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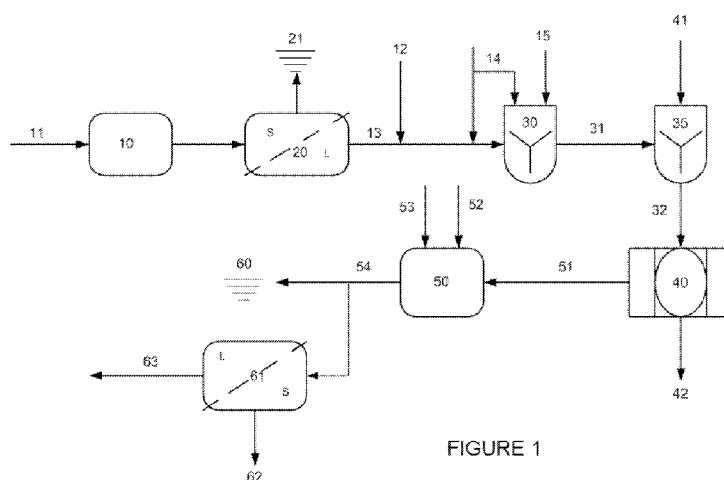


FIGURE 1

(57) Abstract: A process for treating waste water, effluent streams, e.g., acid mine drainage, containing heavy metals and soluble contaminants is provided. In one embodiment, at least a metal cation is added to the effluent stream at a pre-select pH to form insoluble heavy metal complexes. In one embodiment, the metal cation is a trivalent metal ion, e.g., ferric iron such as in ferric sulfate. In another embodiment, a divalent metal ion such as in ferrous sulfate is used. After the removal of the heavy metal complexes, the effluent water is treated with an additive selected from aluminum salts, phosphate additives, and mixtures thereof, to remove remaining soluble contaminants, thus producing a treated water stream with reduced levels of contaminants.



Method for Treating Effluent Waters

CROSS-REFERENCE TO RELATED APPLICATIONS

[001] This application is continuation-in-part (CIP) of US Patent Application No. 13/017,417 with a filing date of January 31, 2011. This application claims priority to and benefits from the foregoing, the disclosure of which is incorporated herein by reference.

TECHNICAL FIELD

[002] The invention relates to methods for treating waste, drainage, and effluent waters emanating from sources including but not limited to excavations and mining operations.

BACKGROUND

[003] Excavations such as mining operations, milling operations, road constructions, etc., generate effluents which may require treatment prior to discharge. These effluents include, for example, acid mine drainage (AMD), mill tailings, excess decant water, seepages, and acidic process waste streams. Acid mine drainage (AMD) forms when minerals in rocks are exposed to oxidizing conditions in mining operations, highway construction, and other large scale excavations.

[004] Prior art methods for treating excavation effluents generally require extensive capital outlay and are specific in application to a particular effluent. In one example, lime neutralization to pH around 11 is used to remove a majority of contaminants. However, lime neutralization does not work with some metals such as antimony, vanadium, arsenic and molybdenum, and does not work well with anions such as sulfates, fluorides, nitrates and chlorides. In other examples, technologies developed for sulfate reduction may work to remove certain anions to government-mandated levels together with anionic species such as fluorides. However, they do not particularly work well with molybdenum and require 2-stage clarification / separation steps to isolate precipitates that interfere with downstream metal removal. Desalination technologies, e.g., membrane processes using reverse osmosis and ion-exchange, may work in removing molybdenum. However, they are expensive technology options and are prone to scaling issues due to calcium sulfate precipitation.

[005] There is a need for improved methods for treating excavation effluents, particularly effluents with concentrations of anions such as fluorides, sulfates, molybdates,

arsenates etc., as well as heavy metals such as nickel, cobalt, manganese, chromium, and the like.

SUMMARY

[006] In one aspect, a method for treating a discharge stream to reduce the concentration of heavy metals and soluble contaminants is provided. The discharge stream contains one or more metal ions selected from molybdenum, aluminum, manganese, nickel, cobalt, copper, zinc, arsenic, and vanadium, and at least a soluble anionic species selected from nitrate, nitrite, sulfate, fluoride, and chloride. The method comprises: contacting the discharge stream with at least a metal cation selected from divalent and trivalent metal cations and mixtures thereof, in an amount effective and at a pre-select pH for the at least a metal cation to form at least a complex with at least one of the heavy metals; performing a liquid solid separation to remove the heavy metal complex forming a first effluent; adding an additive selected from aluminum salts and phosphate additives and mixtures thereof to the first effluent for at least one of the soluble anionic species to form a precipitate at an alkaline pH; and performing a liquid solid separation to remove the precipitate to form a second effluent.

[007] In another aspect, there is provided a method for treating acid mine drainage to reduce the concentration of heavy metals and soluble contaminants. The acid mine drainage contains one or more metal ions selected from molybdenum, aluminum, manganese, nickel, cobalt, copper, zinc, arsenic, and vanadium, and at least a soluble anionic species selected from nitrate, nitrite, sulfate, fluoride, and chloride. The method comprises the steps of: contacting the acid mine drainage with at least a trivalent and / or a divalent metal ion source in an amount effective and at a pre-select pH for the trivalent metal and / or the divalent metal ion source to form at least an insoluble complex with at least one of the heavy metals; performing a liquid solid separation to remove the heavy metal complex forming a first effluent; adjusting the pH of the first effluent to an alkaline range; adding at least an aluminum salt to the first effluent having an alkaline pH to cause at least one of the soluble anionic species to form a precipitate; performing a liquid solid separation to remove the precipitate, forming a treated effluent. In one embodiment, the metal ion source comprises ferric iron and / or ferrous ion, and the aluminum salt is an aluminate compound. In a second embodiment, the metal ion source comprises ferric ion and the aluminum salt is a calcium aluminate cement.

[008] In another aspect, there is provided a method for treating effluent waters to reduce the concentration of heavy metals and soluble contaminants. The effluent stream contains one or more metal ions selected from molybdenum, aluminum, manganese, nickel, cobalt, copper, zinc, arsenic, and vanadium, and at least a soluble anionic species selected from nitrate, nitrite, sulfate, fluoride, and chloride. The method comprises the steps of: contacting the acid mine drainage with at least a trivalent and / or a divalent metal ion source in an amount effective and at a pre-select pH for the trivalent metal and / or the divalent metal ion source to form at least an insoluble complex with at least one of the heavy metals; performing a liquid solid separation to remove the heavy metal complex forming a first effluent; adjusting the pH of the first effluent to an alkaline range; adding at least a phosphate additive to the first effluent having an alkaline pH to cause at least one of the soluble anionic species to form a precipitate; performing a liquid solid separation to remove the precipitate, forming a treated effluent.

BRIEF DESCRIPTION OF THE DRAWINGS

[009] Figure 1 is a block diagram illustrating one embodiment of a process to treat an effluent stream such as acid mine drainage to reduce contaminants.

[010] Figure 2 is a block diagram illustrating a second embodiment of a process to treat acid mine drainage.

DETAILED DESCRIPTION

[011] The following terms will be used throughout the specification and will have the following meanings unless otherwise indicated.

[012] “ppm” refers to parts per million. One ppm is equivalent to 1 mg per liter.

[013] “Divalent metal cation” and “trivalent metal cation” refer to a metal cation in its divalent state and trivalent state, respectively. For example, ferric sulfate is a trivalent ferric iron and ferrous sulfate is a divalent ferrous iron.

[014] LSI refers to the Langelier Saturation index, an equilibrium model derived from the theoretical concept of saturation and provides an indicator of the degree of saturation of water with respect to calcium carbonate. It can be shown that the Langelier saturation index (LSI) can be correlated to the base 10 logarithm of the calcite saturation level. The Langelier saturation level approaches the concept of saturation using pH as a main variable. The LSI can be interpreted as the pH change required to bring water to equilibrium.

Water with a negative LSI means that there is little or no potential for scale to form, with the water typically dissolving CaCO_3 . If the LSI is positive, scale will typically form and CaCO_3 precipitation will typically occur.

[015] “Tailings” or “tailing” (also known as slimes, tails, or leach residue) refers to waste or materials remaining after the process of separating the valuable fraction from the uneconomic fraction of an ore.

[016] Overburden or waste rock refers to the materials overlying an ore or mineral body that are displaced during mining without being processed.

[017] “AMD” or acid mine drainage, or acid rock drainage (ARD), refers to effluents from extractions and / or excavations, characterized by acidity and metals which may include aluminum, antimony, cadmium, chromium, cobalt, copper, iron, lead, magnesium, manganese, molybdenum, nickel, zinc and others. In one embodiment, AMD is a consequence of the decomposition of pyrite (FeS_2) and pyrrhotite [$\text{Fe}_{(1-x)}\text{S}$] in waste rock upon exposure to water and oxygen, resulting in the groundwater becoming acidified and contaminated with dissolved metals and sulfates.

[018] The term mine here includes mining, referring to active, inactive, or abandoned extraction and or excavation operations for removing minerals, metals, ores and / or coal from the earth. Examples of extraction operations include minerals, metals and ores including limestone, talc, gold, silver, iron, zinc, manganese, molybdenum, antimony, chromium, and nickel.

[019] “Aerated” refers to the natural and / or mechanical methods of mixing air and water. Any suitable mechanical aeration device can be used. Suitable devices are described in US Pat. Nos. 3,142,639 and 4,695,379, the references are including herein by reference.

[020] Environmental regulations throughout the world such as those promulgated by the US EPA under CAA, RCRA and CERCLA, as well as state and local authorities, require material producers to manage water effluents and wastes from extractions / excavations. Concentration of certain minerals / metals in water effluents must be contained below regulatory levels. Many states in the US have standards for the treatment of reclaimed water to be used for crop irrigation. State agencies, e.g., the Colorado Department of Public Health and Environment (DPHE), have classifications system establishing water use categories. Waters are classified according to the uses for which they are presently suitable or intended to become suitable, e.g., domestic water supply, irrigation of crop, etc. For example, the 2000 DPHE MCL (“Maximum Contaminant Level”) standard for nitrate / nitrite in irrigation

water is 100 mg/L, the total dissolved solids (TDS) MCL is 500 mg/L, the fluoride MCL is 4 mg/L, the sulfate MCL is 500 mg/L. No MCL currently exists for vanadium; however, the Superfund Removal Action Level for vanadium is 250 ug/l. New Mexico MCL for arsenic is 0.02 mg/L. The EPA has not established an MCL for molybdenum in drinking water. The EPA has developed a health advisory for children of 0.08 mg/L and a lifetime health advisory of 0.04 mg/L of molybdenum in drinking water.

[021] In one embodiment, the invention relates to an improved method to remove and or treat contaminants / minerals from discharge streams, effluents, run-off, and seepage, from mines, coal refuse piles, construction sites, plants and other locations. In one embodiment, the discharge stream is from AMD, wherein rock formations have been disturbed, excavated, exposed to water sources such as rainfall, surface water, and subsurface water sources, such that the water contains metals and minerals in solution or suspension. In another embodiment, the invention relates to an improved method for treating AMD to reduce heavy metals such as chromium, cobalt, zinc, nickel etc., and anionic species such as arsenate, vanadate, molybdate, fluoride and sulfate down to a level meeting regulatory requirements. After treatment, the treated water meeting regulatory requirements can be returned to the environment.

[022] AMD Contaminants For Treatment: As used herein, the term AMD refers to the water to be treated, which includes all sources of effluents from excavations, including AMD as well as tailings water and effluents, seepage from tailings facilities, leach residues, as well as seepage, well water, mine water and effluents from waste rock piles obtained from the excavation.

[023] The term “treatment” refers to the steps or processes for the removal of metals and dissolved anionic species in AMD. It is not a single step or process, but can occur at various stages of the process to be described herein, where a combination of chemical and / or physical mechanisms are involved.

[024] Depending on the location and amount of mineral deposits, the AMD in one embodiment is from an ore containing materials including magnetite, zircon, rutile, manganosiderite, fluorite, molybdenite, chalcopyrite, sphalerite, galena, fluorite. In one embodiment, some ores may include light gravity minerals (less than 2.9 specific gravity) such as quartz, orthoclase, oligoclase, biotite, calcite, and chlorite.

[025] Depending on the ore location, the mineralogy of AMD in one embodiment may comprise quartz, plagioclase feldspar, potassium feldspar, biotite, chlorite, amphibole,

calcite and sulfide minerals. The sulfide minerals in one embodiment include pyrite, sphalerite, chalcopryrite and molybdenite with trace amounts of galena, covellite and pyrrhotite, with the minerals as potential sources of acidity and dissolved metals including aluminum, cadmium, chromium, cobalt, copper, iron, lead, magnesium, manganese, molybdenum, nickel, zinc and others.

[026] Depending on the source, the excavation means, the tailing impoundment means, the water source, the AMD in one embodiment contains soluble species including but not limited to fluorides, sulfates, cadmium, cobalt, manganese, molybdenum, and nickel. In another embodiment, the AMD contains one or more metal ions or salts of iron, copper, zinc, lead, mercury, cadmium, arsenic, barium, selenium, silver, chromium, aluminum, manganese, nickel, cobalt, uranium, and antimony. In one embodiment, the water has a positive LSI.

[027] In one embodiment, the AMD has a pH from 2.0 to 10.0; often from 3.0 to 6.0 and typically in the range of 3.5 to 5.5. The AMD has a calcium hardness of greater than 200 ppm in one embodiment; greater than 400 ppm in a second embodiment; and greater than 600 ppm in a third embodiment.

[028] One heavy metal that may be dissolved in aqueous effluents of base metal mines is molybdenum. In one embodiment of tailing ponds associated with copper mines, the Mo concentration ranged from 1 to 30 ppm. In another embodiment, the tailings water from a uranium mill contained dissolved Mo in an amount of up to 900 ppm.

[029] Removal of Heavy Metals from the AMD: In one embodiment, the pH of the AMD is first adjusted to a pH value at which selective precipitation of the heavy metal complexes occurs ("pre-selected pH") with the addition of at least a metal cation selected from divalent and trivalent metal cations ("metal cation"). In one embodiment, the pre-select pH is between 2.0 to 6.0. In another embodiment, from 3.0 to 5.0. This can be accomplished by the addition of at least an acid with a relatively high ionization constant. In one embodiment, the acid is used in a strength ranging from 1.0 to 12.0 normal. In another embodiment, sulfuric acid is used in view of its availability and low cost.

[030] The metal cation is added to the AMD to scavenge heavy metals such as molybdenum, tungsten, chromium, arsenic, antimony and vanadium from the AMD. In one embodiment, the metal cation is selected from the group of iron, cobalt, aluminum, rhenium, and combinations thereof.

[031] By varying the concentration of the metal cations to heavy metal ions and the pH, nearly total removal of dissolved heavy metal ions can be achieved, wherein the heavy

metal ions are converted to heavy metal insoluble complexes for subsequent removal. In one embodiment, at least 50% of the heavy metals can be removed as precipitate with the rest remaining in solution. In another embodiment, the removal rate is at least 75%. In a third embodiment, at least 90% of a heavy metal is removed as a precipitate. In yet another embodiment, the removal rate is at least 96% as precipitate. In one embodiment, the concentration of a heavy metal such as V is reduced to less than detectable limit of 0.005ppm. In another embodiment, Mo is reduced to a level of 0.08 ppm or less. In yet another embodiment, As is reduced to 0.003 ppm or less.

[032] In one embodiment, the metal cation is trivalent ferric iron, e.g., ferric sulfate, in view of its availability, low cost, and ease of use. In another embodiment, the metal cation is provided as ferric chloride solution. In another embodiment, the metal cation is divalent ferrous iron, e.g., ferrous sulfate. In yet another embodiment, the metal cation is aluminum, e.g., hydrous aluminum oxide, provided at a pH of about 5.2.

[033] In one embodiment with the use of a divalent metal cation such as ferrous iron, oxidizing means such as aeration or an oxidizing agent is provided to convert the divalent metal ion into a trivalent metal ion, e.g., ferric iron. Air injection of the AMD stream / tank can be continuous or intermittent. The injection rate in one embodiment varies from 2 Lpm to 20 Lpm per 100 gpm (gallon per minute) flow for a conversion based on 50 ppm of ferrous iron, for full conversion into ferric iron, assuming 50% oxygen utilization. In another embodiment, hydrogen peroxide is employed to oxidize the divalent metal cation for precipitation of the heavy metal complexes

[034] In one embodiment, the metal cation is added to the AMD in an amount sufficient to provide from about 6 to 50 ppm (parts per million) of metal cation to each ppm of the metal to be removed from the AMD. The addition of the metal cation enables the formation of insoluble heavy metal complexes such as iron molybdate, tungstate, vanadate, antimonate, arsenate and the like, depending on the source and original concentration of heavy metals in the AMD. In one embodiment with the use of aluminum as the trivalent cation, the quantity of aluminum required is greater than that of iron.

[035] It should be noted that the "treatment" or contact time between the effluent AMD and the additive such as a metal cation, or the residence time in the mixing tank varies depending on factors including but not limited to the size of the equipment and effluent flow rate. In one embodiment, treatment with the metal cation is for at least a retention time of 3 minutes under agitation and aeration to enable the formation of the insoluble heavy metal

salts. In another embodiment, the retention time ranges from 5 minutes to 2 hrs. In yet another embodiment, the retention time is for at least an hour. The treatment is at a temperature ranging from ambient to 60°C in one embodiment, and from 40 to 80°C in a second embodiment. The treatment can be suitably conducted at atmospheric pressure.

5 [036] Liquid Solid Separation to Remove Solids: Depending on the source and concentration of the contaminants in the AMD, the level of solids containing heavy metal precipitate in the AMD after treatment can be quite low, e.g., less than 1 wt% in one embodiment, and less than 0.5 wt. % in a second embodiment. In the next step, the AMD stream containing heavy metal precipitate along with any insoluble iron oxyhydroxides is
10 subject to liquid solid separation to remove effluent water for further treatment. The metal precipitate in one embodiment may be slime-like in character. In another embodiment, the precipitate may be in the form of suspended matter as fine particulates.

 [037] In one embodiment, the liquid solid separation is achieved via the ‘body feed’ addition of a material such as calcium silicate or diatomaceous earth or cellulose. In one
15 example, the AMD slurry containing the insoluble metal complexes is body fed with 1,000 – 20,000 ppm of diatomaceous earth. The diatomaceous earth provides a matrix for holding the fine particulates together, assisting solids filterability through the use of a plate and frame filter.

 [038] In another embodiment, the liquid solid separation to remove the metal precipitate is via coagulation / flocculation / clarification. In one example, at least a
20 flocculent is first added to the AMD. In one embodiment prior to the addition of the flocculent, the pH of the AMD is adjusted to control the size of the coagulated particles, density of the slime, as well as the tendency and rate of settling of the solids. Flocculants are well-known in the art. Examples include but are not limited to natural and synthetic organic polymers, e.g., anionic polymers such as hydrolyzed polyacrylamides. The flocculent in
25 one embodiment facilitates the precipitation of the heavy metal complexes. In one embodiment, the flocculent addition results in flocs that are buoyed to the surface which can be skimmed from the surface to remove the metal complexes. In another embodiment, the flocculent binds to the metal complexes, resulting in an aggregation of solids that subsequently settle out.

30 [039] In one embodiment, inclined plate settlers or lamella clarifiers are employed for the flocculation / clarification step. AMD containing insoluble heavy metal complexes enters the lamella clarifier, where it is flash mixed with the polymer flocculent and then gently agitated with a separate mixer. In one embodiment, as the liquid flows up the inclined

plates, the flocculated material containing the heavy metal complexes settle out from the stream, allowing water containing soluble cationic and anionic species to be collected for further treatment. After the removal of the insoluble metal complexes, the concentration of heavy metals such as Mo, V, As, etc., in the collected water effluent is reduced to 1 ppm in one embodiment, less than 0.5 ppm in another embodiment, and less than 0.1 ppm in a third embodiment.

[040] Removal of other Soluble Contaminants: In one embodiment after the removal of heavy metals such as Mo, V, As and Sb, the effluent water still contains soluble cationic and anionic species initially present in the AMD such as aluminum, cadmium, cobalt, manganese, nickel, copper, zinc, fluorides, sulfates and the like. In one embodiment, the concentration of these soluble species are lowered upon contact with a phosphate additive as a precipitant at a pre-selected pH, e.g., an alkaline pH. In one embodiment, the phosphate additive is phosphoric acid and a calcium salt and / or a phosphate salt. In another embodiment, the concentration of these soluble species are lowered using an aluminum salt. Examples of aluminum salts include but are not limited to as aluminium chloride, aluminum chlorohydrate, polyaluminum chloride, aluminum sulfate, silicoaluminate, polyaluminum chlorosulfate; aluminate salts such as calcium chloroaluminate, calcium sulfoaluminate, sodium aluminate, potassium aluminate, calcium aluminate, and mixtures thereof. In one embodiment, the aluminum compound is a calcium aluminate cement, commercially available under the trade name of Lumnite™ MG 4.

[041] The aluminum additive or phosphate additive is added to the alkaline AMD in an amount sufficient for reactions with anionic soluble species to form an insoluble precipitate. A sufficient amount of the additive is added to the AMD for a weight ratio ranging from 0.75:1 to 20:1 of additive to soluble species to be removed in one embodiment; a weight ratio of 2:1 to 5:1 in a second embodiment; and from 0.7:1 to 1.5:1 in a third embodiment. In one embodiment, the additive is added in an amount ranging from 500 ppm to 10,000 ppm. In another embodiment, the amount of additive ranges from 1,000 to 6,000 ppm. In a third embodiment, the additive is added in an amount ranging from 2,000 to 5,000 ppm.

[042] In one embodiment with the use of a phosphate additive, e.g., phosphoric acid can be any of wet process amber phosphoric acid, wet process green phosphoric acid, hydrophosphoric acid, technical grade phosphoric acid, and mixtures thereof. In one embodiment with the addition of phosphoric acid, at least a salt of calcium bicarbonate is

added for the generation of a soluble phosphate based calcium compound, e.g., $\text{Ca}(\text{H}_2\text{PO}_4)_2$ or CDHP.

[043] In one embodiment, the phosphate additive is selected from the group including but not limited to hydroxyapatite, hexametaphosphate (HMP), polyphosphates, monocalcium phosphate, dicalcium phosphate, tricalcium phosphate, calcium orthophosphates, phosphate fertilizers, phosphate rock, pulverized phosphate rock, calcium orthophosphates, animal bone phosphate, and combinations thereof. Phosphate fertilizers refer to monoammonium phosphate (MAP), diammonium phosphate (DAP), single superphosphate (SSP), and triple superphosphate (TSP).

[044] In one embodiment, the phosphate additive is a soluble phosphate based calcium compound, e.g., $\text{Ca}(\text{H}_2\text{PO}_4)_2 \cdot \text{H}_2\text{O}$ or CDHP, that is added to the alkaline slurry at a pH of greater than 10. CDHP is a readily available and inexpensive fertilizer chemical, showing a strong propensity for fluoride and sulfate removal, in addition to removing / reducing the concentration of metals in the AMD. Depending on the starting concentration of fluoride and sulfate, in one embodiment, the use of CDHP reduces the fluoride and sulfate level to less than 1 ppm and 250 ppm respectively.

[045] In one embodiment, the pH of the effluent water is first adjusted to an alkaline value at which maximum removal of contaminants will occur. In one embodiment, the alkaline pH is at between 9 and 13. In a second embodiment, the pre-selected pH is at least 10. The pH can be increased in one embodiment with lime supplementation.

[046] In one embodiment, the pH of the AMD is maintained at a basic level during treatment to cause at least one of the soluble anionic species to form a precipitate. In one embodiment, an alkaline pH is maintained with the continuous addition of agents known in the art, e.g., lime (CaO (quicklime) or $\text{Ca}(\text{OH})_2$ (hydrated lime)), calcium carbonate (CaCO_3), etc.

[047] In one embodiment, the treatment under agitated conditions with an additive such as calcium dihydrogen phosphate monohydrate is for at least an hour. In another embodiment, the treatment ranges from two hours to 4 hours. In yet another embodiment, the treatment is for at least 3 hours. The treatment is at a temperature ranging from ambient to 60°C in one embodiment, and from 40 to 80°C in a second embodiment. The treatment in one embodiment generates a dense solid volume at a fairly fast settling rate, which solid can be subsequently removed using liquid-solid separation means known in the art to generate treated water. In one embodiment, the treated water contains less than 1 ppm fluoride, and

less than 300 ppm sulfate. In one embodiment, the treated water contains less than 0.010 ppm nickel, less than 0.005 ppm manganese, less than 0.02 ppm aluminum, and less than 0.05 ppm zinc. In one embodiment, the treated water contains less than 0.003 ppm arsenic, less than 0.08 ppm molybdenum, less than 0.005 ppm vanadium, and less than 0.005 ppm antimony.

[048] After treatment of the AMD to remove the contaminants of concern, the treated and unfiltered water may be pumped to a mill tailings impoundment for storage. In one embodiment for recycling treated and filtered water for on-site or off-site re-use, the pH is adjusted towards the neutral range to prevent deposition of hard carbonate scale in filters and distribution piping. In another embodiment, the treated and filtered water is returned to the environment by way of a suitable waterway, the pH is adjusted to less than 9 to meet local effluent discharge regulations. In one embodiment, addition of carbon dioxide is performed in order to reduce the pH to meet discharge requirements. Carbon dioxide (CO₂) is a commonly used reagent for pH adjustment from the alkaline range. CO₂ reacts reversibly with water to form carbonic acid, which deprotonates (loses its hydrogen cation) causing the pH to decrease (due to the H⁺ in solution). Non-limiting examples of suitable waterways include spillways, rivers, streams, lakes, and the like. "Spillway" refers to a waterway beginning at a point of discharge from a final settling pond at a water treatment site and ending where the water in the waterway enters a naturally occurring waterway through gravity flow.

[049] Reference will be made to figures 1 and 2 that schematically illustrate various embodiments of a process to treat acid mine drainage from an excavation, which contains contaminants that are above regulatory limits. The process as shown comprises of a number of treatment zones, with one or more of the treatment zones operating in a batch flow mode, a sequential mode, or a continuous flow mode having a continuous or periodic AMD inflow.

[050] In Figure 1, the AMD to be treated enters the treatment system through conduit **11** and is contained in a stirred storage vessel **10**. In one embodiment, an AMD feed having a pH of about 4.0 is commingled with mill flotation tailing slurry yielding a pH of near neutral, is first passed through a plate & frame filter **20** to separate out solids **21**, yielding an effluent stream **13** for treatment. The solids **21** are transported to a tailings impoundment. The effluent stream **13** is combined with AMD **12** from other sources, e.g., mine water or recovery well water, and fed to aeration tank **30**. The water is treated with a metal ion source **14**, e.g., iron sulfate and sulfuric acid **15**, and mechanically stirred and

aerated. Sulfuric acid **15** is added in sufficient amounts to control the effluent pH between 4 and 4.5.

[051] The treated stream containing suspended heavy metal precipitates **31** with pH of between 4 and 4.50 is pumped to a slowly stirred holding tank **35**, wherein a high
5 molecular weight pre-mixed anionic polymer **41** is added to flocculate and aggregate the dispersed iron oxy-hydroxide particulates. The flocculated slurry **32** is gravity fed to an inclined plate settler **40** to create a dense sludge **42**, which can be pumped to a tailings impoundment or filtered and removed for disposal. The clear supernatant stream **51** is sent to a stirred tank **50**, wherein sufficient amount of slaked lime **52** is continuously added to
10 raise and maintain the pH to at least about 11. A phosphate compound **53** such as CDHP is added in conjunction with the lime in sufficient amounts to remove cationic and anionic soluble contaminants to target discharge standards.

[052] In one embodiment as shown, the alkaline slurry **54** is pumped to a tailings impoundment **60** or filtered **61** and the solids **62** removed for disposal. The clarified filtrate
15 **63** is treated with CO₂ to ensure effluent discharge pH requirements are met.

[053] Figure 2 illustrates another embodiment to treat acid mine drainage, wherein instead of using a phosphate compound a calcium aluminate cement compound is employed. In Figure 2, process steps are substantially as shown in Figure 1 except that in stream **53**, Lumnite™ calcium aluminate cement is added in conjunction with lime in sufficient amounts
20 to remove cationic and anionic soluble contaminants to target discharge standards. After the aluminate treatment, the alkaline treated slurry **54** is thickened and filtered **61** and the solids **62** removed for disposal to a tailings impoundment or repository **60**. The clarified filtrate **63** is treated with CO₂ to ensure effluent discharge pH requirements and trace soluble metals are met. From carbonation tank **70**, the effluent **64**, containing low levels of suspended solids, is
25 pumped through a dual media filter bed **75** for clarification. A portion of the treated and clarified stream **65** is discharged with the remainder being recycled back to the milling circuit **9** as make-up water.

[054] EXAMPLES: The following illustrative examples are intended to be non-limiting.

30 [055] Chemical treatment was performed in a Kontes 500-mL or 1000-mL flask with stirring and air sparging through a glass frit, or in 1-liter plastic bottles placed on a shaker table or in a six-port gang stirring unit with 2-liter vessels & paddle mixers. Splits of each sample were vacuum filtered through sterilized 0.45-micron pore membranes and the

filtrates were assayed for metal content using a Thermo Fisher Scientific, Iris Advantage Inductively Coupled Plasma (ICP) spectrometer and a Perkin Elmer 6000 ICP-Mass Spectrometer; anionic species were analyzed by ion chromatography on a Dionex IC 25 unit with a carbonate/bicarbonate eluant system on AS-12 columns.

5 [056] Example 1: An effluent stream “A” from an excavation site is used for treatment. The stream has species concentrations as indicated in Table 1.

[057] Example 2: A stream “C” is used for treatment with species concentrations as indicated in Table 1.

Table 1

Properties	Stream A	Stream C
pH @~20°C	4.30	7.90
Total dissolved solids (mg/L)	845	852
F ⁻ (ppm)	21	7
Cl ⁻	21	11
NO ₃ ⁻	10	8.6
SO ₄ ²⁻	920	800
Al	50.58	0.065
As	<0.003	<0.003
B	< 0.1	< 0.1
Ba	< 0.1	< 0.1
Bi	< 0.1	< 0.1
Cd	0.034	0.019
Co	0.15	0.13
Cr	< 0.1	< 0.1
Cu	0.53	< 0.005
Fe	0.1	< 0.1
K	3.3	5.4
Li	< 0.1	< 0.1
Mg	98.1	92.8
Mn	17.64	25.6
Mo	< 0.1	2.1
Ni	0.45	0.26
P	< 0.1	< 0.1
Pb	< 0.1	< 0.1
Si	14.2	5.5
Sn	< 0.1	< 0.1
Sr	0.7	4.1
Ti	< 0.1	< 0.1
V	< 0.1	< 0.1
Zn	4.01	1.89

[058] Example 3: Several samples of “A” from Example 1 were treated at varying pH with lime and aeration over 1-hour of reaction time as shown in Table 2. The amount of lime added ranged from 171 ppm (Test #2) to 482 ppm (Test #7). Aeration was accomplished by air sparging. The final concentrations after treatment are shown in Table 3, depicting the reduction in level of a number of metals at a pH of 9 or above.

Table 2

Test No	Description	Lime (ppm)	Initial pH	Final pH	Aeration Rate (Lpm)
1	Control - Sample A (as-is)	0	4.4	4.3	0
2	Lime - CaO + Aeration	171	7.2	7.3	2 to 3
3	Lime - CaO + Aeration	195	8.2	7.7	2 to 3
4	Lime - CaO, NO Aeration	341	9.0	8.0	0
5	Lime - CaO + Aeration	246	9.0	8.1	2 to 3
6	Lime - CaO + Aeration	351	9.8	8.2	2 to 3
7	Lime - CaO + Aeration	482	10.9	8.7	2 to 3
8	Lime - CaO + Aeration	413	9.9	9.0	2 to 3

Table 3

Species	Untreated (ppm)	Test 1	Test 2	Test 3	Test 4	Test 5	Test 6	Test 7	Test 8
F ⁻	21	18	8.8	10	12	13	13	14	9.5
Cl ⁻	21	22	19	19	21	19	20	19	23
NO ₃ ⁻	10	6.5	6.7	6.9	6.9	6.7	6.3	6.5	7.5
SO ₄ ²⁻	920	1,000	1,000	1,000	920	1,000	1,000	1,000	1000
PO ₄ ³⁻	<0.1	-	-	-	-	-	-	-	-
Al	50.6	49.2	0.118	0.197	3.7	1.000	0.495	0.516	1.9
As	<0.003	<0.003	<0.003	<0.003	<0.003	<0.003	<0.003	<0.003	<0.003
Cd	0.034	0.0323	0.027	0.011	<0.001	0.003	<0.001	<0.001	<0.001
Co	0.2	0.138	0.082	0.033	<0.004	<0.004	<0.004	<0.004	<0.004
Cu	0.5	0.4	<0.005	<0.005	<0.005	<0.005	<0.005	<0.005	<0.005
Fe	0.1	0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1
Mn	17.6	17.8	15.300	13.100	0.3	6.300	0.900	0.039	0.01
Mo	<0.1	<0.01	<0.010	<0.010	<0.010	<0.010	<0.010	<0.010	<0.010
Ni	0.5	0.4	0.300	0.097	<0.01	0.009	0.009	<0.009	<0.010
P	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1
Si	14.2	14.3	4.4	2.1	0.6	0.7	0.9	0.9	0.9
Sr	0.7	0.8	<0.1	<0.1	0.8	<0.1	<0.1	<0.1	0.7
Zn	4.0	3.9	<0.1	0.067	<0.01	<0.067	<0.067	<0.067	<0.01

[059] Example 4: Several samples of stream “A” from Example 1, Table 1 were treated with lime, a soluble phosphate based calcium compound ($\text{Ca}(\text{H}_2\text{PO}_4)_2 \cdot \text{H}_2\text{O}$ or CDHP), a mixture of lime and CDHP, and with and without aeration as shown in Table 4. The final concentrations after treatment are shown in Table 5. The dramatic effect of phosphate treatment at high pH levels, e.g., tests 5 and 6, on the concentration of species such as fluoride, sulfate and aluminum is evident.

Table 4

Test No	Additive Description	CDHP (ppm)	P (ppm)	Lime (ppm)	Final pH
1	Control - Sample A (as-is)	0	0	0	4.4
2	Lime (CaO)	0	0	341	8.0
3	Lime (CaO) + Aeration	0	0	413	9.0
4	P as $\text{Ca}[\text{H}_2\text{PO}_4]_2$	3,980	1,055	0	3.1
5	P as $\text{Ca}[\text{H}_2\text{PO}_4]_2 + \text{CaO}$	4,098	1,086	6,206	11.0
6	P as $\text{Ca}[\text{H}_2\text{PO}_4]_2 + \text{CaO} + \text{Aeration}$	4,071	1,079	5,500	12.1

Table 5

Species	Untreated (ppm)	Test 1	Test 2	Test 3	Test 4	Test 5	Test 6
F ⁻	21	18	12	9.5	14	<0.2	<0.2
Cl ⁻	21	22	21	23	20	24	19
NO ₃ ⁻	10	6.5	6.9	7.5	6.9	22	6.2
SO ₄ ²⁻	920	1000	920	1000	960	200	240
PO ₄ ³⁻	<0.1	-	-	-	2,300	-	-
Al	50.6	49.2	3.7	1.9	50.9	<0.002	<0.002
As	<0.003	<0.003	<0.003	<0.003	<0.003	<0.003	<0.003
Cd	0.034	0.0323	<0.001	<0.001	0.0185	<0.001	<0.001
Co	0.2	0.138	<0.004	<0.004	0.1	<0.004	<0.004
Cu	0.5	0.4	<0.005	<0.005	0.5	<0.005	<0.005
Fe	0.1	0.1	<0.1	<0.1	0.3	<0.1	<0.1
Mn	17.6	17.8	0.3	0.0148	18	<0.01	<0.004
Ni	0.5	0.4	<0.01	<0.01	0.4	<0.01	<0.01
P	<0.1	<0.1	<0.1	<0.1	HIGH	<0.1	<0.1
Si	14.2	14.3	0.6	0.9	15.3	<1	0.2
Sr	0.7	0.8	0.8	0.7	1.1	0.7	1.2
Zn	4.0	3.9	<0.01	<0.01	3.8	<0.01	<0.01

[060] Example 5: In this example, several samples of stream “C” from Example 2, Table 1 were treated individually with lime, CDHP, an insoluble phosphate mineral hydroxyapatite (HAP or $\text{Ca}_5(\text{PO}_4)\text{OH}$) or a combination of the above at various pH with and without aeration over 1-hour of reaction time as shown in Table 6. The amount of added HAP in terms of P content ranged from around 500 ppm to 1,000 ppm (Tests 5 through 9). The amount of added CDHP in terms of P content was around 1,500-ppm (Tests 10 through 12). Table 7 depicts that the final species concentrations, after treatment with CDHP (Tests 10 through 12), were mostly lowered to non-detectable levels at a pH greater than 10.

Table 6

Test No	Sample Description	HAP (ppm)	P (ppm)	CDHP (ppm)	P (ppm)	Lime (ppm)	Final pH
1	Control - Sample C (as-is)	-	-	-	-	0	6.9
2	Aeration - Sample C (as-is)	-	-	-	-	0	7.9
3	Lime (CaO)	-	-	-	-	130	9.7
4	Lime (CaO)	-	-	-	-	352	11.20
5	P as HAP	5,795	1,074	-	-	0	7.1
6	P as HAP + CaO	3,022	560	-	-	124	9.6
7	P as HAP + CaO	5,437	1,007	-	-	104	9.6
8	P as HAP + CaO	5,585	1,035	-	-	300	10.94
9	Aeration + CaO + HAP	5,345	990	-	-	105	9.2
10	P as CDHP + CaO	-	-	6,172	1,519	2,437	11.90
11	P as CDHP + CaO	-	-	6,180	1,520	2,313	8.50
12	P as CDHP + CaO	-	-	5,990	1,474	2,513	10.10

[061] Example 6: In this example, several samples of stream “C” from Example 2, Table 1 were reacted with ferric iron (as ferric sulfate) and lime or sulfuric acid at various concentrations and pH for up-to 1 hour. Following treatment, half of the sample was filtered to remove iron solids. The clarified and unfiltered portions were reacted with CDHP and lime at various pH for a period of up-to 1-hour. The test conditions are shown in Table 8. The final concentrations of various species after treatment are shown in Table 9, demonstrating the reduction in the level of heavy metals such as Mo as well as soluble anionic species with ferric ion treatment followed by CDHP and lime treatment.

[062] Tests 3 and 4 indicate that molybdenum and other contaminants may be reduced according to the following sequence: a) Ferric ion at 35 to 45-mg/L, or at a 20:1 iron

to Mo mass ratio, is reacted with AMD water at pH between 4 & 4.5 for up-to an hour; b) the acidic slurry undergoes liquid-solid separation; and c) CDHP at 4,000-ppm is reacted with the clarified effluent at pH ~11 for up-to an additional hour.

- [063] In the Example, separation of the acidic iron sludge from the clarified effluent, following iron treatment, helps with the reduction of heavy metal concentrations, otherwise re-dissolution of the precipitated molybdenum occurs during subsequent reaction with CDHP at the highly basic slurry pH.

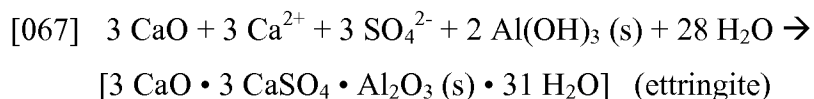
[064] Table 8

Test No	Sample Description	Fe (ppm)	CDHP (ppm)	P (ppm)	Lime (ppm)	Final pH
1A	Fe ⁺³ + CaO, 1-hr, FILTERED	10	0	0	0	6.80
1B	Fe ⁺³ + CaO, 1-hr, UNFILTERED	10	0	0	0	6.80
1C	FILTERED CDHP + CaO, 1-hr	-	4,121	1,014	5,165	12.10
1D	UNFILTERED CDHP + CaO, 1-hr	-	4,202	1,034	4,737	12.20
2A	Fe ⁺³ + CaO, 1-hr, FILTERED	29	0	0	19	6.40
2B	Fe ⁺³ + CaO, 1-hr, UNFILTERED	29	0	0	19	6.40
2C	FILTERED CDHP + CaO, 1-hr	-	4,232	1,041	3,465	11.65
2D	UNFILTERED CDHP + CaO, 1-hr	-	4,212	1,036	2,433	12.10
3A	Fe ⁺³ + CaO, 1-hr, FILTERED	29	0	0	0	4.50
3B	Fe ⁺³ + CaO, 1-hr, UNFILTERED	29	0	0	0	4.50
3C	FILTERED CDHP + CaO, 1-hr	-	4,066	1,000	3,987	12.30
3D	UNFILTERED CDHP + CaO, 1-hr	-	4,101	1,009	3,255	12.40
4A	Fe ⁺³ + CaO, 1-hr, FILTERED	40	0	0	13	4.05
4B	Fe ⁺³ + CaO, 1-hr, UNFILTERED	40	0	0	13	4.05
4C	FILTERED CDHP + CaO, 1-hr	-	4,090	1,006	3,105	11.45
4D	UNFILTERED CDHP + CaO, 1-hr	-	4,293	1,056	2,834	10.85
5A	Fe ⁺³ + CaO, 1-hr, FILTERED	51	0	0	42	6.15
5B	Fe ⁺³ + CaO, 1-hr, UNFILTERED	51	0	0	42	6.15
5C	FILTERED CDHP + CaO, 1-hr	-	4,054	997	4,899	12.15
5D	UNFILTERED CDHP + CaO, 1-hr	-	4,093	1,007	4,337	12.15
6A	Fe ⁺³ + CaO, 1-hr, UNFILTERED	98	0	0	132	6.20
6B	CDHP + CaO, 1-hr	-	2,079	512	1,621	11.25
7A	Fe ⁺³ + CaO, 1-hr, FILTERED	99	0	0	135	6.36
7B	CDHP + CaO, 1-hr	-	2,089	514	1,580	11.40
8A	CDHP + CaO, 1-hr	-	2,041	502	1,562	11.50
8B	Fe ⁺³ , 30-min	100	0	0	0	10.53

9A	Fe ⁺³ + CaO, 30-min	101	0	0	218	9.50
9B	CDHP + CaO, 1-hr	-	2,047	504	1,354	11.00
10	Fe ⁺³ + CDHP + CaO	103	2,051	505	2,501	11.90

[065] Example 7: Several samples of various streams with different concentrations of cations and anionic species as shown in Table 10 were combined into one composite stream. The composite mixture was developed using flow-weighted proportions of various streams that would provide a representative composite of all ground water, seepage, and mine flows that may enter a water treatment facility. Stream A was a recovery well water from a mine site comprising of seepage from interception wells. Streams H and I were from acidic ground water extraction wells. Stream K was from underground mine water. The composite stream was treated with ferric ion (as ferric sulfate at 35 to 45-mg/L) and lime at pH between 4 & 4.5 for up-to 1 hour, at an Fe:Mo mass ratio of at least 20.

[066] Following the ferric ion treatment, a liquid solid separation step was performed via flocculent addition and thickening. The clarified and unfiltered portions were reacted with an Al-based reagent, e.g., calcium aluminate at a mass ratio of between 0.80 to 0.85 of soluble sulfate and fluoride concentration in the stream. The aluminum based reaction was maintained at a pH ~11 for a period of up 3.5 hours. It is believed that the following reaction occurs towards ettringite formation and sulfate removal:



[068] Table 11 compares the composition of the composite stream AHIK vs. the preliminary remedial goal (PRG) of a regulatory agency and the stream treated with calcium aluminate.

[069] Example 8: A portion of the untreated composite stream AHIK was combined with a portion of a filtered flotation tails permeate stream X at a volumetric ratio of 20:80 to generate a composite stream Y. The composite stream Y underwent the same treatment as in Example 7. Table 12 compares the compositions of stream X and composite stream Y versus the treated composite stream Y. All species of concern were lowered to PRG requirements.

[070] For purposes of this specification and appended claims, unless otherwise indicated, all numbers expressing quantities, percentages or proportions, and other numerical values used in the specification and claims, are to be understood as being modified in all instances by the term "about." Accordingly, unless indicated to the contrary, the numerical

parameters set forth in the following specification and attached claims are approximations that may vary depending upon the desired properties sought to be obtained by the present invention. It is noted that, as used in this specification and the appended claims, the singular forms "a," "an," and "the," include plural references unless expressly and unequivocally limited to one referent. The use of "including," "comprising," or "having," "containing," "involving," and variations thereof herein, is meant to encompass the items listed thereafter and equivalents thereof as well as additional items.

[071] This description uses examples to disclose the invention, including the best mode, and also to enable any person skilled in the art to make and use the invention. The patentable scope is defined by the claims, and may include other examples that occur to those skilled in the art. Such other examples are intended to be within the scope of the claims if they have structural elements that do not differ from the literal language of the claims, or if they include equivalent structural elements with insubstantial differences from the literal languages of the claims. All citations referred herein are expressly incorporated herein by reference.

Table 7

Species	Untreated (ppm)	Test 1	Test 2	Test 3	Test 4	Test 5	Test 6	Test 7	Test 8	Test 9	Test 10	Test 11	Test 12
F ⁻	7	6.8	7.2	6.4	3.5	6.5	6.2	6.3	3.3	6.2	<1	<1	<1
Cl ⁻	11	10	10	11	13	10	10	10	14	10	14	15	17
NO ₃ ⁻	8.6	3	2.8	3.2	3	3.3	2.9	3.1	3	3.4	3	4	3
SO ₄ ²⁻	800	900	900	900	920	900	890	890	890	910	430	630	520
PO ₄ ³⁻	-	-	-	-	-	-	-	-	-	-	-	<10	-
Al	0.065	0.0751	0.0461	0.004	<0.01	0.0058	0.0203	0.0303	<0.01	0.0151	<0.01	<0.01	0.065
As	<0.003	<0.003	<0.003	<0.003	<0.015	<0.003	<0.003	<0.003	<0.015	<0.003	<0.015	<0.015	<0.015
Cd	0.019	0.0172	0.0113	0.0049	<0.005	0.0124	0.0048	0.0047	<0.005	0.0046	<0.005	<0.005	<0.005
Co	0.130	0.0455	0.0318	<0.004	<0.02	0.0353	<0.004	<0.004	<0.02	<0.004	<0.02	<0.02	<0.02
Cu	<0.005	<0.005	<0.005	<0.005	<0.025	<0.005	<0.005	<0.005	<0.025	<0.005	<0.025	0.030	0.054
Fe	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1
Mn	25.6	15.4	15.2	<0.004	<0.02	15.2	0.0087	0.0099	<0.02	0.7	<0.02	<0.02	<0.02
Mo	2.100	1.7	1.7	1.8	1.1	1.8	1.8	1.8	1.1	1.8	1.0	1.3	0.9
Ni	0.260	0.2	0.0853	<0.010	<0.05	0.2	<0.010	<0.010	<0.05	<0.010	<0.05	<0.05	<0.1
P	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	1.9	<0.02
Si	5.500	5.8	5.7	2.8	2.4	5.8	3.1	3.1	1.6	3.6	0.1	4.1	1.2
Sr	4.100	3.9	4.0	3.6	3.8	4.0	3.5	3.5	3.8	3.6	2.2	0.9	1.0
Zn	1.890	0.83	0.4	<0.010	<0.1	0.6	<0.010	<0.010	<0.1	<0.010	<0.1	<0.1	<0.1

Table 9

Species	Untreated (ppm)	Test 1A	Test 1C	Test 1D	Test 2A	Test 2C	Test 2D	Test 3A	Test 3C	Test 3D	Test 4A	Test 4C	Test 4D
F ⁻	7	6.6	1.2	<1	6.8	<1	<1	7.2	1	<1	6.9	<1	<1
Cl ⁻	11	13	13	11	14	14	15	14	12	13	12	11	11
NO ₃ ⁻	8.6	4	16	3	9	15	14	3	2	3	4	5	3
SO ₄ ²⁻	800	940	370	350	980	500	510	1,000	470	480	1,000	190	270
PO ₄ ³⁻	-	-	-	-	-	-	-	-	-	-	-	-	-
Al	0.065	0.134	0.021	0.015	0.191	0.084	0.255	2.68	0.022	0.014	2.96	0.009	0.061
Cd	0.019	0.01	<0.005	<0.005	0.009	<0.005	<0.005	0.012	<0.005	<0.005	0.011	<0.005	<0.005
Co	0.130	0.015	<0.005	<0.005	0.017	<0.005	<0.005	0.007	<0.005	<0.005	<0.005	<0.005	<0.005
Fe	<0.1	0.009	0.038	0.03	0.016	0.093	0.039	0.056	0.076	0.031	0.812	0.011	0.01
Mn	25.6	11.4	<0.005	<0.005	11.2	<0.005	<0.005	8.14	<0.005	<0.005	6.1	<0.005	<0.005
Mo	2.100	0.939	0.672	0.998	0.313	0.310	1.02	0.029	0.073	1.1	0.048	0.062	0.307
Ni	0.260	0.115	<0.005	<0.005	0.119	<0.005	<0.005	0.119	<0.005	<0.005	<0.005	<0.005	<0.005
P	<0.1	<0.1	0.124	<0.1	<0.1	0.131	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1
Si	5.500	6.11	0.11	0.07	5.33	0.1	0.15	7.67	0.08	0.06	7.23	0.15	0.20
Zn	1.890	1.1	0.063	0.051	1.02	0.061	0.074	1.77	0.059	0.05	1.84	0.045	0.051

Table 9 (continued)

Species	Untreated (ppm)	Test 5A	Test 5C	Test 5D	Test 6A	Test 6B	Test 7A	Test 7B	Test 8A	Test 8B	Test 9A	Test 9B	Test 10
F ⁻	7	6.4	<1	<1	6	<1	6	<1	<1	<1	7	<1	<1
Cl ⁻	11	11	12	12	10	10	11	15	14	10	10	10	34
NO ₃ ⁻	8.6	8	10	3	4	4	3	4	3	3	3	3	3
SO ₄ ²⁻	800	1,100	470	480	1,200	750	1,200	740	430	900	1,200	880	640
PO ₄ ³⁻	-	-	-	-	-	-	-	-	-	-	-	-	-
Al	0.065	0.943	0.017	0.02	<0.01	0.0245	<0.01	<0.01	<0.01	<0.05	<0.010	<0.01	0.527
Cd	0.019	0.012	<0.005	<0.005	0.0122	<0.005	0.0101	<0.005	<0.005	<0.006	<0.005	<0.005	0.0076
Co	0.130	0.018	<0.005	<0.005	<0.02	<0.02	<0.02	<0.02	<0.02	<0.02	<0.02	<0.02	<0.02
Fe	<0.1	0.012	0.032	0.054	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1
Mn	25.6	11.2	<0.005	<0.005	13.2	<0.02	13	<0.02	<0.02	<0.02	<0.02	<0.02	<0.02
Mo	2.100	0.107	0.097	1.07	0.0705	0.407	0.1385	0.097	1.0	1	0.7	0.5	1.2
Ni	0.260	0.128	<0.005	<0.005	0.0932	<0.05	0.0843	<0.05	<0.05	<0.05	<0.05	<0.05	<0.05
P	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1	<0.1
Si	5.500	6.29	0.08	<0.05	4.4	<0.1	3.8	0.2	0.1	0.4	0.9	0.2	<0.1
Zn	1.890	1.44	0.054	0.069	0.3	<0.05	<0.1	<0.05	<0.1	<0.05	<0.073	<0.05	<0.05

Table 10

Stream	%	Sulfate	Fluoride	Nitrate	TDS	Soluble Metals (mg/L)									
ID	Comp	mg/L				Al	As	Cd	Co	Cu	Mn	Mo	Ni	Zn	
A	47.7%	1,000	24	9		870	29.90	0.0042	0.0223	0.1007	0.3860	13.7	0.0015	0.31	3.30
H	3.5%	12,000	110	4	5,590	8.00	0.1030	0.5400	3.4300	8.3700	453.1	0.0070	8.36	121.80	
I	23.8%	3,900	180	73	2,630	217.30	0.0189	0.1170	0.6900	7.0900	110.4	0.0150	2.60	26.95	
K	25.0%	1,800	7	4	1,605	0.02	0.0003	0.0003	0.0096	0.0002	19.4	6.5600	0.03	0.17	
Total	100.0%	2,273	60	23	1,637	66.33	0.0101	0.0573	0.3338	2.1642	53.4	1.6463	1.07	12.26	

Table 11

Stream / Species mg/L	TDS	F ⁻	SO ₄ ²⁻	NO ₃ ⁻	Al	As	Cd	Co	Cu	Mn	Mo	Ni	Zn
PRG Target value	1,000	1.60	600	44	1.86	0.010	0.0016	0.050	0.032	0.200	0.080	0.200	0.200
Untreated stream AHIK	1,637	60	2,273	23	66.33	0.0101	0.0573	0.3338	2.1642	53.4	1.646	1.07	12.26
Treated stream AHIK	<600	<1.5	<500	<20	<2	<0.001	<0.001	<0.001	<0.003	<0.050	<0.08	<0.01	<0.03

Table 12

Untreated Stream X	1,334	4	1,700	4	0.20	0.0006	0.0007	0.0004	0.0001	0.5	3.500	0.01	0.0009
Untreated Composite Y 20% AHIK & 80% X	1,393	15	1,812	8	13.18	0.0025	0.0118	0.0658	0.4249	10.9	3.136	0.22	2.41
Treated Composite Y	<600	<1.5	<500	<10	<2	<0.0003	<0.001	<0.001	<0.001	<0.015	<0.08	<0.01	<0.01

CLAIMS:

1. A method for treating a discharge stream to reduce the concentration of heavy metals and soluble contaminants, the discharge stream contains one or more metal ions selected from molybdenum, aluminum, manganese, nickel, cobalt, copper, zinc, arsenic, and vanadium, and at least a soluble anionic species selected from nitrate, sulfate, fluoride, and chloride, the method comprising:

contacting the discharge stream with at least a metal cation selected from divalent and trivalent metal cations and mixtures thereof, in an amount effective and at a pre-select pH for the at least a metal cation to form at least a complex with at least one of the heavy metals;

performing a liquid solid separation to remove the heavy metal complex forming a first effluent;

adding an additive selected from aluminum salts and phosphate additives and mixtures thereof to the first effluent for at least one of the soluble anionic species to form a precipitate at an alkaline pH;

performing a liquid solid separation to remove the precipitate to form a second effluent.

2. The method of claim 1, wherein the discharge stream is an acid mine drainage.

3. The method of claim 1, wherein the additive is a phosphate additive.

4. The method of claim 3, wherein the additive comprises a mixture of phosphoric acid and at least a salt of calcium bicarbonate.

5. The method of claim 3, wherein the additive is selected from the group of hydroxyapatite, hexametaphosphate, polyphosphate, monocalcium phosphate, dicalcium phosphate, tricalcium phosphate, calcium orthophosphates, calcium dihydrogen phosphate, phosphate fertilizers, phosphate rock, pulverized phosphate rock, calcium orthophosphates, animal bone phosphate, and combinations thereof.

6. The method of claim 3, wherein the additive is selected from monoammonium phosphate (MAP), diammonium phosphate (DAP), single superphosphate (SSP), triple superphosphate (TSP), and combinations thereof.

7. The method of claim 1, wherein the additive is calcium dihydrogen phosphate.

8. The method of claim 1, wherein the additive is an aluminate compound.

5 9. The method of claim 8, wherein the additive is selected from the group of calcium aluminate, calcium chloroaluminate, calcium sulfoaluminate, sodium aluminate, potassium aluminate, and mixtures thereof.

10. The method of claim 1, wherein the additive is calcium aluminate.

10

11. The method of any of claims 1 - 10, wherein the additive is added in a weight ratio of additive to total soluble anionic species ranging from 0.75:1 to 10:1.

12. The method of any of claims 1 - 10, wherein the additive is added in a weight
15 ratio of additive to total soluble anionic species ranging from 2:1 to 5:1.

13. The method of any of claims 1 - 10, wherein the additive is added in an amount ranging from 500 ppm to 10,000 ppm.

20 14. The method of any of claims 1 - 10, wherein the additive is added in an amount ranging from 1,000 to 6,000 ppm.

15. The method of any of claims 1 - 10, wherein the contact with the metal cation is at a pre-selected pH between 3.0 and 6.0.

25

16. The method of claim 15, wherein the contact is at a pH between 3.0 and 5.0.

17. The method of any of claims 1 - 10, wherein the contact is for a sufficient amount of time for at least 50% of the heavy metals to form insoluble complexes with the
30 metal cation.

18. The method of any of claims 1 - 10, wherein the pH of the first effluent is adjusted to a pH between 9 and 13.

19. The method of any of claims 1 - 10, wherein the effective amount of metal cation ranges from 6 to 50 ppm of metal cation to each ppm of heavy metals contained in the acid mine drainage.

5 20. The method of any of claims 1 - 10, wherein the at least a metal cation is a trivalent metal ion.

21. The method of any of claims 1 - 10, wherein the metal cation is selected from ferric chloride and ferric sulfate.

10 22. The method of any of claims 1 - 10, wherein the metal cation is a divalent metal ion.

15 23. The method of any of claims 1 - 10, wherein the metal cation is ferrous sulfate.

24. The method of any of claims 1 - 10, further comprising oxidizing the metal cation by aerating or adding an oxidizing agent to the discharge stream.

20 25. The method of any of claims 1 - 10, wherein the discharge stream contains molybdenum and the first effluent contains less than 0.08 ppm molybdenum.

26. The method of any of claims 1 - 10, wherein the discharge stream contains manganese and the second effluent contains less than 0.005 ppm manganese.

25 27. The method of any of claims 1 - 10, wherein the discharge stream contains nickel and the second effluent contains less than 0.010 ppm nickel.

28. The method of any of claims 1 - 10, wherein the discharge stream contains zinc and the second effluent contains less than 0.05 ppm zinc.

30 29. The method of any of claims 1 - 10, wherein the discharge stream contains aluminum and the second effluent contains less than 2 ppm aluminum.

30. The method of any of claims 1 - 10, wherein the liquid solid separation to remove the insoluble heavy metal complex forming a first effluent is via flocculation and clarification in an inclined plate settler.

31. The method of claim 30, wherein at least a flocculent is added to the inclined plate settler to bind the heavy metal complex.

32. The method of claim 31, wherein the flocculent is an anionic polymer.

33. The method of any of claims 1 - 10, wherein the pH of the first effluent is adjusted to 9.0 to 12.0 by adding lime.

34. The method of any of claims 1 - 10, wherein the at least a soluble anionic species is fluoride, the additive is calcium aluminate, and a sufficient amount of calcium aluminate is added to the first effluent to reduce the concentration of fluoride in the first effluent to less than 1 ppm.

35. The method of any of claims 1 - 10, wherein the at least a soluble anionic species is sulfate, the additive is calcium aluminate, and a sufficient amount of calcium aluminate is added to the first effluent to reduce the concentration of sulfate in the first effluent to less than 500 ppm.

36. The method of any of claims 1 - 10, wherein the pH of the second effluent is adjusted to less than 9 for on-site or off-site reuse or discharge.

37. A method for treating discharge streams to reduce the concentration of heavy metals and soluble contaminants in the discharge, comprising:

providing a discharge having a pH from 2.0 to 10.0, one or more heavy metal ions selected from molybdenum, cadmium, copper, manganese, nickel, aluminum, cobalt, zinc, arsenic, and vanadium, and at least a soluble anionic species selected from nitrate, sulfate, fluoride, and chloride;

contacting the discharge with ferric ion in an amount effective and at a pre-selected pH for the ferric iron to form at least an insoluble complex with at least one of the heavy metals;

performing a liquid solid separation to remove the heavy metal complex forming a first effluent;

adding a sufficient amount of calcium aluminate to the first effluent to cause at least one of the soluble anionic species to form a precipitate at an alkaline pH; and

5 performing a liquid solid separation to remove the precipitate, forming a second effluent.

38. A method for treating effluents from excavations and extractions to reduce the concentration of heavy metals and soluble contaminants in the effluents, comprising:

10 providing an effluent water having a pH from 2.0 to 10.0, one or more heavy metal ions or metal salts selected from molybdenum, tungsten, manganese, nickel, chromium, arsenic, and vanadium, and at least a soluble anionic species selected from nitrate, nitrite, sulfate, fluoride, and chloride;

15 contacting the effluent water with ferric ion in an amount effective and at a pre-select pH for the ferric iron to form at least an insoluble complex with at least one of the heavy metals;

performing a liquid solid separation to remove the heavy metal complex forming a first effluent;

20 adding at least a phosphate fertilizer to the first effluent to cause at least one of the soluble anionic species to form a precipitate at an alkaline pH; and

performing a liquid solid separation to remove the precipitate, forming a second effluent.

39. The method of claim 38, wherein the phosphate fertilizer is selected from the group of single superphosphate and triple superphosphate.

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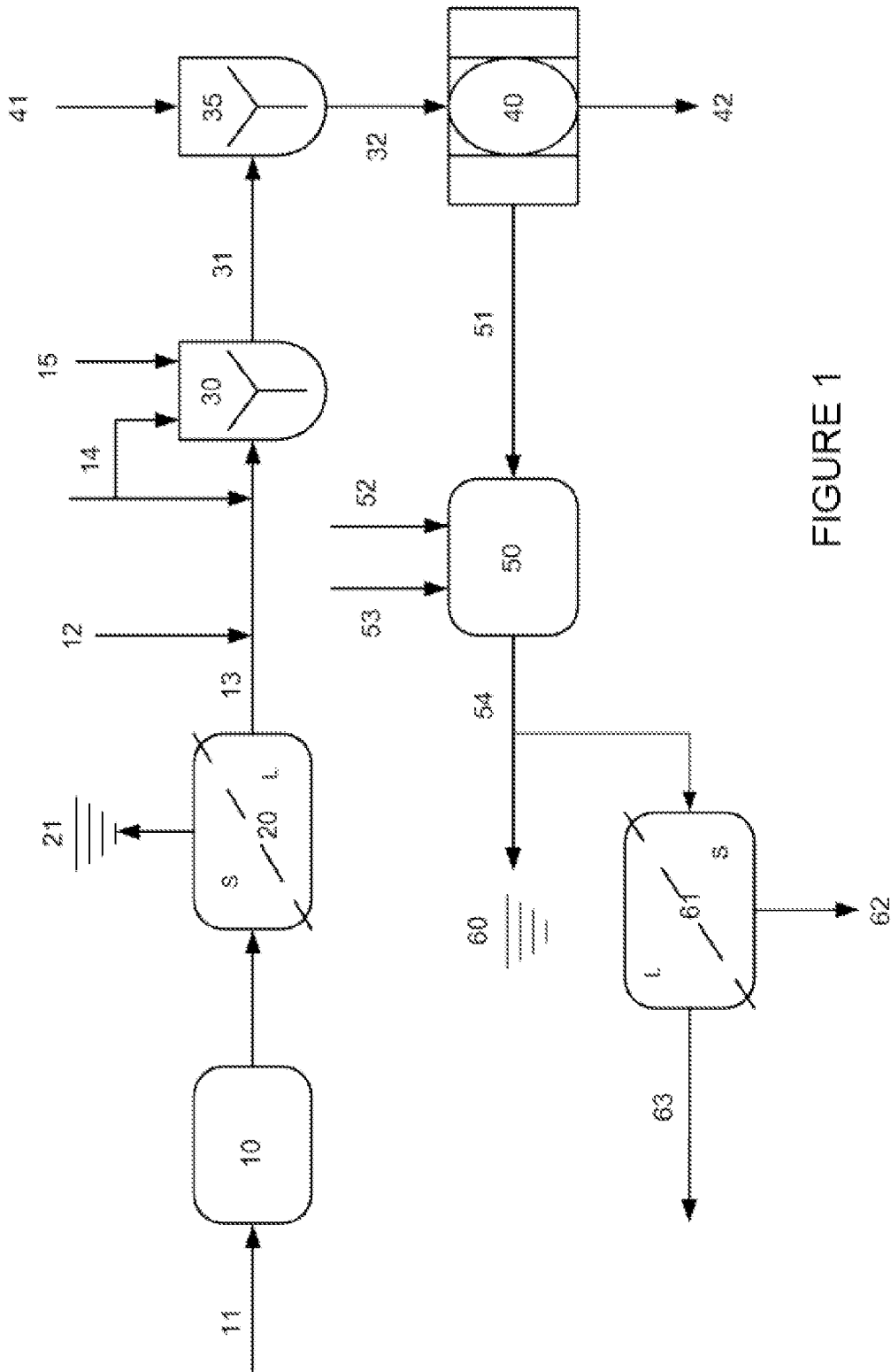


FIGURE 1

