

(54) Title of the Invention: **Processes for producing high biogenic concentration Fischer-Tropsch liquids derived from municipal solid wastes (MSW) feedstocks**

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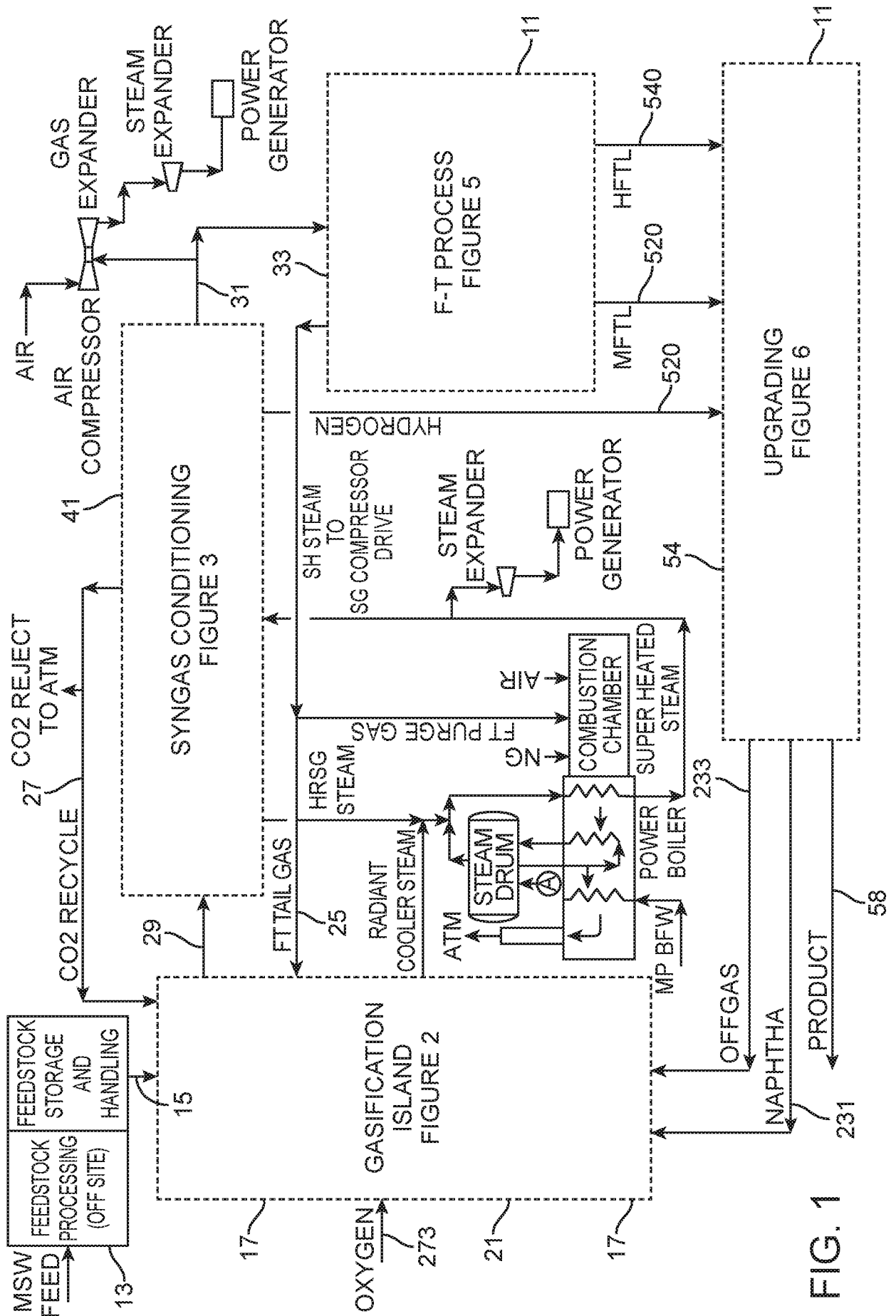


FIG. 1

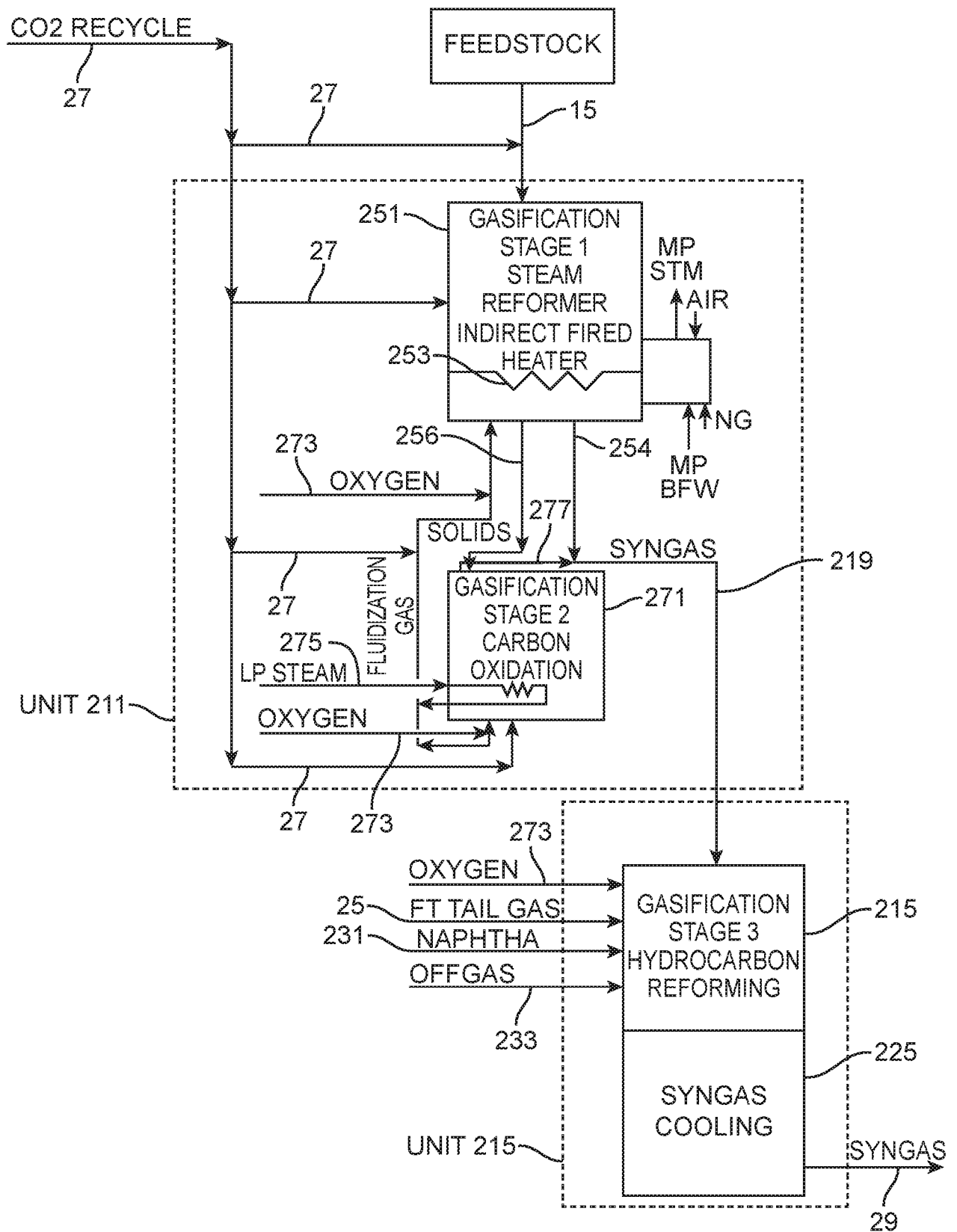


FIG. 2

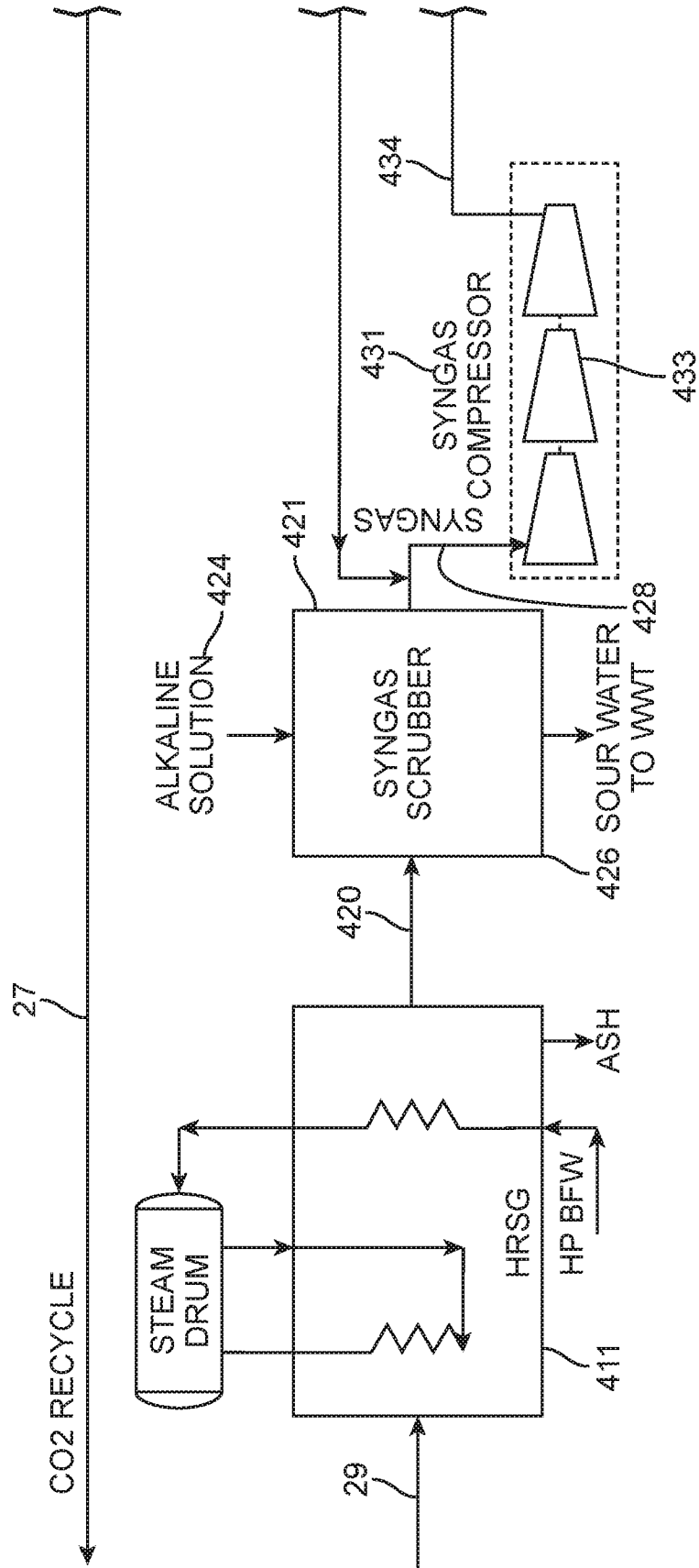


FIG. 3

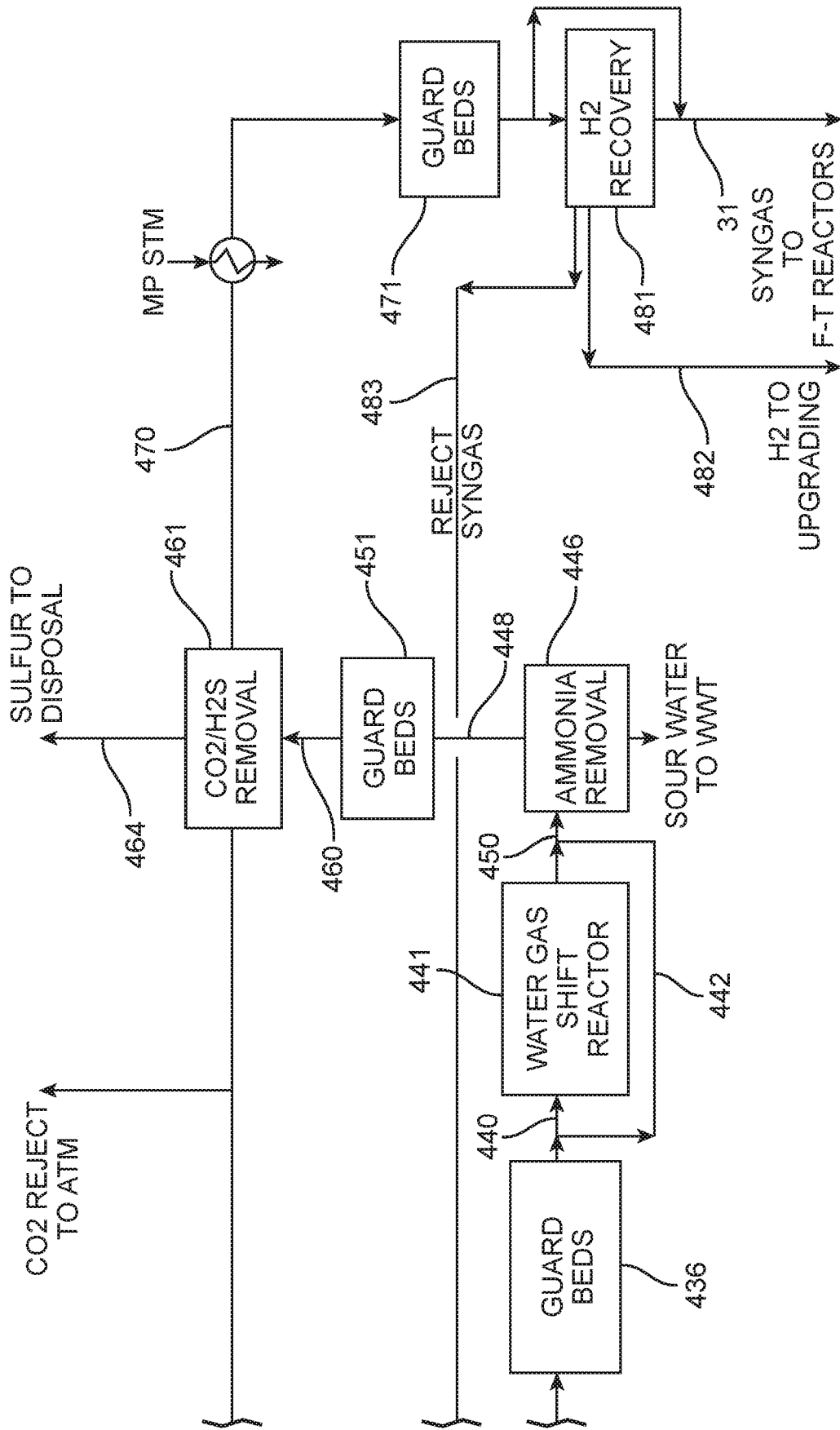


FIG. 3 (Cont.)

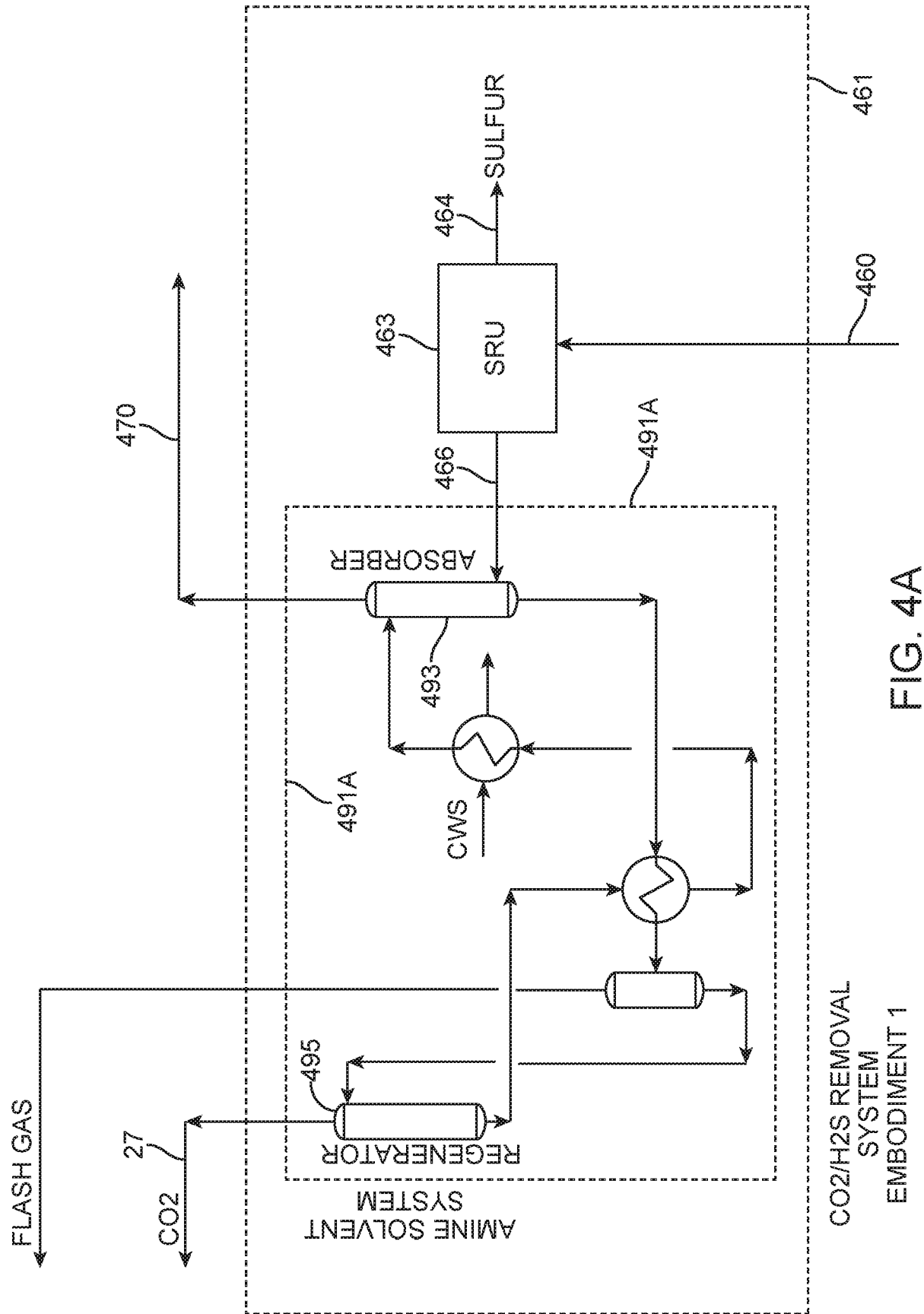
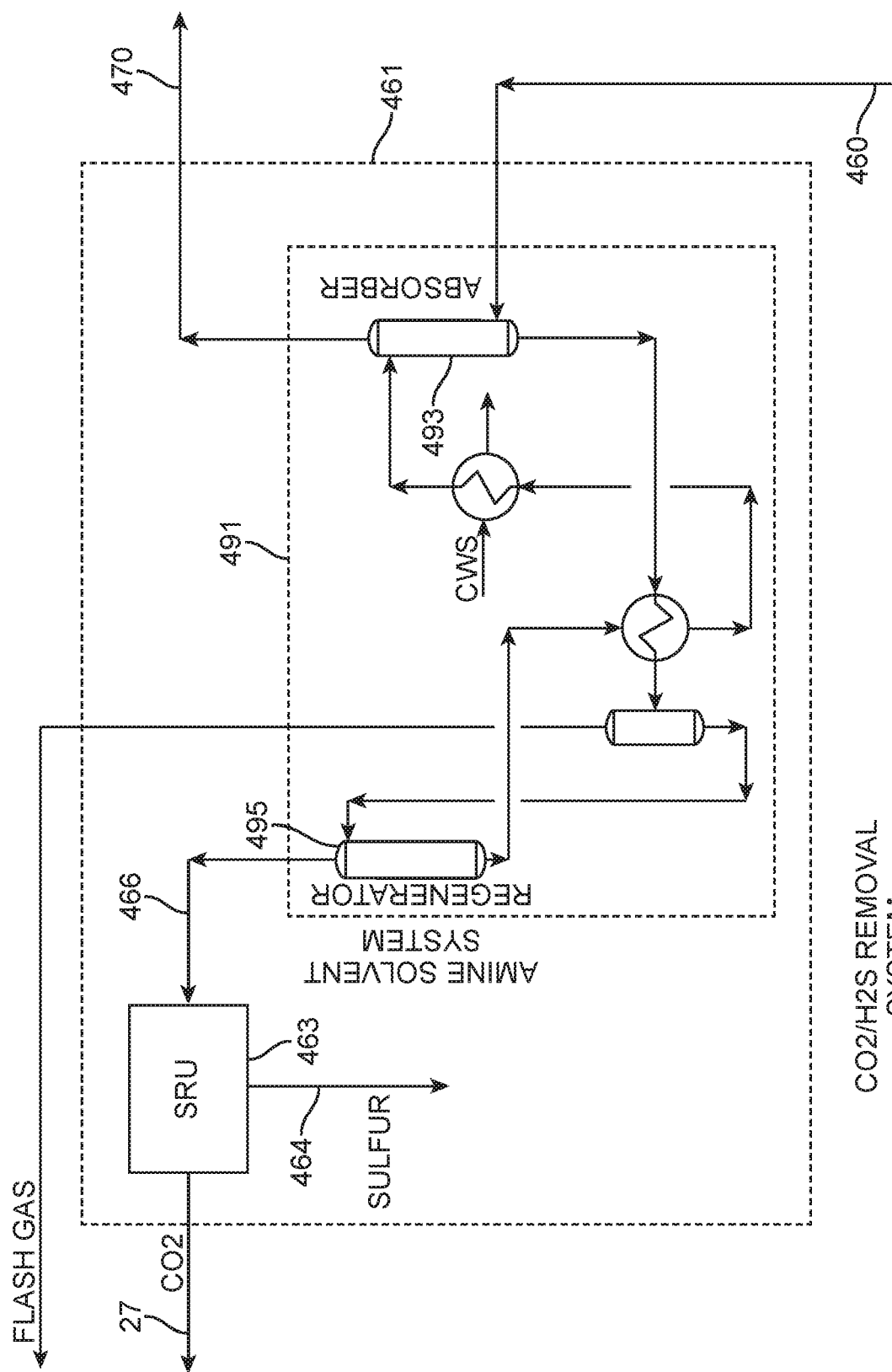


FIG. 4A

CO₂/H₂S REMOVAL
SYSTEM
EMBODIMENT 1



CO₂/H₂S REMOVAL
SYSTEM
EMBODIMENT 2

FIG. 4B

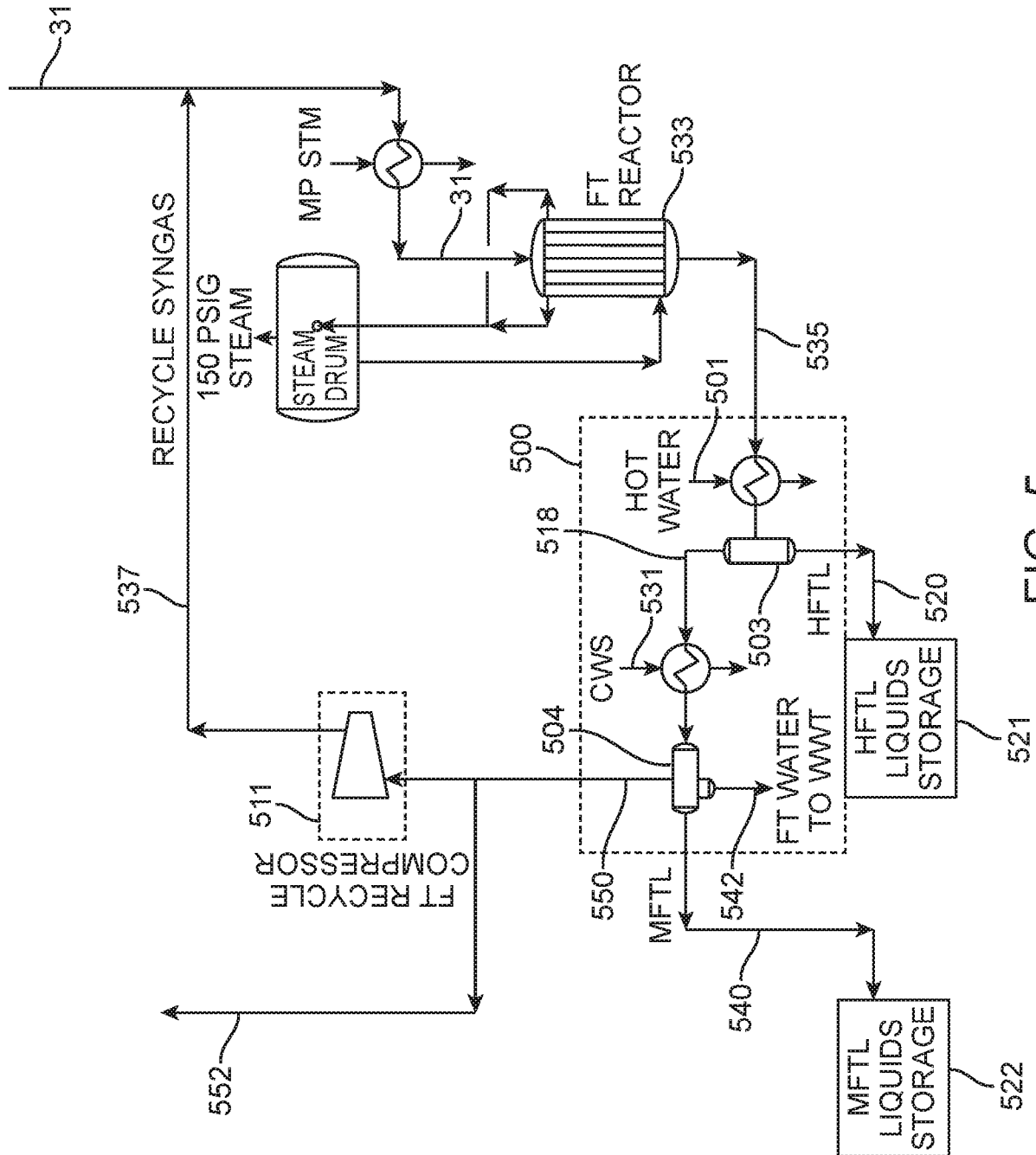


FIG. 5

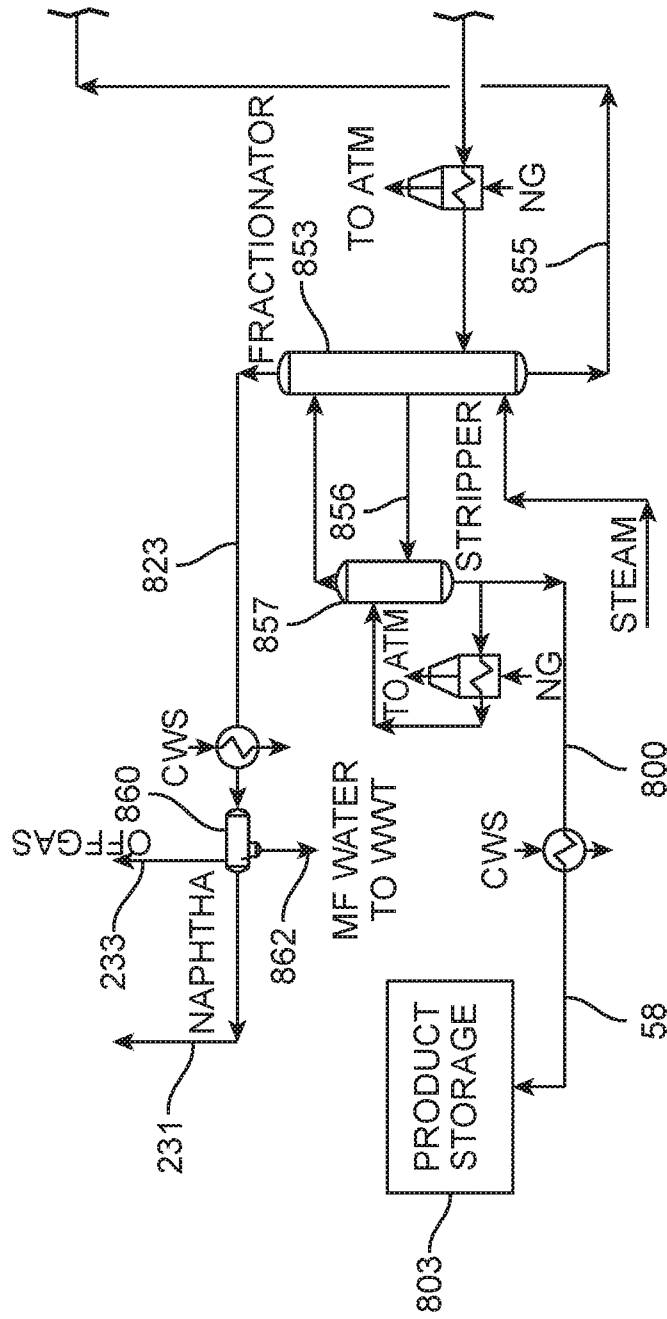


FIG. 6

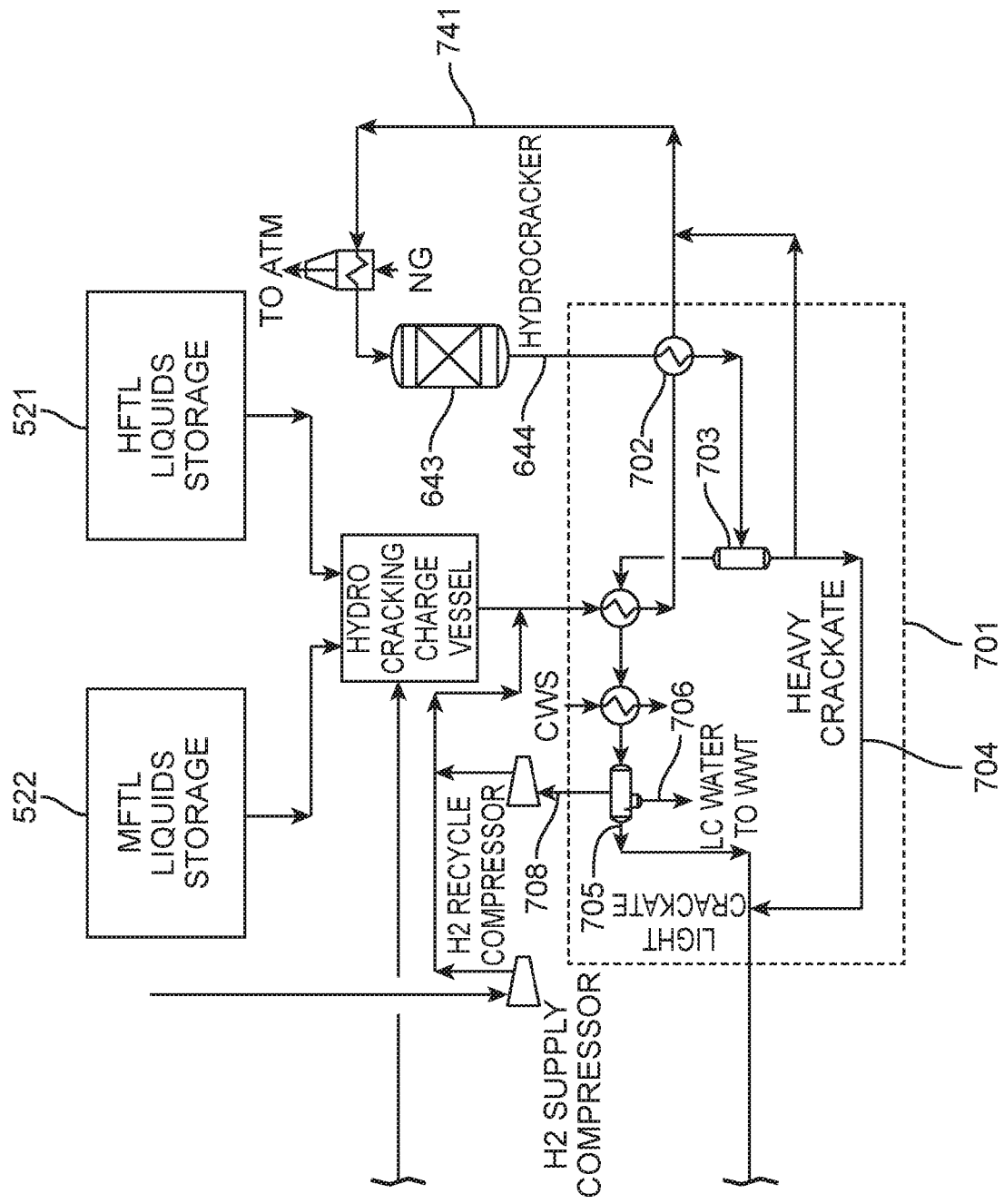


FIG. 6 (Cont.)

**PROCESSES FOR PRODUCING HIGH BIOGENIC CONCENTRATION
FISCHER-TROPSCH LIQUIDS DERIVED FROM MUNICIPAL
SOLID WASTES (MSW) FEEDSTOCKS**

TECHNICAL FIELD

[0001] The subject matter relates generally to processes, systems, and facilities for converting municipal solid wastes (MSW) into fuel.

BACKGROUND

[0002] Municipal solid waste (MSW) includes all solid materials disposed by municipalities. While some of this waste is recycled, the majority is typically dumped in landfills, where it decomposes over a period of decades or even centuries. It has been recognized that municipal solid waste contains organic materials that have energy content. If MSW is left untreated in landfills, the energy content can be drained slowly from the landfill by bacterial processes, which not only dissipate the concentrated energy but, also, produce methane, a strong greenhouse gas. Some landfills have sought to collect methane, which may be used for fuel; however, the conversion to methane takes place on long time scales and is rather ineffective in recovering much of the available energy content of the MSW.

[0003] The early method of recovering energy from MSW is incineration. Incineration includes the combustion of MSW or refuse-derived fuel (RDF) to produce heat, which typically powers a turbine to produce electricity. Byproducts of incineration include fly ash, bottom ash, and flue gases containing pollutants including sulfur compounds, CO₂, which is a green-house gas, acid gases as well as metals, metal compounds and particulates. Fly ash, when collected, and bottom ash are typically discarded in landfills.

[0004] Another method of recovering energy from MSW is pyrolysis. Pyrolysis involves heating the organic portions of the MSW to the point that thermally unstable compounds are chemically decomposed into other compounds. Those compounds mix with other volatile components to form a pyrolysis gas that typically includes tars, alkenes, aromatic hydrocarbons, sulfur compounds, steam, and carbon dioxide. The solid residues from pyrolysis include coke (residual carbon), which can be burned or used as a gasification feedstock.

[0005] A related method for recovering energy from MSW is gasification. Gasification involves converting at least a fraction of the MSW into a synthesis gas (“syngas”) composed mainly of carbon monoxide, carbon dioxide, and hydrogen. Gasification technology has existed since the nineteenth century, when coal and peat were gasified into “town gas” that provided a flammable

mix of carbon monoxide (CO), methane (CH₄) and hydrogen (H₂) that was used for cooking, heating and lighting. During World Wars I and II, biomass and coal gasifiers were used to produce CO and H₂ to meet transportation needs. Sometimes, some of the syngas was converted directly in to liquid transportation fuels using the Fisher-Tropsch process.

[0006] Gasification has been applied directly to the MSW but, in other cases, the MSW is first pyrolyzed, and then subjected to a secondary gasification process. Gasification of MSW generally includes a mechanical processing step that removes recyclables and other materials that have low or no energy content. Then, the processed MSW feedstock is heated in a gasifier in the presence of a gasification agent (including at least some oxygen and possibly steam). Gasifiers can have a number of configurations. For example, fixed-bed gasifiers place the feedstock in a fixed bed, and then contact it with a stream of a gasification agent in either a counter-current (“up draft”) or co-current (“down draft”) manner. Also, gasifiers may use fluidized bed reactors.

[0007] Another method of gasifying MSW is treatment in the presence of oxygen with a high-temperature plasma. Such systems may convert the MSW to syngas, leaving vitrified wastes and metals as byproducts.

[0008] To create hydrocarbons as synthetic fuels, a known method for converting syngas into synthetic fuels is the catalytic Fischer-Tropsch (F-T) process. This process produces a mixture of hydrocarbons which could be further refined to produce liquid transportation fuels.

[0009] With numerous detrimental effects of greenhouse gases being increasingly documented, there is a clear need to reduce energy production from fossil fuels, particularly from petroleum and coal-derived fuel sources. To encourage the reduction of fossil fuel usage, governments are promoting the usage of fuels derived from renewable organic sources rather than fossil-based sources.

[0010] The Environmental Protection Agency (EPA) in the United States has mandated a Renewable Fuel Standard (“RFS”) under which cellulosic-based fuels generate Cellulosic RINs (renewable identification numbers) which are a form of compliance credits for Obligated Parties (e.g., refineries). Under the RFS, the Obligated Parties are required to blend cellulosic fuel into fossil-derived fuels.

[0011] To determine the biogenic percentage content of fuels, the USEPA requires tests that use radiocarbon dating methods. More particularly, current USEPA regulations, at Section 8.1426(f)(9), require parties to use Method B or Method C of ASTM D 6866 to perform radiocarbon dating to determine the renewable fraction of the fuel.

BRIEF SUMMARY OF THE INVENTION

[0012] The present disclosure generally relates to processes and methods for converting organic materials, such as are contained in MSW, into fuels. More particularly, the present disclosure relates to processes for producing high biogenic concentration Fischer-Tropsch liquids and the respective upgraded fuel products derived from the organic fraction of municipal solid wastes (MSW) feedstocks that contain relatively high concentrations of biogenic carbon (derived from plants) and a relatively low concentration of non-biogenic carbon (derived from fossil sources) along with other non-carbonaceous materials. In practice, the relatively high concentration of biogenic carbon is up to about 80% biogenic carbon. Particularly noteworthy is that the high biogenic concentration Fischer-Tropsch liquids contain the same relatively high concentration of biogenic carbon as the feedstock derived from MSW.

BRIEF DESCRIPTION OF THE DRAWINGS

[0013] The accompanying drawings, which are incorporated into this specification, illustrate one or more exemplary embodiments of the inventions disclosed herein and, together with the detailed description, serve to explain the principles and exemplary implementations of those inventions. One of skill in the art will understand that the drawings are illustrative only, and that the depictions therein may be adapted, based on this disclosure, in view of knowledge within this field.

[0014] Various embodiments, including additions and modifications to the illustrated embodiment, of the present inventions are described herein in the context of converting feedstock derived from MSW waste into fuels.

[0015] In the Drawings:

[0016] **FIG. 1** shows one embodiment of an overall system for producing high biogenic concentration Fischer-Tropsch liquids derived from municipal solid wastes (MSW) feedstock; that contains a relatively high concentration of biogenic carbon and a relatively low concentration of non-biogenic carbons along with other non-carbonaceous materials;

[0017] **FIG. 2** shows an example of one embodiment of a gasification island;

[0018] **FIG. 3** shows an example of one embodiment of a syngas conditioning system;

[0019] **FIG. 4A** shows an example of one embodiment of a CO₂/H₂S removal system;

[0020] **FIG. 4B** shows an example of another embodiment of a CO₂/H₂S removal system;

[0021] **FIG. 5** shows an example of one embodiment of a system for generating F-T liquids; and

[0022] FIG. 6 shows an example of one embodiment of a system for producing refined F-T liquids from the system of FIG. 5.

DETAILED DESCRIPTION

[0023] Those of ordinary skill in the art will understand that the following detailed description is illustrative only and is not intended to be limiting. Other embodiments of the present inventions will readily suggest themselves to skilled persons having the benefit of this disclosure in light of what is known in the relevant arts.

[0024] In the interest of clarity, not all of the routine features of the exemplary implementations described herein are shown and described. It will of course, be appreciated that in the development of any such actual implementations, numerous implementation-specific decisions must be made in order to achieve the specific goals of the developer. Specific goals may include compliance with regulatory, safety, social, environmental, health, and business-related constraints; these specific goals will vary from one implementation to another and from one developer to another.

[0025] Throughout the present disclosure, relevant terms are to be understood consistently with their typical meanings established in the relevant art. However, without limiting the scope of the present disclosure, further clarifications and descriptions are provided for relevant terms and concepts as set forth below:

[0026] The term *municipal solid waste* (MSW) as used herein has the same meaning as the term is understood by one of skill in the art. An example of MSW is the solid waste that is obtained from the collection of commercial and household trash. In its raw form, MSW need not be entirely solid, as it may contain entrained or absorbed liquids, or liquids in containers or other enclosed spaces. One of skill in the art will understand that MSW will have a broad range of compositions, and that the source of MSW need not necessarily be from a municipality. For purposes of this disclosure, other organic waste materials and various biomass materials such as vegetative matter, may be equivalent to MSW.

[0027] The term *stream* as used herein means any fluid or solid moving or en route, directly or indirectly, from one location to another. A stream is still a stream even if it is temporarily stationary.

[0028] Reference to a *portion* of a stream or material refers to any portion of the stream or material, including the stream or material in its entirety. A portion of a stream or material may be

mixed with other compositions of matter and the mixture will be considered to comprise the portion of the original stream or material.

[0029] The term *in fluid communication with* as used herein includes both direct and indirect fluid communication, such as, for example, through an intermediate process unit.

[0030] The term *unit* as used herein means part of a system, and may for example comprise a unit operation, a system or group of unit operations, a plant, etc.

[0031] The term *syngas* (synthesis gas) as used herein has the same meaning as the term is used by one of skill in the art. For example, syngas may comprise a combination of carbon monoxide, hydrogen, carbon dioxide and possibly other components such as, without limitation, water vapor, sulfur or nitrogen-containing compounds, methane and other alkanes, hydrocarbons, acid gases, halogens and particulates.

[0032] The term *separator* as used herein refers to any process unit for performing a separation process. Depending upon context, a separator can include distillation columns, membrane separation systems, ion exchange adsorption systems, thermal adsorption, pressure swing adsorption, molecular sieves, flash drums, absorption or adsorption columns, wet scrubbers, venturi scrubbers, centrifuges, chromatographs, or crystallizers. Separators may separate vapors from liquids, liquids from liquids, vapors from liquids from solids, solids from solids, or fluids from solids.

[0033] The term *heat exchanger* as used herein includes without limitation any heat exchange device, and more broadly, any device which raises the enthalpy or internal energy of a first composition of matter, decreases the enthalpy or internal energy of a second composition of matter, and transfers heat from the second composition of matter to the first composition of matter. Various heat exchange means are disclosed herein, all of which are encompassed within this term. The term also includes combinations or series of multiple heat exchangers. It includes, without limitation, shell and tube heat exchangers, air or “fin-fan” coolers, refrigeration units, chillers, **cooling towers**, steam generators, boilers, plate heat exchangers, adiabatic wheel heat exchangers, plate fin heat exchangers, fluid heat exchangers, waste heat recovery units of any kind, or phase change heat exchangers of any kind. They may operate in a countercurrent, parallel, crosscurrent configuration, or any other flow configuration, and may involve separation of two fluids or direct contact between two fluids, or the use of an intermediate fluid (such as water, hot oil, molten salt, etc.) to transfer heat from one fluid to another.

[0034] The term *compressor* as used herein includes anything that is understood as a compressor in the normal sense of that term. In general, the term includes any device that raises a fluid from a

first pressure to a second, higher pressure, either adiabatically or non-adiabatically. It may include any kind of compressor or pump, including without limitation, centrifugal or axial, or positive displacement (such as reciprocating, diaphragm, or rotary gear). The term may also include one or more stages of a multi-stage compressor. The term *compressor* used in the singular may also refer to multiple compressors arranged in series and/or parallel.

[0035] In **Fig.1**, the numeral **11** designates an overall system for producing high biogenic concentration Fischer-Tropsch liquids derived from municipal solid wastes (MSW) feedstock that contains a relatively high concentration of biogenic carbon and a relatively low concentration of non-biogenic carbons along with other non-carbonaceous materials.

[0036] At the head of the system **11**, a MSW feedstock producing facility, generally designated by the numeral **13**, is provided for removing non-biogenic derived carbon materials and non-carbonaceous materials from MSW to produce a segregated feedstock that contains a relatively high concentration of biogenic carbon and a relatively low concentration of non-biogenic carbon along with other non-carbonaceous materials found in MSW.

[0037] In the preferred embodiment, the Feedstock Processing Facility **13** will process inbound MSW and separate materials into the following categories:

- Feedstock Material, sorted from MSW stream to be used for conversion into fuel;
- Recoverable Material, including but not limited to ferrous and nonferrous metals, cardboard, plastics, paper, and other recyclable materials that can be sorted and shipped to commodities markets; and
- Residual Material, which is the remainder of the material not recycled or used as feedstock, which can be sent to landfill.

[0038] By recovering plastics such as High Density Polyethylene (HDPE) and Polyethylene Terephthalate (PET) among others, the percentage of non-biogenic fossil-based carbon in the feedstock is reduced. Thus, the feedstock processing facility functions to provide a highly biogenic feedstock material that can be gasified into syngas. For the reasons explained above, the biogenic percentage content of the feedstock has a significant impact on the economic value of the cellulosic fuel.

[0039] In the feedstock processing unit **13**, the waste material may be sized, separated, and processed to remove materials that are not useful in the process, or which might reduce its efficiency. For example, the system removes metals, inorganic materials, and wet materials such as food waste or agricultural products. Such materials may, for example, be recycled or sent to a

landfill. Some of the food waste and agricultural materials which are high in biogenic content could be dried and added back to the feed stream along with other materials.

[0040] As indicated in the drawing, the Feedstock Processing Facility **13** can be physically separate facility from the other portions of the system shown in Fig. 1. As a example, the Feedstock Processing Facility **13** can be as described in co-pending United States patent application Serial No: 14/138,635 for Product Recycle Loops in Process for Converting Municipal Solid Waste into Ethanol, the disclosure of which is incorporated herein by reference.

[0041] Although the feedstock may vary greatly in composition, example nominal values for the composition of the material remaining after the feedstock is recycled and sorted are listed in **Table 1** below.

Table 1. Example Ultimate Chemical Composition of Feedstock

Feedstock Constituent	Approx. Weight (Percent)
C	45.4
H	5.7
O	33.8
N	0.7
S	0.11
Cl	0.09
Ash	4.21
Metal	1.4
H ₂ O	8.6

[0042] The residual materials preferably excluded by the processing, storage, and handling process may include, for instance, metals, rocks, dirt, glass, concrete, and PVC. Under normal conditions, the reject rate will run between about 10% and about 55% of the total feed rate to the material processing unit. Often, the rejects will be individually separated from the feedstock, deposited in a container, and transported to a landfill or composting operation, or sent for recycling or disposal off-site in accordance with applicable governmental regulations.

[0043] An important point is that the bio-refinery, generally designated by the numeral **17**, is fed with a stream **15** containing relatively high concentration of biogenic carbon and the relatively low concentration of non-biogenic carbons along with other non-carbonaceous materials from the

municipal solid wastes. In practice, the relatively high concentration of biogenic carbon is up to about 80% biogenic carbon.

[0044] The remainder of the system depicted in **Fig. 1** is the bio-refinery **17** for converting the stream **15** of processed feedstock into streams **520** and **524** of Fischer-Tropsch liquids.

Particularly noteworthy is that the high biogenic concentration Fischer-Tropsch liquids contain the same relatively high concentration of biogenic carbon as the input stream **15**. In other words, percentage-wise, no non-biogenic carbon is added to the Fischer-Tropsch liquids in the production system and, indeed, some may be eliminated.

[0045] In the illustrated embodiment, the bio-refinery **17** includes a gasification system, generally designated by the numeral **21** and sometimes referred to herein as the Gasification Island (GI), for converting feedstock derived from MSW into syngas and further processing that syngas through a hydrocarbon reformer (HR), as will be described below, to generate a high biogenic content syngas. It should be noted that the gasification system **21** receives streams **231** and **233** that carry recycled hydrocarbon products and intermediate products, respectively, to the HR. Also, the GI **21** receives a stream **27** that carries recycled CO₂ to its stage 1 and stage 2, both of which will be described in detail below. Also as will be explained further below, the recycled CO₂ is used for moderating the water-gas-shift reaction within the steam reformer in the GI **21** and as a purge gas for instruments, instrument systems and MSW feeder systems. Further, the GI **21** receives stream **273** of oxygen and a stream **25** of F-T tail gas.

[0046] In the gasification island **21**, generally speaking, the biogenic carbon is converted into biogenic syngas by a combination of steam reforming, sub-stoichiometric carbon oxidation and hydrocarbon reformation. The syngas product, including CO, H₂ and CO₂, is carried by stream **29** in the illustrated embodiment. The gasification reactions occurring in the GI **21** will be further described below.

[0047] The syngas stream **29** is processed in a syngas conditioning system **41**, as will be described in more detail below, to provide a syngas feed stream **31** to an F-T reactor system **33**. It should be noted that the syngas conditioning system **41** provides the CO₂ recycle stream **27** for recycling CO₂ back to the GI **21**.

[0048] The output from the F-T reactor system **33** comprises F-T fluids, including a Medium Fischer Tropsch Liquid (MFTL) stream **520** and a Heavy Fischer Tropsch liquid (HFTL) stream **540**, both of which are F-T hydrocarbons. Any unreacted syngas can be recycled in the F-T reactor **33** as will be described below. Further, the output of the F-T reactor system **33** includes the afore-mentioned stream **25** of F-T tail gas.

[0049] The bio-refinery includes a hydrogen recovery system to remove hydrogen that is needed for upgrading from the conditioned syngas. A portion of the conditioned syngas flows through a combination membrane/PSA unit to yield a high purity hydrogen stream for the upgrading unit. The recovered hydrogen (permeate) from the membrane is fed to a PSA unit and the retentate is combined with bypass syngas and fed forward to the FT reactor. The recovered hydrogen is fed to the PSA unit where a relatively pure hydrogen stream is produced (>99.5% H₂) and the PSA reject stream is routed to the suction of the syngas compressor for recovery of the reject syngas.

[0050] The bio-refinery 17 in **Fig. 1** further includes an upgrading system 54 for receiving the F-T fluids from the F-T system 33. In the illustrated embodiment, both the Heavy Fischer Tropsch liquid (HFTL) stream 540 and the Medium Fischer Tropsch Liquid (MFTL) stream 520 are fed to the upgrading system 54. The F-T liquids output liquid from the upgrading system 54 is carried by the stream 58 in the illustrated embodiment. In practice, the F-T liquids can include naphtha, diesel, Synthetic Paraffinic Kerosene (SPK), heavier alkanes along with iso-alkanes, oxygenates, and olefins or combinations of all of these components. Other outputs from the upgrading system 54 are the aforementioned stream 231 of naphtha and the stream 233 of off gas.

[0051] The gasification island system 21, as shown in detail in **Fig. 2**, implements a 3-stage gasification process. In the preferred embodiment, the 3-stage gasification process includes:

- a. Stage 1 - steam reforming;
- b. Stage 2 – sub-stoichiometric carbon oxidation to gasify unreacted carbon after steam reforming; and
- c. Stage 3 - hydrocarbon reforming.

[0052] In the illustrated embodiment, the stage 1 gasification unit 251 selectively receives the stream 15 of processed feedstock and produces a stream 254 of syngas. Gasification unit 271 receives unreacted carbon from gasification unit 251 and produces a stream 277 of syngas. Syngas streams 254 and 277 are combined to form syngas stream 219.

[0053] In the illustrated embodiment, the gasification unit, generally designated by the numeral 211, includes stage 1 and 2 units, generally designated by the numerals 251 and 271, respectively. It can be understood that unit 251 is a steam reformer wherein gasification is accomplished. Further it can be understood that unit 271 is a carbon oxidation system wherein unreacted carbon from the stage 1 gasification is converted into syngas sub-stoichiometrically. Also in the gasification island 21, hydrocarbon reforming is provided in a third stage by a hydrocarbon reforming system generally designated by the numeral 215.

[0054] In the illustrated embodiment, the stage 1 gasification unit **251** selectively receives the stream **15** of processed feedstock and produces a stream **254** of syngas. Gasification unit **271** receives unreacted carbon from gasification unit **251** and produces a stream **277** of syngas. Syngas streams **254** and **277** are combined to form syngas stream **219**. Also, the gasification unit **211** receives streams **27** of recycled CO₂. In the gasification unit **211**, the recovered high biogenic CO₂ in stream **27** can be used to assist in fluidizing the bed materials, moderating the water-gas-shift reaction and purging instruments in the steam reformer **251**, in the sub-stoichiometric carbon oxidation unit **271** and in the hydrocarbon reformer **215**. Also, the recovered high biogenic CO₂ in stream **27** can be added to stream **15** of processed feedstock as shown.

[0055] As mentioned above, the gasification unit **211** in the embodiment of **Fig. 2** includes the steam reformer **251** and the sub-stoichiometric carbon oxidation unit **271**. It is the steam reformer **251** that initially receives the steam **15** of processed feedstock. Also, it is the steam reformer **251** that initially receives the steam **273** of oxygen. Preferably, the steam reformer **251** includes an indirect heat source **253**. The output streams from the steam reformer **251** include a stream **254** of syngas and a stream **256** of solids. The syngas stream **254** is carried to the hydrocarbon reforming unit **215** with the stream **219**. The solids stream **256**, primarily comprised of ash and fine char, is carried to the sub-stoichiometric carbon oxidation unit **271**.

[0056] In the preferred embodiment, the steam reformer **251** is a fluidized bed system that utilizes superheated steam, CO₂, and O₂ as the bed-fluidizing medium. In another embodiment only steam and O₂ are used as a bed-fluidizing medium. Preferably, externally-fired indirect heaters **253** maintain the reformer bed temperature and provide much of the energy to support the endothermic reactions required in the gasification process. The process gas stream can exit the steam reformer **251** through a series of cyclones. Preferably, an internal cyclone separates and returns the majority of any entrained bed media to the reformer fluidized bed while a second external cyclone collects unreacted char for further conversion to syngas in the sub-stoichiometric carbon oxidation unit **271**. Preferably, flue gas from the steam reformer's indirect heaters is used in a fire tube boiler to generate steam for plant use.

[0057] The illustrated hydrocarbon reformer unit **215** receives the syngas stream **219** and produces the afore-mentioned primary stream **29** of syngas containing CO, H₂ and CO₂ along with trace constituents. Further, the hydrocarbon reformer unit **215** receives stream **273** of oxygen and stream **25** of F-T tail gas. Finally, the hydrocarbon reformer unit **215** receives the aforementioned streams **231** of naphtha and **233** of off gas.

[0058] The hydrocarbon reformer unit **215** operates to recover the biogenic carbon by thermally dissociating hydrocarbons at temperatures greater than 2200 degrees F (1204 degrees Celsius).

Heat for the hydrocarbon reformer is provided by oxidation of carbon monoxide and hydrogen. It may be noted that these reactions are exothermic.

[0059] The hydrocarbon reformer unit **215**, in the embodiment of **Fig. 2**, includes a syngas cooling section **225**. The syngas cooling section can comprise, for example, a radiant slagging cooler or a recycle syngas slagging quencher.

[0060] In preferred practice, the hydrocarbon reforming unit **215** is a refractory-lined vessel with oxygen gas burner/mixer which operates in the range of 1800°F to 3000°F (982.2 °C to 1649 °C) to assure all hydrocarbon compounds in the gas stream, including tars are converted to syngas, sulfur compounds are converted to H₂S, and the water gas shift reactions approach equilibrium. In the hydrocarbon reforming unit **215**, the F-T tail gas purged from the F-T reaction loop, the purification system off gas, and stream **231** of vaporized naphtha are converted back to CO and H₂.

[0061] The sub-stoichiometric carbon oxidation unit **271**, in addition to receiving the solids stream **256**, receives the stream **27** of recycled CO₂ stream and a stream **273** of oxygen. Heating in the carbon sub-stoichiometric oxidation unit **271** is provided by sub-stoichiometric oxidation of the unreacted carbon. A stream **275** of low pressure steam is superheated in the sub-stoichiometric carbon oxidation unit and used as fluidization steam for both stage 1 and stage 2 gasification. The output of the sub-stoichiometric carbon oxidation unit **271** is syngas stream **277** which, in the illustrated embodiment, joins with the syngas stream **254** from steam reformer **251** to form syngas stream **219** which is fed to the hydrocarbon reformer unit **215**.

[0062] In the preferred embodiment, the sub-stoichiometric carbon oxidation unit **271** utilizes a fluidized bed in which oxygen is added with the fluidization steam and CO₂ to further convert fine char to syngas. The gasses generated in and passing through the sub-stoichiometric carbon oxidation unit **271** pass through an external cyclone and re-enter the main syngas stream **219**. Preferably, the ash removed in the cyclone is cooled and transported to a collection silo for offsite disposal. Heat exchangers, submerged in the fluid bed of the sub-stoichiometric carbon oxidation unit **271** remove some heat by superheating low-pressure steam to 1100°F (593 °C)

for use in the fluidization bed steam reformer **251** and the fluidization bed of the unit **271** itself.

[0063] In operation of the system of **Fig. 2**, within the fluidized bed of the steam reformer **251**, externally fired heaters rapidly heat the circulating bed media and the feedstock entering the vessel. Almost immediately, the feedstock undergoes drying and pyrolysis, thereby creating

gaseous and solid (char) products. The gaseous pyrolysis products undergo water-gas shift reactions and together with simultaneous steam reforming of the solid char material, produce a syngas primarily made up of H₂, CO, CO₂, and some hydrocarbons. Most remaining char reacts with superheated steam and oxygen to produce syngas. Char that escapes the steam reformer is separated via a cyclone and dropped into the sub-stoichiometric carbon oxidation unit for additional gasification and conversion. The steam reformer and the sub-stoichiometric carbon oxidation unit utilize internal and external cyclones to separate and retain bed media that becomes entrained in the process gas stream. From the steam reformer **251** and the sub-stoichiometric carbon oxidation unit **271**, the syngas flows via stream **219** to the hydrocarbon reformer unit **215** to convert any remaining char, hydrocarbons, and tars into syngas.

[0064] As mentioned above, the output of the hydrocarbon reformer unit **215** is the syngas stream **29** which is fed to the syngas conditioning system **41** which will now be described in conjunction with **Fig. 3**.

[0065] As shown in **FIG. 3**, the exemplary syngas conditioning system, which has been generally designated by the numeral **41**, receives the primary syngas stream **29** and conditions that stream to produce the gaseous feed stream **31** to F-T reactors. In the illustrated embodiment, the syngas conditioning system **41** includes, sequentially in fluid flow communication, a Syngas Heat Recovery Steam Generator (HRSG) unit **411** for waste heat recovery, a syngas scrubber unit **421**, a syngas compressor **431**, a primary guard bed **436**, a water gas shift reactor **441**, ammonia removal unit **446**, secondary guard beds **451**, and a CO₂/H₂S removal system **461**. One output of the CO₂/H₂S removal system **461**, in the illustrated embodiment, is a syngas feed stream **470**. Another output of the CO₂/H₂S removal system **461** is the stream **27** of recycled CO₂.

[0066] As can be seen from the drawings, steam is generated from several sources inside the process. A HRSG recovers steam from the flue gas generated in the indirect fired heater unit **253** in the steam reformer unit **251**. Steam is also generated in the HRSG unit **411** that recovers heat from the syngas stream **29** leaving the gasification island and steam is generated in the power boiler. The steam from all three sources are combined and superheated to provide the medium pressure steam used as the motive fluid in either syngas compressor (i.e., unit **431**) steam turbine or a steam turbine power generator (**Fig. 1**). The combined medium pressure steam can have a biogenic content equal to the MSW feed depending on the quantity of natural gas used in firing the external heaters. In the preferred embodiment a portion of the generated syngas is fed to a gas turbine / steam turbine (combined cycle power plant) to generate a high biogenic content power that is used to supply the electrical demand of the plant. In another embodiment, all of the syngas

is used to generate steam for biogenic power and to drive the syngas compressor unit **431** with a steam turbine drive.

[0067] The syngas scrubber unit **421** is a conventional gas scrubbing device that receives the syngas stream **420** and a stream **424** of caustic or other suitable alkaline solution. The liquids removed from the scrubber unit **421** comprise sour water stream **426** which can be conveyed to a wastewater treatment system. The sour water may contain undesirable contaminants such as, for example, ash particles, acids, mercury, and acidic compounds such as hydrochloric acid (HCl) and hydrogen sulfide (H₂S) that are removed from the syngas. Thus, it can be appreciated that the syngas scrubber unit **421** is provided to remove contaminants that can potentially damage downstream equipment and affect the F-T synthesis catalyst performance.

[0068] Preferably, the syngas scrubber unit has three primary sections - a venturi scrubber, a packed tower section, and a direct contact cooler section. If a syngas quench cooler is utilized then approximately half of the cleaned syngas leaving the syngas scrubber unit will be circulated back to the hydrocarbon reformer quench cooler via the quench blowers while the remaining half will be compressed in the syngas compressor **431** to meet the requirements of the F-T synthesis process. If a radiant slagging cooler is employed the recycle gas blower will not be required and the flow into the scrubber will equal the flow leaving the gasification island **21**. Syngas scrubbing is further described in co-pending United States patent application Serial No: 14/138,635, the disclosure of which has been incorporated herein by reference. The scrubbed syngas is conveyed in stream **428**.

[0069] In the illustrated embodiment, a syngas compressor stage **431** comprising one or more conventional compressor stages **433** arranged in series to raise the pressure of a compressor inlet stream comprising at least a portion of the syngas stream to a predefined level, thereby outputting a compressed syngas stream **436**. In practice, the final pressure of the syngas stream **434** may range between about 400 psig to about 600 psig (about 2758 kPa to about 4137 kPa) to meet the process requirements of the F-T synthesis process. Preferably, the heat of compression is removed with intercoolers after all but the final stage with all condensed water being collected and sent to the waste water treatment plant for recovery. The outlet of the compressor is sent hot to primary guard bed **436** where any COS and HCN is hydrolyzed to H₂S and NH₃ and then to the shift reactor **441**.

[0070] In one embodiment, the syngas compressor drive is an extraction/condensing turbine that is driven by superheated high pressure steam with a portion of the steam extracted at low pressure for process requirements. Also, the F-T recycle compressor (unit **511** in Fig. 5) can be on the syngas compressor shaft and driven by the syngas compressor steam turbine drive. In another

embodiment the syngas compressor is driven by an electric motor which is energized from the power generated in a combined cycle power plant using syngas as a fuel to produce high biogenic power.

[0071] As also shown in **Fig. 3**, the water gas shift reactor **441** receives a portion of the pressurized primary syngas stream **440** to shift some of the steam and CO into H₂ and CO₂ via the water gas shift reaction until the required H₂/CO ratio in the outlet stream **450** is met. Subsequently, a side stream **442** of the pressurized primary syngas may bypass the water gas shift reactor **441** and may be recombined with an outlet stream **450** from the water gas shift reactor **441**. High pressure steam is generated in the water gas shift unit to remove the heat of the shift reaction. The generated steam is fed back into the syngas stream **440** feeding the reactor to provide the hydrogen source for the shift reaction. Any additional steam required can be provided by the plant steam system.

[0072] In the embodiment of **Fig. 3**, the outlet stream **450** of syngas from the water gas shift reactor **441** is conveyed to a conventional ammonia removal unit **446**. In the ammonia removal unit **446**, the syngas is cooled until the excess water condenses out with absorbed ammonia. Then, the syngas leaves the condenser **446** as stream **448**. The sour water from the condenser **446** can be conveyed to a wastewater treatment system. The stream **448** is conveyed to the inlet of the second guard bed **451** where any volatilized Hg is removed.

[0073] As further shown in **Fig. 3**, the pressurized primary syngas from the second guard beds **451** is conveyed as a stream **460** to the CO₂/H₂S removal system **461**. The CO₂/H₂S removal system **461** will be further described in conjunction with **Figs. 4A** and **4B**. One output of the CO₂/H₂S removal system **461** is a stream **464** of sulfur. Another output is a stream **470** of syngas from which sulfur has been removed. The third output is the CO₂ recycle stream **27**.

[0074] In the illustrated embodiment of **Fig. 3**, the syngas feed stream **470** is conveyed to H₂S and Arsine guard beds **471** and, then, to an H₂ recovery unit **481**.

[0075] Syngas from the H₂S/Arsine guard beds flows into the hydrogen recovery unit **481**. The hydrogen recovery unit **481** extracts a stream **482** of high purity H₂ which is required for the Hydrocracking Upgrading process, as described below. The output of the H₂ recovery unit **481** is the syngas feed stream **31** to the F-T reactor **33**. A third output from the hydrogen recovery unit **481** is a stream **483** of rejected syngas. The stream **483** can be recycled to join the stream **428**.

[0076] In the preferred embodiment, the hydrogen recovery unit (HRU) **481** extracts H₂ using a combination membrane and pressure swing adsorption ("PSA") system. The HRU membrane retentate gas is re-mixed with the bulk syngas stream and sent to the F-T Reactors. The HRU

PSA purge gas is routed to the suction of the Syngas Compressor **431** and the purified H₂ stream **482** is sent to upgrading.

[0077] As illustrated in **FIG. 5**, a system **33** for generating F-T liquids receives the syngas feed stream **31**. The system includes one or more F-T reactors **533** and provides, as mentioned above, the fluids output stream **535** that comprises F-T liquids and F-T tail gas. The F-T reactor output stream **535** is fed into a thermal separation system generally designated by the numeral **500** to separate the F-T liquid into its heavy F-T liquid (HFTL), medium FT liquid (MFTL), water and the F-T tail gas.

[0078] In the preferred embodiment as illustrated in **FIG. 5**, the thermal separation system **500** includes two condensers **501** and **531** and two separators **503** and **504**. The HFTL separator **503** has outlets **518** and **520**, respectively. In practice, the condenser **501** operates using a tempered hot water loop as the cooling medium to condense and separate the HFTL liquid fraction from the F-T water and MFTL liquid fraction. Both the MFTL Water and the FT Tail gas remain in a vapor phase. The HFTL stream is carried by the outlet **520** for storage in tank(s) **521** for further processing. In practice, the HFTL stream **520** is composed primarily of heavy hydrocarbon waxes which are solid at room temperature. These waxes are kept warm above 230°F (110 °C) to prevent solidification.

[0079] Also as illustrated in **FIG. 5**, the thermal separation system **500** includes the second condenser **531** that receives, via the stream **518** from the HFTL separator **503**, the F-T water and MFTL. In practice, the second condenser **531** uses cooling water to condense and separate the F-T water and MFTL from unreacted syngas and non-condensable hydrocarbons (i.e., methane, etc.). The condensed F-T water and MFTL stream phase split in the second separator **504**, with the MFTL stream routed to storage unit(s) **522** via stream **540** and the F-T water routed to waste water treatment via a stream **542**.

[0080] As **Fig. 5** further shows, the F-T tail gas can be recycled to the F-T reactors **533** via a stream **537**. In the illustrated embodiment, the F-T tail gas is separated at the MFTL separator **504** and carried by stream **550** to a compressor **511** whose output is conveyed on the syngas recycle line **537**. Prior to the recycle compressor **511**, a purge stream **552** branches off of stream **550**. The purge stream **552** can be directed to both the hydrocarbon reformer **215** via stream **25** (**Fig. 2**) to control hydrocarbon content in the recycle syngas and to the power boiler to purge inerts from the recycle syngas.

[0081] **FIG. 6** shows an example of one embodiment of the upgrading system **54** of **Fig. 1**. More particularly, this figure illustrates a system for producing refined F-T liquids from the system of

FIG. 5. The illustrated system includes a hydrocracker reactor unit **643** which receives liquids from hydrocracking charge vessel **524** fed by the aforementioned tanks **521** and **522** (**Fig. 5**). In the preferred embodiment, the hydrocracker reactor unit **643** employs a high temperature, high pressure catalytic process that upgrades the HFTL and MFTL hydrocarbon streams into a transportation fuel (SPK or Diesel). Due to the low severity of the upgrading, the hydro-processing and hydrocracking occur in one reactor. The olefins and alcohols are first saturated and then the alkanes are cracked into the SPK range of products. The hydrocracking mechanism, which involves a protonated cyclopropane intermediate, forms an isomer product along with a straight chained product. In the hydrocracker reactor unit **643**, the feed mixture passes through a series of catalyst beds for conversion into shorter chained hydrocarbons.

[0082] In an alternative embodiment, the pre-fractionate the MFTL can be pre-fractionated and there can be removal of the light fraction overhead to the hydrocarbon reformer; then, the heavy fraction along with the HFTL would be conveyed to the hydrocracker for upgrading. This embodiment removes most of the oxygenates from the stream flowing to the hydrocracker and lessens the hydrotreating load on the hydrocracker.

[0083] As further illustrated in **FIG. 6**, the hydrocracker reactor unit **643** provides the output stream **644** which is fed to a hydrocarbon thermal separation system generally designated by the numeral **701** wherein the crackate is cooled, condensed, and separated into two separate heavy and light crackate streams, using a series of heat exchangers and separator vessels.

[0084] In the illustrated embodiment of the, hydrocarbon thermal separation system **701**, the crackate is cooled in a feed/effluent heat exchanger **702** and the heavy crackate is separated from the light crackate in a heavy crackate separator **703**. From the heavy crackate separator **703**, the heavy crackate and light crackate are routed to a fractionator **853**, as by streams **704** and **750**. In addition, some of the heavy crackate can be recycled to the hydrocracker **643** to keep material flowing into the hydrocracker during startup and when the fractionation column is malfunctioning.

[0085] In the illustrated embodiment, a light crackate separator **705** is provided for separating the light crackate from generated water and hydrogen. The separated light crackate is routed to the fractionator **853** by stream **750**. The heavy crackate water is sent, as by line **706**, to the bio-refinery's waste water treatment plant for treatment. The separated hydrogen gas is routed to recycle as by streams **708**, **741** and **742**. Fresh hydrogen is introduced into the system by stream **741**.

[0086] The fractionation process in **Fig. 6** will now be described in greater detail. As previously mentioned, the fractionator **853** receives a stream **704** of heavy crackate liquids and a stream **750** of light crackate liquids. The purpose of the fractionator **853** is to separate the SPK or Diesel cut from the heavy crackate fraction and the naphtha fraction. The side draw stream **856** is fed into a stripper column **857** to remove lights from the SPK/Diesel feed and provide final clean up and recovery of the SPK/Diesel products. In the fractionator **853**, the incoming heavy and light crackate streams are combined and heated by natural gas fired heater for an initial separation in the fractionator column. Preferably, the fractionator **853** uses direct steam injection to strip the low boiling hydrocarbons from the high boiling hydrocarbons without utilizing a high temperature reboiler configuration.

[0087] The outputs from the fractionator **853** include overhead stream **23** that carries recyclable hydrocarbon products. Preferably, the overhead stream **823** which is provided into a condenser unit **860** where the stream is condensed and separated into three streams: main fractionator ("MF") water stream **862**, the afore-mentioned light phase (naphtha) stream **231**, and offgas stream **233**. In practice, a portion of the naphtha can be refluxed back into the fractionator **53** and/or a portion is sent to a Naphtha Vaporizer for injection into the hydrocarbon reformer. The offgas stream **233** is recycled by the off gas compressor to the hydrocarbon reformer for reprocessing. The bottoms from the fractionator column **853** are pumped to the hydrocracking charge vessel **524**, as by stream **855**, for additional hydrocracking. The water is sent to the bio-refinery's wastewater treatment plant for treatment.

[0088] Naphtha from the Fractionator OH Separator is pumped into the Naphtha Vaporizer where it is vaporized using low-pressure steam. The naphtha vapor then flow into the hydrocarbon reformer **215** of **Fig. 2** for recovery. The fractionation column overhead pressure floats on the offgas Compressor discharge rate. The offgas Compressor provides motive force to move the Fractionator Overhead Separator offgas into the discharge of the Naphtha Vaporizer. The combined streams then flow into the hydrocarbon reformer.

[0089] The SPK product, withdrawn by the steam **856** from the upper part of the fractionator **853**, is sent to the Product Stripper column **857** for final product separation. The heat to the product Stripper column **857** is provided, for example, by a natural gas fired Product Stripper Reboiler. The Product Stripper overhead stream recycles back to the Fractionator **853**. The bottoms stream **800** is cooled and sent, via the stream **58**, to storage unit **803** as the SPK product.

[0090] As shown in **FIG. 4A**, one embodiment of an exemplary CO₂/H₂S removal system **461** includes a sulfur removal unit **463** that receives the stream **460**. One output of the sulfur removal

unit **463** is a stream **464** of sulfur. Another output of the removal unit **463** is a stream **466** of syngas from which sulfurs have been removed.

[0091] The syngas stream **466** is fed to an amine solvent system, generally indicated by the numeral **491**. In the illustrated embodiment, the amine solvent system **491A** comprises an absorber unit **493** and a regenerator unit **495** connected in counter-current relationship. The output of the regenerator unit **493** is the aforementioned syngas feed stream **470**. The output of the absorber unit **495** is the aforementioned stream **27** of recycled CO₂.

[0092] In the preferred embodiment of **Fig 4A**, the absorber unit **493** is a column where CO₂ is removed by contact with a circulating amine/water solution. In this embodiment the amine absorber can remove H₂S from stream **466** in the event the sulfur removal unit under performs. The treated syngas is water washed to remove any entrained amine solution. In the preferred embodiment, the cleaned syngas leaving the solvent absorber **493** is heated using Medium Pressure (MP) saturated steam and routed, as stream **470**, to the guard bed to removal trace H₂S and arsenic catalyst poisons prior to introduction into the F-T synthesis process.

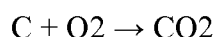
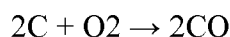
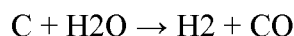
[0093] As shown in **FIG. 4B**, another exemplary CO₂/H₂S removal system **461** includes an amine unit where syngas stream **460** is fed to an amine solvent system, generally indicated by the numeral **491B**. In the illustrated embodiment, the amine solvent system **491B** comprises an absorber unit **493** and a regenerator unit **495** connected in counter-current relationship. The output of the regenerator unit **495** is fed to the sulfur removal unit **463**. The output of the absorber unit **493** is the aforementioned syngas feed stream **470**. In this embodiment, the absorber unit **493** is a column where CO₂ and H₂S is removed by contact with a circulating amine/water solution. The treated syngas is then water washed to remove any entrained amine solution and sent, as stream **470**, to the final guard beds **471**.

[0094] In embodiment of **Fig. 4B**, the regenerator overhead output stream **466** is fed to the sulfur removal unit **463** where the H₂S is removed from the reject CO₂ stream. One output of the sulfur removal unit **463** is the aforementioned stream **27** of recycled CO₂ and a stream **464** of sulfur. A portion of the overhead CO₂ reject stream from the Sulfur Removal unit is compressed and recycled back the gasification island and the excess is vented to the atmosphere.

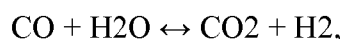
[0095] In operation of CO₂/H₂S removal system in **Figs. 4A** and **4B**, "rich" amine (i.e., amine after absorption of CO₂) from the absorber column passes through a lean/rich exchanger and then flashes into the Rich Solvent Flash Drum. The flashed gas, rich in CO and H₂, flows to the suction of the syngas compressor for reuse in the process. The flashed rich liquid stream flows to the Solvent Regenerator column. In the Solvent Regenerator, the rich solvent is heated in a steam

reboiler, driving off the absorbed CO₂/H₂S. The “leaned” solvent flowing out the bottom of the Solvent Regenerator is recirculated back via the lean/rich exchanger and the solvent cooler to the Absorber for reuse. A portion of the overhead CO₂ reject stream from the Solvent Regenerator is compressed and recycled back the gasification island and the excess is vented to the atmosphere. Preferably, the system is designed to reduce the CO₂ content in the syngas stream to <1 mol% and the H₂S content to <5ppmv, while minimizing the loss of CO and H₂.

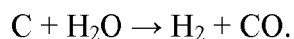
[0096] In the overall operation of the above-described system, multiple reactions take place as MSW is gasified. The major reaction occurs at elevated temperatures when char (carbon) reacts with steam to produce syngas primarily made up of hydrogen (H₂), carbon monoxide (CO), carbon dioxide (CO₂), and some hydrocarbons:



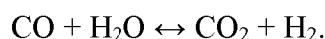
Simultaneously, the reversible “water gas shift” reaction



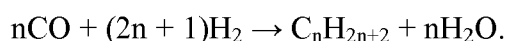
approaches equilibrium conditions with the CO/ H₂O and the CO₂/ H₂ ratios based on the equilibrium constant at the gasifier operating temperature. The gasification system may be configured, and conditions provided, so that at least the following gasification reaction occurs:



Simultaneously, conditions may preferably be provided so that the following reversible “water shift” reaction reaches an equilibrium state determined mainly by the temperature of the gasifier, the pressure preferably being near atmospheric:



The primary FT reaction converts syngas to higher molecular weight hydrocarbons and water in the presence of a catalyst:



[0097] Further as to the overall operation of system, it should be noted that the syngas produced in the gasification island **21** has an insufficient quantity of hydrogen for the effective production and upgrading of F-T liquids. The Sour shift reactor **441** generates additional hydrogen to increase the H₂:CO ratio in the syngas from about 0.8 to approximately 2.0. The water gas shift

reaction converts a portion of the CO and H₂O in the syngas to H₂ and CO₂. The reaction is exothermic and occurs over a sour shift catalyst. The reaction is a “sour shift” as H₂S is still present in the syngas stream. Utility steam and steam generated by the Shift Reactor **441** are mixed with the syngas to provide the water for the water-gas shift reaction and to moderate the temperature rise in the reactor. Hydrogen production and the syngas H₂:CO ratio are controlled by bypassing a portion of the syngas stream around the Shift Reactor. The Shift Reactor effluent heat is recovered by interchanging with the reactor influent syngas, generating shift reactor steam, and pre-heating boiler feed water.

[0098] The creation of fuel from MSW by the above-described system has significant advantages. It provides an energy efficient system with a very low emissions profile, reduces MSW entering landfills (thus dramatically reducing harmful methane gas emissions from landfills and mitigating the need for new or expanded landfills), reduces by displacement greenhouse gases associated with the use of petroleum and coal derived fuel products. The system increases the biogenic content of cellulosic-based fuels and, therefore, substantially increases the value of such fuels.

[0099] Exemplary embodiments have been described with reference to specific configurations. The foregoing description of specific embodiments and examples has been presented for the purpose of illustration and description only, and although the invention has been illustrated by certain of the preceding examples, it is not to be construed as being limited thereby.

CLAIMS

1. A process for producing high biogenic carbon content Fischer-Tropsch liquids derived from municipal solid wastes (MSW) that contain materials that are produced from plant derived carbon (biogenic) as well as non-biogenic derived carbon (fossil based) materials, the process comprising:
 - a) in a feedstock processing step, removing non-biogenic derived carbon materials and non-carbonaceous materials from the municipal solid wastes to produce a feedstock that contains a high concentration of greater than 50% biogenic carbon and a lower concentration of non-biogenic carbons along with other non-carbonaceous materials from the municipal solid wastes;
 - b) in a power generation process, converting some of the high biogenic carbon content material produced from the feedstock processing step into high biogenic power with reduced lifecycle greenhouse gas emissions; and
 - c) in a bio-refinery, converting biogenic carbon in the processed feedstock into syngas in a gasification island by a combination of steam reforming the processed feedstock to produce syngas and solids; followed by sub-stoichiometric carbon oxidation of the solids output from the steam reforming; and hydrocarbon reforming of the combined syngas from the steam reforming and sub-stoichiometric carbon oxidation; and converting the syngas into Fischer-Tropsch liquids while maintaining the high concentration of greater than 50% biogenic carbon and the lower concentration of non-biogenic carbon along with other non-carbonaceous materials from the municipal solid wastes.
2. A process according to claim 1 wherein, in the feedstock processing step, up to about 80% of the non-biogenic derived carbon materials are removed from the municipal solid wastes.
3. A process according to claim 1 wherein the relatively high concentration of biogenic carbon includes up to about 60% biogenic carbon.
4. A process according to claim 1 wherein the relatively high concentration of biogenic carbon includes up to about 90% biogenic carbon.
5. A system for producing high biogenic carbon concentration Fischer-Tropsch (F-T) liquids derived from municipal solid wastes (MSW) processed feedstock that contain a high concentration of greater than 50% biogenic carbon (carbon derived from plants) and a lower concentration of non-biogenic carbon (from fossil sources of carbon) along with other non-carbonaceous materials, said system comprising:
 - a) a bio-refinery for converting the processed feedstock into Fischer-Tropsch liquids while maintaining the high concentration of greater than 50% biogenic carbon and the lower concentration of non-biogenic carbon from the municipal solid wastes; and within the bio-refinery, a gasification island (GI) that provides at least gasification and sub-stoichiometric oxidation and hydrocarbon reforming of the processed feedstock that contain the high concentration of biogenic carbon, to produce syngas, wherein the GI selectively receives the processed feedstock and produces syngas containing CO, H₂, H₂O and CO₂; and selectively receives recycled hydrocarbon products and intermediate products to recover the biogenic carbon by hydrocarbon

reforming of the biogenic compounds; and selectively receives recycled CO₂; and wherein the gasification island is comprised of three stages:

1) a steam reformer which is arranged to receive the processed feedstock and is configured to dry, volatilize and gasify it to produce: syngas containing CO, H₂, H₂O and CO₂; and a stream of solids containing inert solids, unreacted char, and unreacted hydrocarbons; the steam reformer being arranged to pass the syngas to the hydrocarbon reforming unit and the stream of solids to the sub-stoichiometric carbon oxidation unit;

2) a sub-stoichiometric carbon oxidation unit arranged to receive the stream of solids from the steam reformer, a stream of recycled CO₂, and a stream of oxygen, and configured to gasify the stream of solids to produce syngas and to pass the syngas to the hydrocarbon reforming unit; and

3) a hydrocarbon reforming unit arranged to receive syngas streams from the steam reformer and the sub-stoichiometric carbon oxidation unit, a stream of oxygen, and a stream of F-T tail gas; and configured to convert any remaining char, hydrocarbons and tars into syngas by thermally dissociating at temperatures in the range of 982.2 to 1649 degrees C (1800 to 3000 degrees F); and wherein the hydrocarbon reformer unit further comprises a syngas cooling section to cool the dissociated hydrocarbons which are added to the syngas output from the gasification island;

b) a syngas conditioning unit configured to receive syngas from the gasification island;

c) one or more F-T reactors which receive syngas from the syngas conditioning unit and convert the syngas to F-T liquids; and

d) an upgrading system for producing refined F-T liquid from the F-T liquid output of the one or more F-T reactors, the upgrading system comprising a hydrocracker unit configured to receive the F-T liquid and a fractionator configured to receive heavy F-T liquids (HFTL) and medium F-T liquids (MFTL) from the hydrocracker.

6. A system according to claim 5 further comprising:
 - e) in a power generation process, converting some or all of the high biogenic carbon content material into high biogenic power with reduced lifecycle greenhouse gas emissions.
7. A system according to claim 5 wherein the relatively high concentration of biogenic carbon is up to about 80% biogenic carbon in both the feedstock and the Fischer-Tropsch liquids.
8. A system according to claim 5 wherein the high biogenic concentration Fischer-Tropsch liquids contain the relatively high concentration of biogenic carbon.
9. A system according to claim 8 further including: a syngas conditioning system and an F-T reactor that receives syngas from the syngas conditioning system.

10. A system according to claim 5 wherein the syngas conditioning unit provides recycled CO_2 to the GI system.
11. A system according to claim 9 wherein the F-T reactor provides FT liquids, including a heavy F-T liquid fraction (HFTL) and a medium liquid fraction MFTL, and F-T tailgas.
12. A system for producing high biogenic concentration Fischer-Tropsch liquids according to claim 5 wherein in said liquids include at least naphtha, diesel fuel and synthetic paraffinic kerosene (SPK).
13. A system for producing high biogenic concentration Fischer-Tropsch liquids according to claim 5 wherein CO , H_2 and CO_2 are recycled along with the recycled selected hydrocarbon products including naphtha and methane.
14. A system for producing high biogenic concentration Fischer-Tropsch liquids according to claim 5 wherein the recycled selected hydrocarbon products and intermediate products include tail gas from the Fischer-Tropsch process.
15. A system for producing high biogenic concentration Fischer-Tropsch liquids according to claim 5 wherein high biogenic carbon dioxide (CO_2) produced in the process is removed from the gas streams and a portion of the CO_2 is recycled to the gasification system.