

HYDROGEN PEROXIDE in an ECF BLEACH PLANT: CENIBRA's INDUSTRIAL EXPERIENCE

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ABSTRACT:

With the purpose of expanding production of ECF bleached eucalyptus Kraft pulp, CENIBRA evaluated in laboratory and mill tests alternatives with the application of hydrogen peroxide in its ECF bleaching sequence $D_0EoD_1D_2$. The addition of hydrogen peroxide in this production line aims at a chlorine dioxide demand optimization and an increase of the production, maintaining $90 \pm 0.5\%$ ISO brightness. The following sequences were investigated: $D_0EopD_1D_2$, D_0EoD_1P , $D_0EoD_1(QP)$ and D_0EopD_1P . Industrial results confirmed the laboratory tests, showing replacement rates varying from 1.1 to 2.4 kg ClO_2 /kg H_2O_2 . More attractive replacement rates were obtained for the addition of 2.5 kg H_2O_2 /adt in the last bleaching stage (D_0EoD_1P). However, a larger substitution of the total chlorine dioxide demand was found with the sequence D_0EopD_1P (5 kg H_2O_2 /adt divided between both application points), which decreased the demand by 7.7 kg of ClO_2 /adt for kappa number 8.6 pulp. In addition, pulp and effluent characteristics are described for each alternative, as well as corrosion rates of titanium under alkaline conditions (pH < 11), with low concentrations of hydrogen peroxide (< 0.1%). Results show that the addition of hydrogen peroxide in existent bleaching plants allows increased production without a modification of the chlorine dioxide generation at acceptable levels for operation costs and pulp properties.

Key Words: ECF peroxide bleaching; sequence flexibilization; production increase; replacement of ClO_2/H_2O_2 ; titanium corrosion; Eucalyptus spp.

1. INTRODUCTION

During the last two decades, pulp-bleaching plants underwent a large number of modifications. Bleaching processes using chlorine chemicals still dominate and will maintain this dominance. Modern bleaching technology makes use of oxygen and oxygen derivatives, such as hydrogen peroxide, peracids and ozone. In their implementation special attention must be given to the bleach plant material compatibility in order not to destroy the equipment.

2. OBJECTIVE

This paper demonstrates CENIBRA's laboratory and plant experience with the application of hydrogen peroxide in the $D_0EoD_1D_2$ type ECF bleaching sequence. The aim was to increase the production flexibility and to substitute a part of the chlorine dioxide with hydrogen peroxide for market brightness ($90 \pm 0.5\%$ ISO). The existing capacity for the generation of chlorine dioxide should be sufficient despite the production increase. The existing bleach plant should be used and not be affected by corrosion.

3 - EXPERIMENTAL

For comparison purposes, in the laboratory and at plant level the implementation of hydrogen peroxide in the ECF - $D_0EoD_1D_2$ bleaching sequence was investigated, aiming at a brightness of $90 \pm 0.5\%$ ISO. Thus, the bleaching sequences evaluated were: $D_0EopD_1D_2$, D_0EoD_1P , $D_0EoD_1(QP)$ and D_0EopD_1P . Table 1 shows the most important conditions. In sequence $D_0EoD_1(QP)$ a chelating agent at a constant dosage of 0.6 kg/adt was added, together with hydrogen peroxide and sodium hydroxide. The washing of the pulp between the bleaching stages was carried out with 9 m³/adt in the laboratory and in the plant at 8 to 10 m³/adt in the diffusion washers as shown schematically in Figure 6.

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