 30 Nm³/tHM or more, the carbon consumption was greatly improved along with an increase in the blowing rate. Note that, the rate of use of natural gas is not limited, but a rise in manufacturing cost is invited, so it is possible to set the rate of use of natural gas in the range giving a predetermined effect.

[0068] As explained above, in the future, if operating technology is improved and the minimum coke rate level which enables stable operation further falls, it will become possible to more positively apply the present invention (to a raise in the oxygen enrichment) and to greatly reduce the carbon consumption of the blast furnace. Note that, preferred embodiments of the present invention were
30

explained, but the present invention is not limited to these examples. It is clear to a person having ordinary skill in the technical field to which the present invention belongs that various changes or alterations could be made within the technical idea described in the claims. These will also naturally be understood as falling in the technical scope of the present invention.

Industrial Applicability

[0069] According to the present invention, it is possible to provide a method for operation of a blast furnace able to reduce CO₂ emissions and produce hot metal in a commercial blast furnace stably over a long period.

CLAIMS

Claim 1. A method for operation of a blast furnace in which iron ore and coke are charged from a furnace top and pulverized coal is injected from a usual tuyere at a lower stage of the furnace, comprising:

blowing a blast containing at least one of hydrogen and hydrocarbon from said usual tuyere together with said pulverized coal;

blowing a gas comprised of a first part of a top gas of the blast furnace from which carbon dioxide and steam are removed from a shaft tuyere into the blast furnace;

blowing a second part of said top gas from the usual tuyere without heating the second part thereof; and

raising an oxygen enrichment of the blast blown from the usual tuyere,

wherein said top gas blown from the shaft tuyere is blown from said shaft tuyere by a blowing rate from 100 to 400 Nm³/tHM, and

wherein said blast from the usual tuyere is enriched with oxygen by an oxygen enrichment of not less than 10 vol% and not more than a Y vol% shown in the following formula:

$$Y=0.079 \times CH_4 + 32,$$

where CH₄ indicates a vol% of methane in the blast blown into from the usual tuyere.

Claim 2. The method for operation of a blast furnace according to claim 1, further comprising blowing a gas comprised of the second part of the top gas of the blast furnace from which carbon dioxide and steam are removed from the usual tuyere into the blast furnace.

Claim 3. The method for operation of a blast furnace according to claim 1 or 2, wherein a blowing rate of the

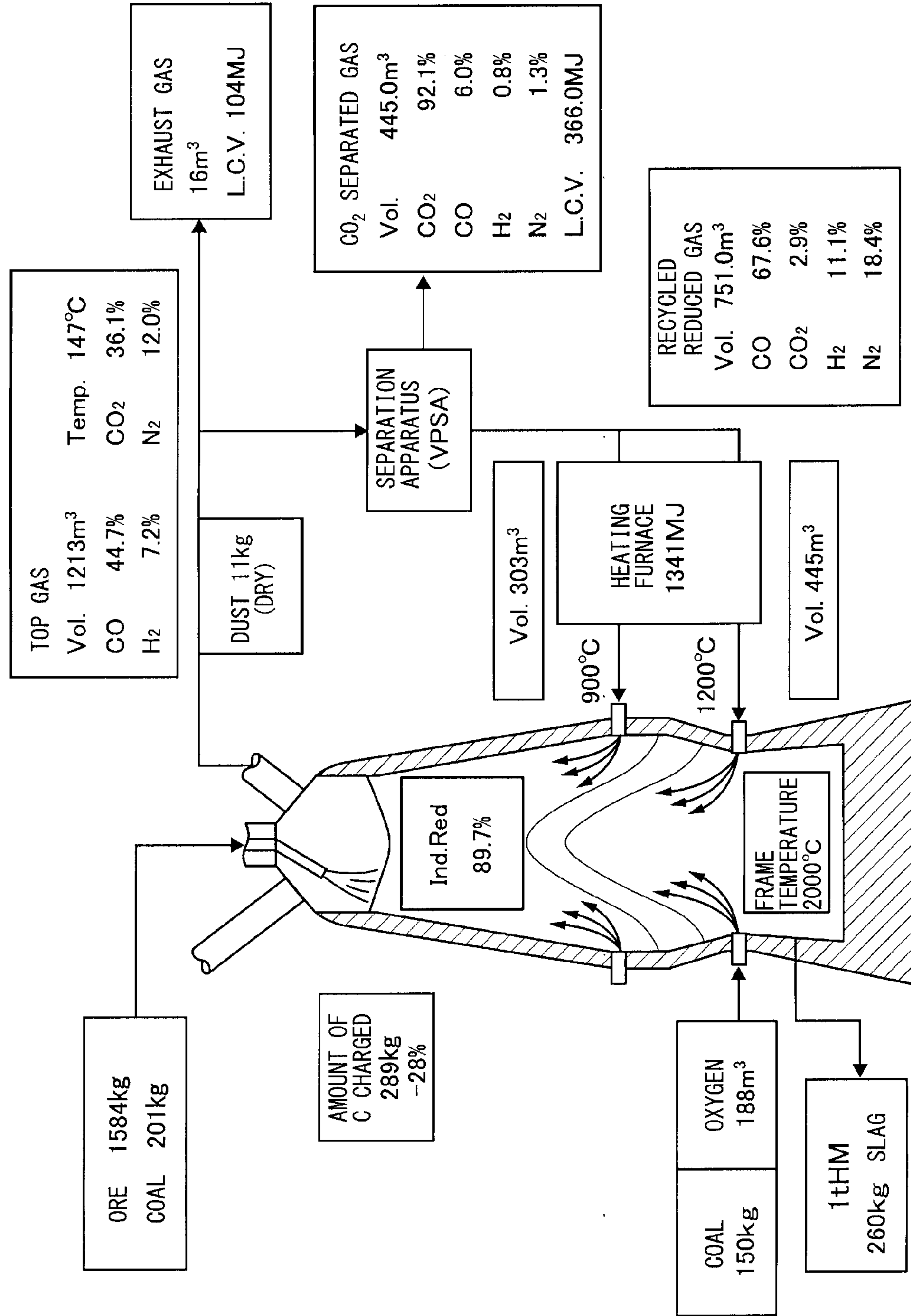
blast containing at least one of hydrogen and hydrocarbon is
30 Nm³/tHM or more.

5 Claim 4. The method for operation of a blast furnace
according to any one of claims 1 to 3, wherein said top gas
blown from the shaft tuyere is blown from said shaft tuyere
at a temperature of 600°C to 1000°C.

10 Claim 5. The method for operation of a blast furnace
according to any one of claims 1 to 4, wherein the blast
containing at least one of hydrogen and hydrocarbon blown
from said usual tuyere contains methane.

Claim 6. The method for operation of a blast furnace
according to claim 5, wherein the blast containing methane
includes at least one of coke oven gas and natural gas.

FIG. 1 (PRIOR ART)



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FIG. 2

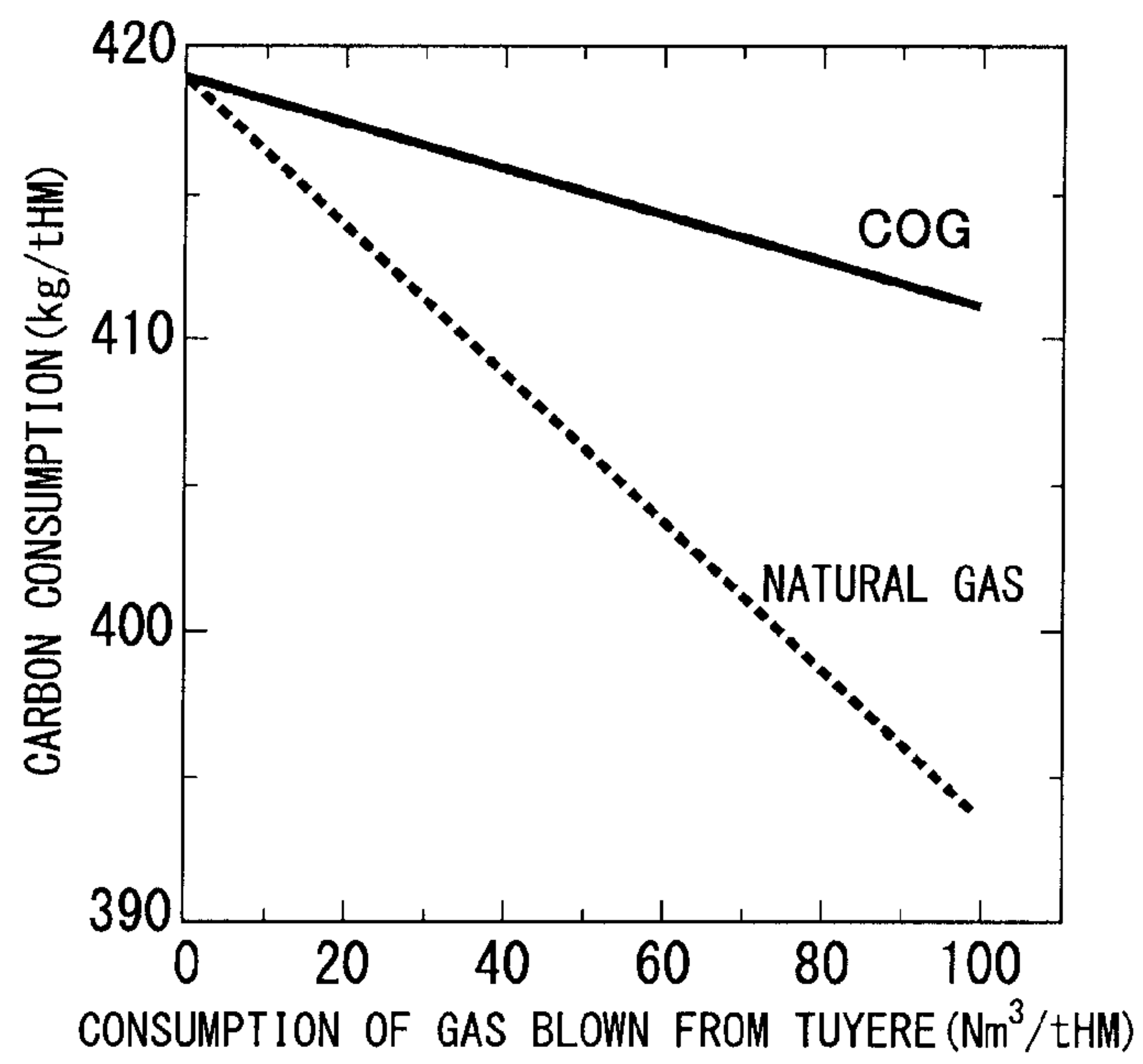
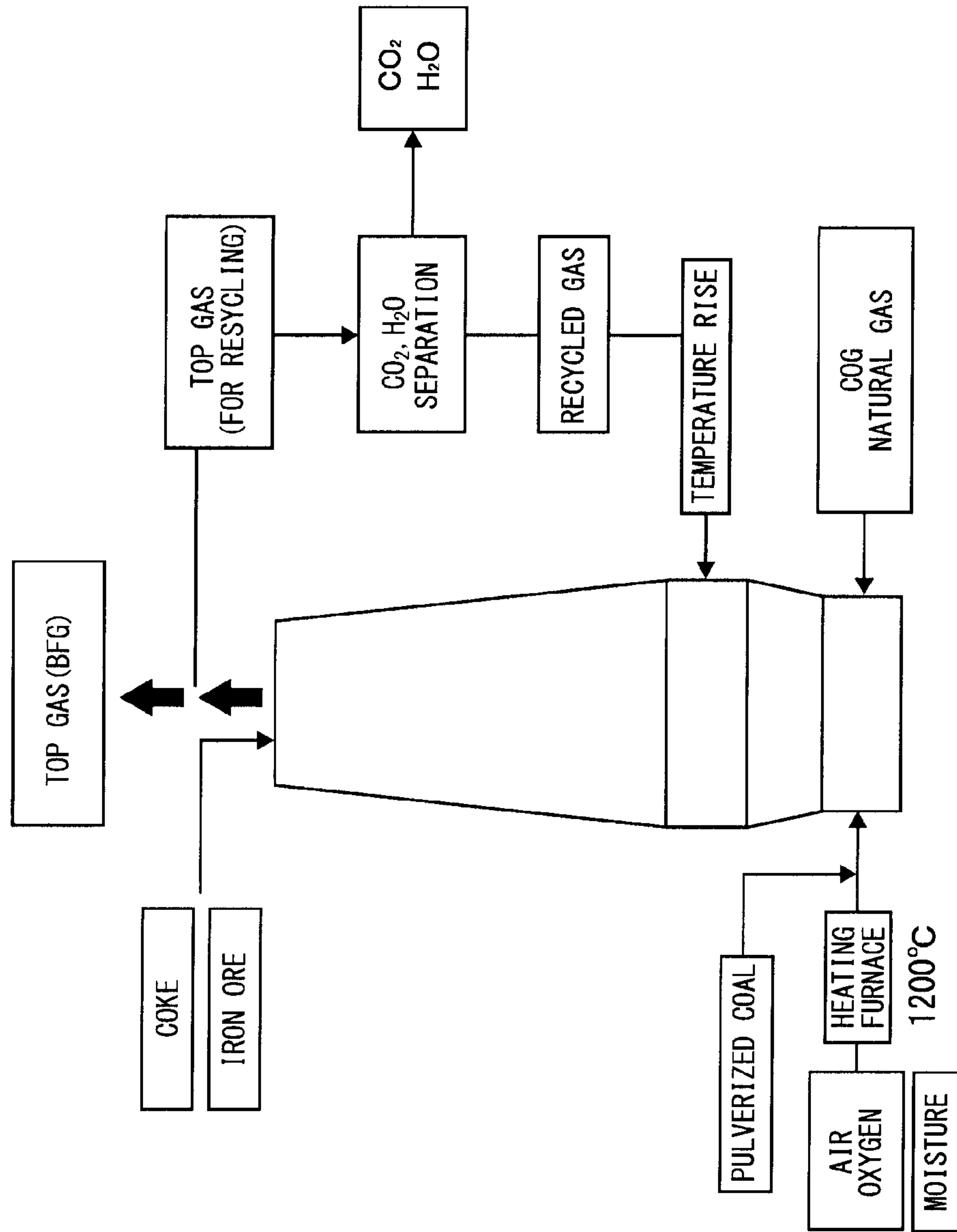
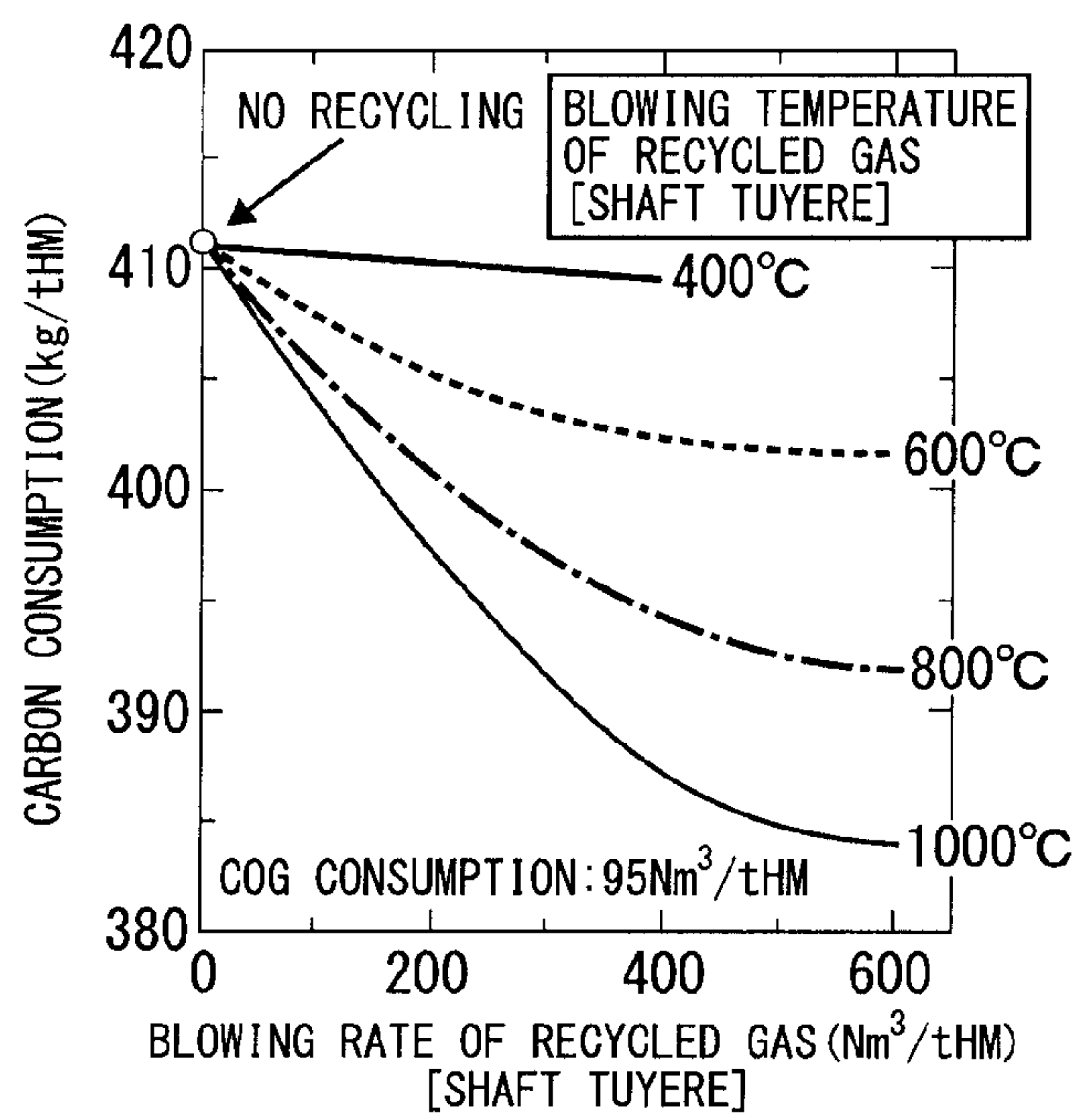


FIG. 3



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FIG. 4



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FIG. 5

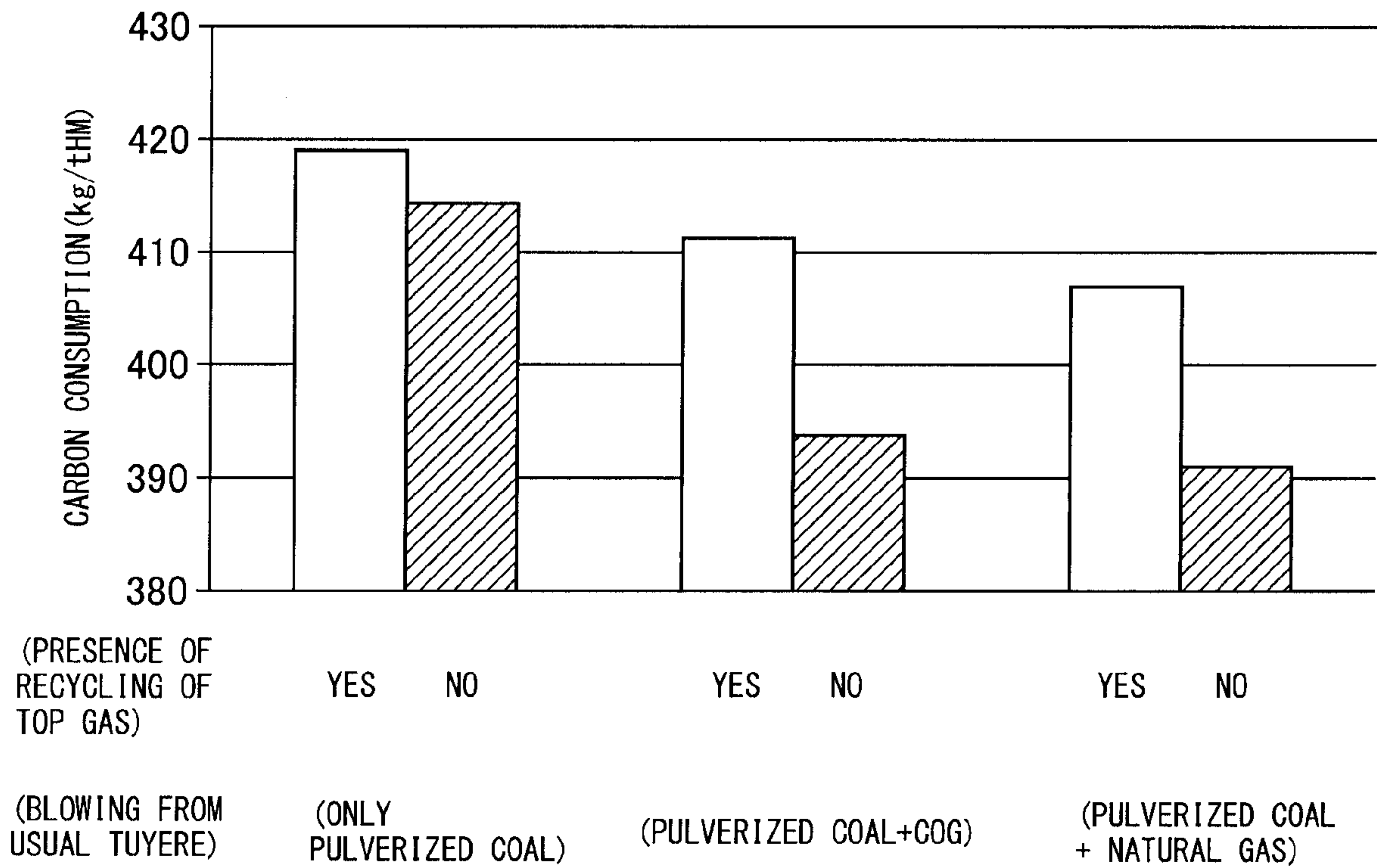
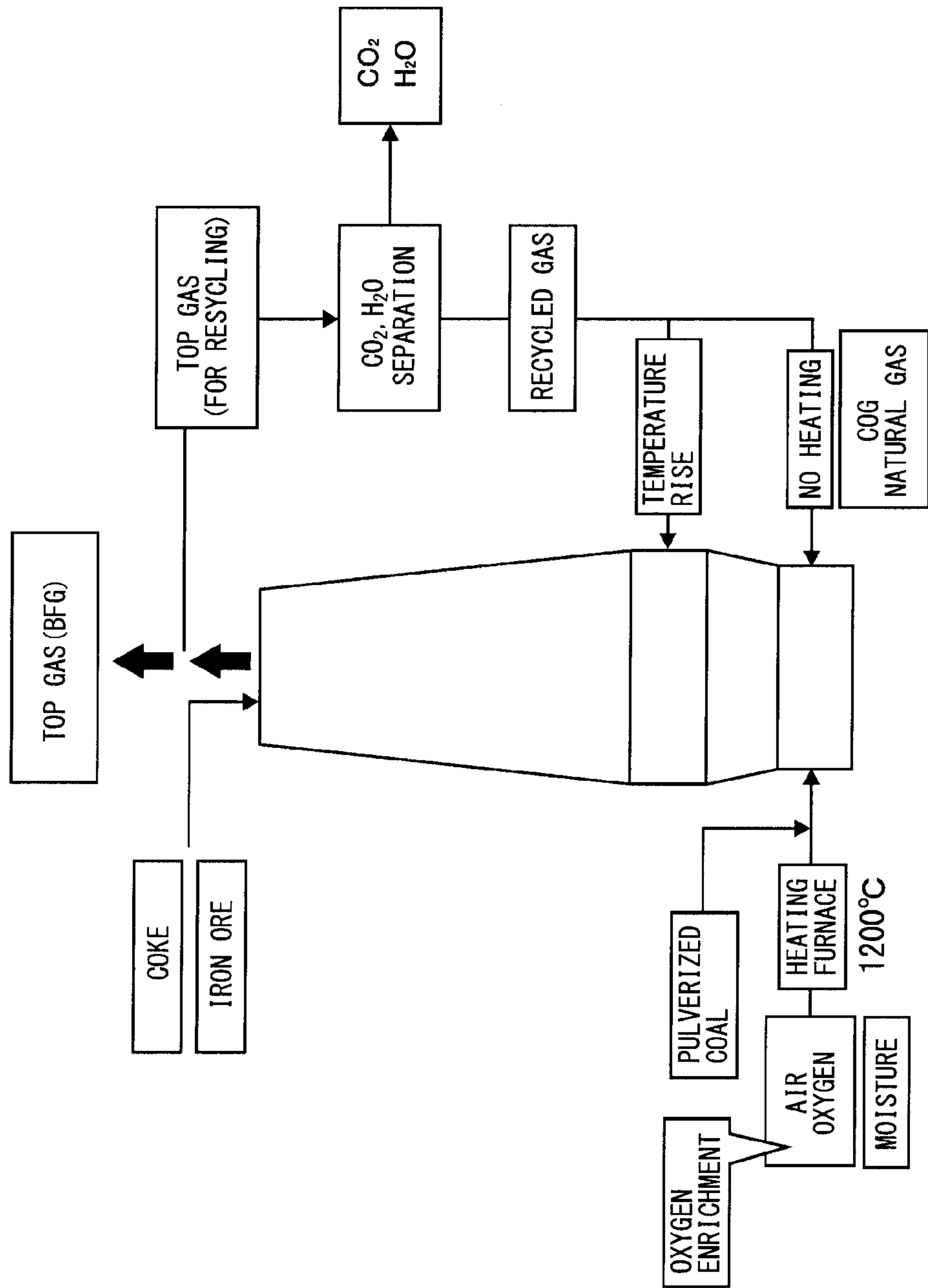


FIG. 6



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FIG. 7

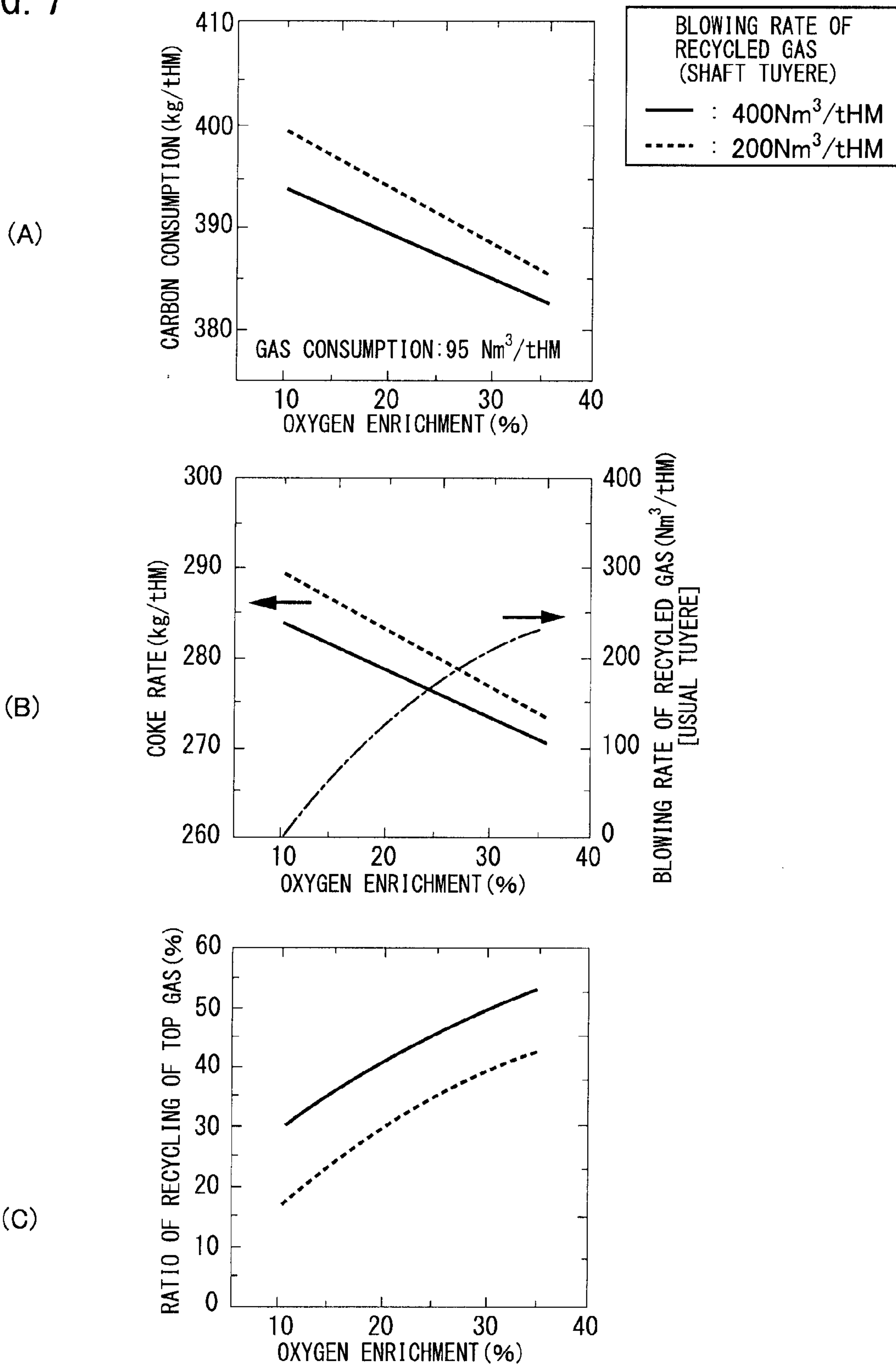


FIG. 8

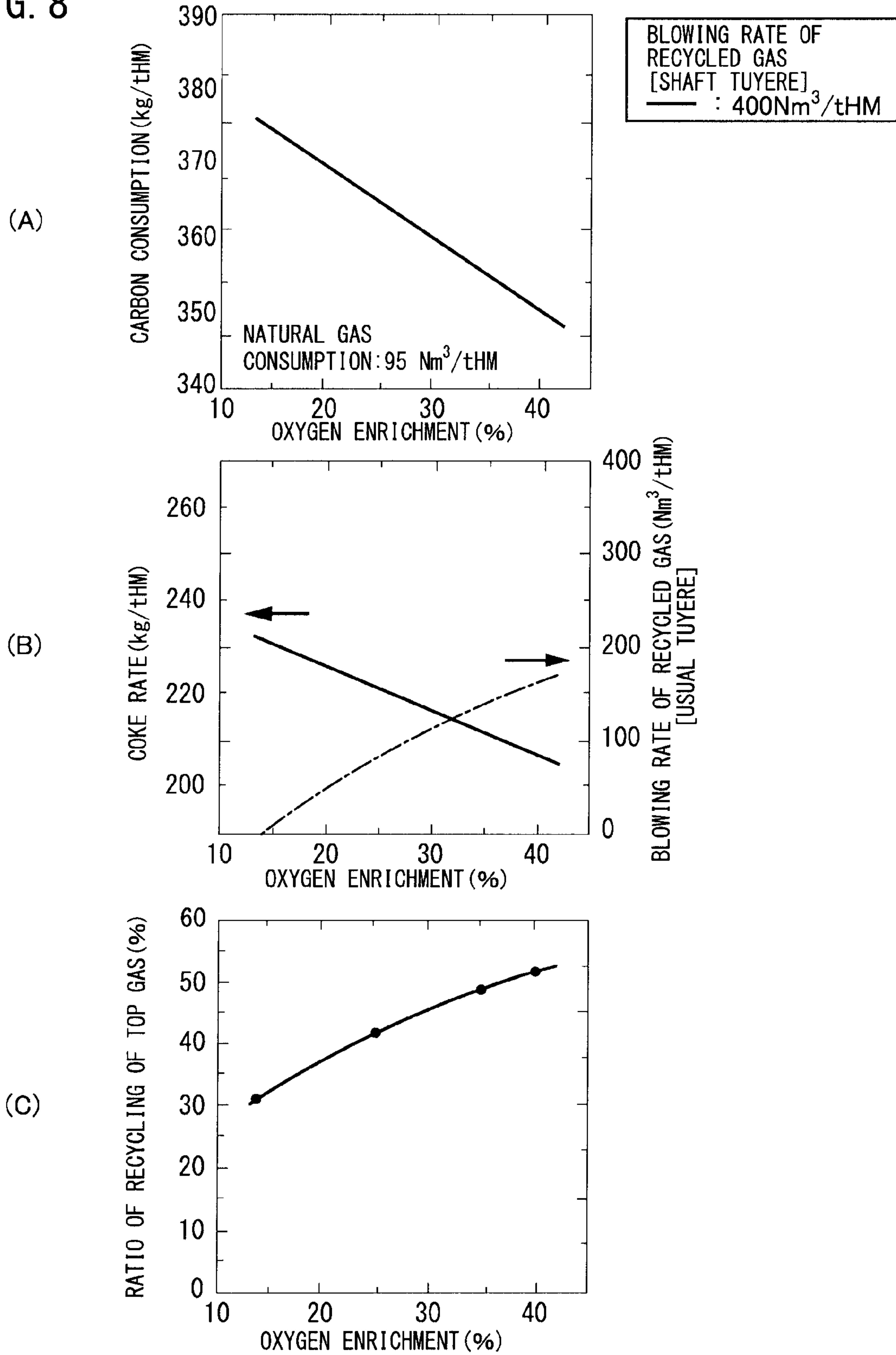


FIG. 9

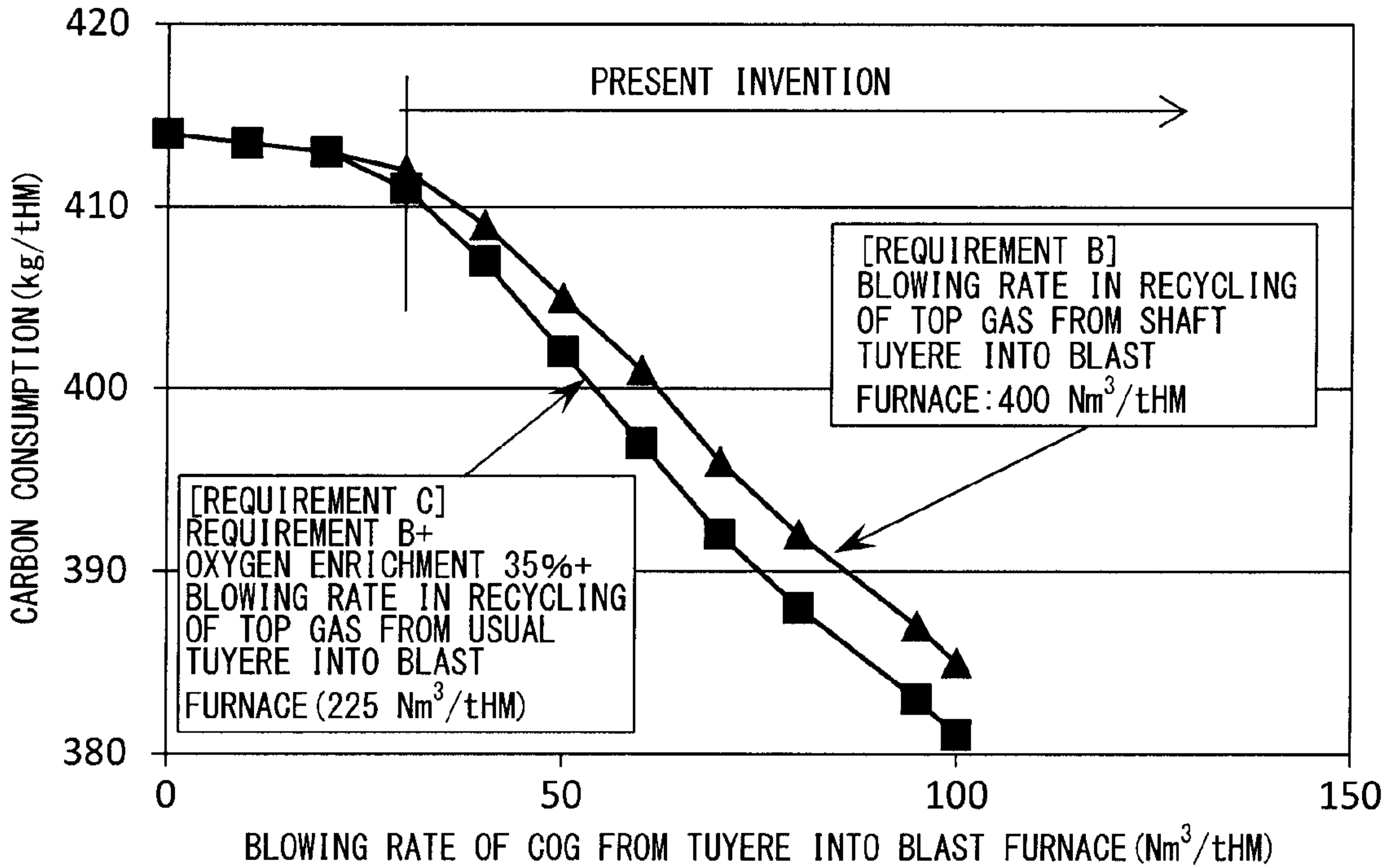


FIG. 10

