Coke calcining systems
KVS Coke calcining systems

Metso provides systems and equipment for thermal processing of solid materials such as ores, minerals, bulk granular chemicals, agricultural products, and waste materials to change their physical and/or chemical properties.

With over 80 years of successful experience in serving the minerals and chemical processing industries, Metso has the proprietary technology and know-how to design and build coke calcining systems best suited to the specific requirements of each customer.

Proven experience
Metso is the world's leading supplier of coke calcining systems and equipment, having furnished 50 plants representing approximately 70 percent of the world's coke calcining capacity. These plants range in capacity from 50,000 STPY to over 400,000 TPY.

Energy efficient
Due to the rotating action in a rotary kiln, the coke bed is in constant gentle motion exposing coke particles to the process heat. Additionally, the incinerator will convert volatile matter and fine coke particles entrained in the kiln exit gases into energy for steam and/or electrical power generation.

Flexibility in operations
KVS rotary kilns can handle a wide range of green coke feeds including needle, sponge, shot, fluid or tar pitch green cokes. The rotary kiln is also able to optimize the coke calcining operating parameters, be it residence time, temperature gradient, and heat up rate, all of which impact product quality.

Product quality
KVS' coke calcining systems can produce a quality product specification from sponge, needle, shot, fluid or tar pitch cokes. The real and vibrated bulk densities are optimized in the KVS rotary kiln calcining system. Also, fines in the calcined product are decreased thus enhancing critical elements of product quality.
Coke calcining systems

Rotary Kiln
The KVS rotary kiln is a tried and proven technology successfully used in various pyro-processing industries around the world. Rugged construction and conservative design is the trademark of KVS's rotary kilns. Operators find them easy to operate and maintenance is minimal.

Calcining of petroleum coke is done in the rotary kiln. The kiln components consist of shell, tires, carrying stations, seals, refractory and a drive train which includes girth gear, pinion, speed reducer and variable speed motor. The drive train also includes an auxiliary drive for use during startup and periods of power failure.

Burner systems
Process heat is furnished to the rotary kiln from two sources. The first is the kiln burner system, which can be designed to handle gaseous, liquid, or solid fuels. The second source of process heat is the burning of a controlled amount of the evolved volatile matter and a small amount of coke fines in the kiln.

Combustion of volatile matter is enhanced by the introduction of secondary and tertiary combustion air. Secondary air is introduced through the firing hood and tertiary air introduced through ports in the kiln shell to control combustion of the volatile matter and coke fines. Tertiary air utilization results in significant reduction in kiln fuel requirements.

Afterburners
KVS cylindrical afterburners are designed for sufficient residence time, temperature, and effective mixing to affect the required volatile matter and particulate combustion. Combustion air to the afterburner is furnished by a combustion air fan and preheated air from the cooler exhaust system. Afterburners can be designed for 100% firing capacity when the kiln is down, thus providing the operator uninterrupted steam production and/or electrical power generation.
Coolers
Metso’s rotary cooler design utilizes both a direct water quench of the hot coke at the cooler entrance and counterflow movement of ambient air to cool the coke. The direct quench type is the most widely used method of cooling in the coke calcining industry.

Kiln feed pipe
The stainless steel double wall construction, refractory lining, and forced fluid cooling of the pipe enhances the design reliability and extends its operating life. A carbon steel ‘Y’ piece outside the kiln hood provides easy cleanout access.

Air seals
Metso’s air seals (marketed as Goodeal and Superdeal seals) with their overlapping steel plates provide an air seal that significantly reduces ambient air infiltration into the rotary kiln. By limiting air infiltration, fuel efficiency is improved and power consumption is reduced. The seals’ simple, yet effective design requires little maintenance and allows for easy replacement.

Heat recovery/air pollution control equipment
Metso’s total project capabilities provide the client with a ‘one stop shopping’ approach. Metso includes in our total equipment package waste heat boilers to recover a large percentage of heat released in the afterburner and air pollution control systems to meet applicable environmental regulations.
Programmable Logic Controller (PLC)
A Programmable Logic Controller (PLC) – the heart of the control system – provides monitoring and interlocking functions. The PLC constantly checks for any abnormal conditions. Based upon its intended sequence, the PLC will take appropriate corrective action to keep the process or sequence within proper operating conditions. Metso programs and pre-commissions the PLC at its facility before shipping to the calcining plant. Metso supplies the Man-Machine Interface software, which provides access to the operating system through industrial personal computers. The total coke calcining plant as well as exploded details of sections of the plant area are readily available to the system operator through the graphic screens provided by Metso.

Optimization Control System (OCS)
Metso has developed an advanced control system using our proprietary Optimization Control System (OCS), which is superimposed on top of the PLC control system. OCS is an upper level control application used to determine set points and to stabilize and maximize coke kiln performance. This software can be run on the same computer as the existing Man-Machine Interface or on a stand-alone computer. The OCS will execute a proprietary set of rules created by Metso for the coke calcining system. OCS has improved product quality, system capacity, fuel and electrical consumption.
Technical specification
<table>
<thead>
<tr>
<th>Item</th>
<th>Green coke</th>
<th>Calcined coke</th>
</tr>
</thead>
<tbody>
<tr>
<td>Moisture</td>
<td>6%-14%</td>
<td>0.1%</td>
</tr>
<tr>
<td>Volatile Matter</td>
<td>8%-14%</td>
<td>0.5%</td>
</tr>
<tr>
<td>Sulfur</td>
<td>1.0%-4.0%</td>
<td>1.0%-4.0%</td>
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<tr>
<td>Silicon</td>
<td>0.02%</td>
<td>0.027%</td>
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<tr>
<td>Iron</td>
<td>0.013%</td>
<td>0.02%</td>
</tr>
<tr>
<td>Nickel</td>
<td>0.02%</td>
<td>0.03%</td>
</tr>
<tr>
<td>Ash</td>
<td>0.25%</td>
<td>0.4%</td>
</tr>
<tr>
<td>Vanadium</td>
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<td>0.3%</td>
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<tr>
<td>Bulk Density</td>
<td>45-50 PCF</td>
<td>45-50 PCF</td>
</tr>
<tr>
<td></td>
<td>(720-800 Kg/m³)</td>
<td>(720-800 Kg/m³)</td>
</tr>
<tr>
<td>Real Density</td>
<td>2.06 g/cm³</td>
<td></td>
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</table>

Table 2. Typical needle coke specifications

<table>
<thead>
<tr>
<th>Item</th>
<th>Green coke</th>
<th>Calcined coke</th>
</tr>
</thead>
<tbody>
<tr>
<td>Moisture</td>
<td>6%-14%</td>
<td>0.1%</td>
</tr>
<tr>
<td>Volatile Matter</td>
<td>4%-7%</td>
<td>0.5%</td>
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<tr>
<td>Sulfur</td>
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<td>0.5%-3.0%</td>
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<tr>
<td>Silicon</td>
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<td>0.025%</td>
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<tr>
<td>Iron</td>
<td>0.013%</td>
<td>0.02%</td>
</tr>
<tr>
<td>Nickel</td>
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<td>0.03%</td>
</tr>
<tr>
<td>Ash</td>
<td>0.25%</td>
<td>0.4%</td>
</tr>
<tr>
<td>Vanadium</td>
<td>0.01%</td>
<td>0.02%</td>
</tr>
<tr>
<td>Bulk Density</td>
<td>45-50 PCF</td>
<td>45-50 PCF</td>
</tr>
<tr>
<td></td>
<td>(720-800 Kg/m³)</td>
<td>(720-800 Kg/m³)</td>
</tr>
<tr>
<td>Real Density</td>
<td>2.11 g/cm³</td>
<td></td>
</tr>
</tbody>
</table>

Reference no. description

101 Kiln feed bin
102 Weigh feeder
103 Feed hood
104 Rotary kiln
105* Tertiary air system
106 Firing hood
107 Firing system
108* Secondary air fan
109 Transfer chute
110* Cooler inlet w/water quench
111 Rotary cooler
112 Cooler discharge housing
113 Dust collector
114 Product conveyor
115 Cooler exhaust fan
116 Afterburner
117 Bypass and draft control guillotine dampers
118 Waste heat boiler
119 Induced draft fan
120 Natural draft stack
121 Baghouse dust collector
122* Dust bin
123* Control room
124* Mcc room

*Denotes items not shown
• Metso Minerals Industries Inc.
  350 Railroad Street, Danville, PA 17821-2046, USA, Phone: +1 570 275 3050, Fax: +1 570 275 6789

• Metso Minerals Industries, Inc.
  2715 Pleasant Valley Road, York, PA 17402, USA, Phone: +1 717 843 8671

• Metso Minerals (South Africa) (Pty) Ltd.
  Private Bag X2006, Isando, Johannesburg, 1600, South Africa, Phone: +27 11 961 4000, Fax: +27 11 397 2050

• Metso Minerals (Australia) Ltd.
  Level 2, 1110 Hay Street, West Perth, WA 6005, Australia, Phone: +61 8 9420 5555, Fax: +61 8 9320 2500

• Metso Minerals (India) Pvt Ltd
  1th floor, DLF Building No. 10, Tower A, DLF Cyber City, Phase - III, Gurgaon - 122 002, India, Phone: +91 124 235 1541, Fax: +91 124 235 1601

• Metso Perú S.A.
  Calle 5 Nro. 144, Urb. Industrial Vulcano, Ate, Lima 03, Peru, Phone: +51 1 313 4366, Fax: +51 1 349 0913

• Metso Minerals (Chile) S.A.
  Av. Los Conquistadores 2758, - Piso 3, Providencia, Santiago, Chile, Phone: +56 2 370 2000, Fax: +56 2 370 2039

• Metso Brasil Indústria e Comércio Ltda.
  Av. Independência, 2500 Eden, 18087-101 Sorocaba-SP - Brazil, Phone: +55 15 2102 13009

• Metso Minerals (Sweden) AB
  Norängsgatan 2, SE-733 38 Sala, Sweden, Phone: +46 224 571 00, Fax: +46 224 169 50

www.metsocom
E-mail: pyro@metso.com