

Contents

Preface	<i>XV</i>
Abbreviations	<i>XVII</i>
Acknowledgement	<i>XXIII</i>

Part I	General thoughts about energy supply	1
1	Energy supply – today and in the future	3
1.1	Primary energy sources	3
1.2	Secondary energy sources	5
1.3	End-point energy sources	6
1.4	Effective energy	6
2	Energy supply in the future – scenarios	7
2.1	Amount of space	11
2.2	Potential yield from biomass	13
2.2.1	Theoretical potential	13
2.2.1.1	C3 plants (energy plants)	15
2.2.1.2	C4 plants and CAM plants	17
2.2.1.3	Micro-algae	20
2.3	Technical potential	21
2.4	Economic potential	23
2.5	Realizable potential	23
3	History and status to date in Europe	27
3.1	First attempts at using biogas	28
3.2	Second attempts at using biogas	30
3.3	Third attempts at applying biogas	32
3.4	Status to date and perspective in Europe	32
4	History and status to date in other countries	35
4.1	History and status to date in China	36

4.1.1	Period from 1970 to 1983	37
4.1.2	Period from 1984 to 1991	38
4.1.3	Period from 1992 to 1998	38
4.1.3.1	“A pit with three rebuildings”	38
4.1.3.2	“4 in 1”	39
4.1.3.3	“Pig-biogas-fruits”	39
4.1.4	Period from the year 1999 onwards	39
4.2	History and status to date in India	40
4.3	Status to date in Latin America	42
4.4	Status to date in the CIS states	42
5	General aspects of the recovery of biomass in the future	45

Part II Substrate and biogas 47

1 Biogas 49

1.1	Biogas compared to other methane-containing gases	49
1.2	Detailed overview of biogas components	52
1.2.1	Methane and carbon dioxide	53
1.2.2	Nitrogen and oxygen	54
1.2.3	Carbon monoxide	55
1.2.4	Ammonia	55
1.2.5	Hydrogen sulfide	55
1.2.6	Chlorine, fluorine, mercaptans	56
1.2.7	BTX, PAK, etc.	56
1.2.8	Siloxanes	56

2 Substrates 57

2.1	Liquid manure and co-substrates	57
2.2	Bio waste from collections of residual waste and trade waste similar to domestic waste	66
2.3	Landfill for residual waste	66
2.4	Sewage sludge and co-substrate	70
2.5	Industrial waste water	74
2.6	Waste grease or fat	74
2.7	Cultivation of algae	74
2.8	Plankton	75
2.9	Sediments in the sea	76
2.10	Wood, straw	77

3 Evaluation of substrates for biogas production 79

4 Benefits of a biogas plant 83

Part III	Formation of biogas	87
1	Biochemical reaction	89
2	Biology	93
2.1	Bioreactions	93
2.1.1	Hydrolysis	94
2.1.2	Acidogenic phase	94
2.1.3	Acetogenic phase	96
2.1.4	Methanogenic phase	98
2.2	Process parameters	100
2.2.1	Parameter: hydrogen partial pressure	101
2.2.2	Parameter: concentration of the microorganisms	102
2.2.3	Parameter: type of substrate	102
2.2.4	Parameter: specific surface of material	103
2.2.5	Parameter: disintegration	106
2.2.6	Parameter: cultivation, mixing, and volume load	110
2.2.7	Parameter: light	112
2.2.8	Parameter: temperature	112
2.2.9	Parameter: pH	113
2.2.10	Parameter: redox potential	116
2.2.11	Parameter: nutrients (C/N/P-ratio)	116
2.2.12	Parameter: trace elements	116
2.2.13	Parameter: precipitants (calcium carbonate, MAP, apatite)	117
2.2.14	Parameter: biogas removal	117
2.2.15	Parameter: inhibitors	118
2.2.15.1	Oxygen	119
2.2.15.2	Sulfur compounds	119
2.2.15.3	Organic acids (fatty acids and amino acids)	121
2.2.15.4	Nitrate (NO_3^-)	122
2.2.15.5	Ammonium (NH_4^+) and ammonia (NH_3)	123
2.2.15.6	Heavy metals	125
2.2.15.7	Tannins	125
2.2.15.8	Other inhibiting thresholds	125
2.2.16	Parameter: degree of decomposition	127
2.2.17	Parameter: foaming	127
2.2.18	Parameter: scum	127
3	Bacteria participating in the process of degradation	129
3.1	Hydrolyzing genera	131
3.2	Acidogenic genera	131
3.3	Acetogenic genera	134
3.4	Methanogenics	135
3.5	Methanotropic species	137

Part IV Laws and guidelines concerning biogas plants 149

- 1 Guidelines and regulations 151**
 - 1.1 Construction of plants 152
 - 1.1.1 Corresponding regulations 152
 - 1.1.2 Checklist of regulations concerning the plant 154
 - 1.2 Utilized biomass 155
 - 1.3 Biomass to be used preferentially 159
 - 1.4 Distribution of the residues 160
 - 1.5 Feeding biogas to the gas network 161
 - 1.6 Risk of explosion 161
 - 1.6.1 Explosion-endangered areas – ex-zones 162
 - 1.6.2 Checklist of measures for explosion protection 164
 - 1.7 Risk of fire 171
 - 1.7.1 Fire protection sectors 171
 - 1.7.2 Checklist for fire protection measures 172
 - 1.8 Harmful exhaust gases 173
 - 1.8.1 Prescriptions and guidelines 173
 - 1.8.1.1 Germs 175
 - 1.8.1.2 Emissions of smells 175
 - 1.8.2 Checklist for immission prevention measures 179
 - 1.9 Noise protection 183
 - 1.9.1 Regulations and guidelines 184
 - 1.9.2 Checklist for noise protection measures 185
 - 1.10 Prevention of injuries 185
 - 1.11 Protection from water 186
 - 1.11.1 Regulations and guidelines 186
 - 1.11.2 Checklist for water protection measures 186
- 2 Building a biogas plant 189**
 - 2.1 Feasibility study 189
 - 2.2 Preliminary planning 189
 - 2.3 The construction process 192

3 Financing 195**Part V Process engineering 197**

- 1 Parts of biogas plants 199**
 - 1.1 Tanks and reactors 199
 - 1.1.1 Brick tanks 199
 - 1.1.2 Reinforced concrete tanks 200
 - 1.1.3 Tanks of normal steel sheet metals with enamel layer or plastic coating 205
 - 1.1.4 Tanks of stainless steel 206

- 1.1.5 Ground basin with plastic foil lining 206
- 1.2 Equipment for tempering the substrate 207
- 1.3 Thermal insulation 209
- 1.4 Piping system 209
- 1.5 Pump system 210
- 1.6 Measurement, control, and automation technology 211
- 1.6.1 Mechanisms for monitoring and regulation 211
- 1.6.1.1 Dry matter concentration in the substrate 213
- 1.6.1.2 Organic dry matter content and/or total organic carbon (TOC) 213
- 1.6.1.3 Biochemical oxygen demand (BOD) 213
- 1.6.1.4 Chemical oxygen demand (COD) 214
- 1.6.1.5 Degree of decomposition 215
- 1.6.1.6 Acid value 216
- 1.6.1.7 Determination of nutrients (nitrogen and phosphorus compounds) 216
- 1.6.1.8 Sludge (volume) index (I_{sv}) 217
- 1.6.1.9 Ignition loss 217
- 1.6.1.10 Biogas yield and quality 217
- 1.6.2 Equipment to secure the operability 217
- 1.6.2.1 Foaming 218
- 1.6.2.2 Blockage 218
- 1.6.3 Safety devices for humans and the environment 218
- 1.6.3.1 Safety device before the gas flare 218
- 1.6.3.2 Overpressure and negative pressure safety device 218
- 1.7 Exhaust air cleaning 220

2 Area for the delivery and equipment for storage of the delivered biomass 221

3 Process technology for the upstream processing 223

- 3.1 Adjustment of the water content 224
- 3.2 Removal of disturbing/harmful substances 224
- 3.3 Comminution 226
- 3.4 Hygienization 226
- 3.4.1 Direct inspection 227
- 3.4.1.1 Salmonella 227
- 3.4.1.2 Plasmodiophora brassicae 229
- 3.4.1.3 Tobacco mosaic virus 229
- 3.4.1.4 Tomato seeds 229
- 3.4.2 Indirect process inspection 229
- 3.4.3 Control of the finished goods 230
- 3.5 Disintegration 231
- 3.5.1 Mechanical processes 235
- 3.5.2 Ultrasonic process 235
- 3.5.3 Chemical processes 236

3.5.4	Thermal processes	238
3.5.5	Biological processes	238
3.6	Feeding	239
4	Fermentation technology	243
4.1	Batchwise and continuous processes without separators	243
4.1.1	Systems engineering	244
4.1.2	Reactor technique	248
4.1.2.1	Reactor size	248
4.1.2.2	Reactor Designs	250
4.1.2.3	Covering of the bioreactor	251
4.1.2.4	Access door and inlet	252
4.1.2.5	Drainage layer below the bioreactor	253
4.1.2.6	Heat insulation	254
4.1.2.7	Agitators	254
4.1.2.8	Heating	257
4.1.3	Efficiency	258
4.2	Existing installations by different suppliers	259
4.2.1	WABIO-Vaasa process	260
4.2.2	DUT process	261
4.2.3	WABIO process	261
4.2.4	Farmatic™ biotech energy installation	262
4.2.5	Bigadan™ process (formerly Krüger process)	263
4.2.6	Valorga™ process	263
4.3	Installation with substrate dilution and subsequent water separation	264
4.3.1	Equipment	265
4.3.2	Implemented installations of different manufacturers	268
4.4	Installation with biomass accumulation	269
4.4.1	Sewage sludge digestion tower installation	269
4.4.1.1	Equipment	270
4.4.1.2	Operation of the digestion tower	285
4.4.2	Industrial purification of sewage	286
4.4.2.1	Process engineering and equipment construction	287
4.4.2.2	Plant installations	299
4.5	Plants with separation of non-hydrolyzable biomass	301
4.5.1	Process of suspension	302
4.5.1.1	Process engineering and equipment construction	302
4.5.1.2	Efficiency	303
4.5.1.3	Plant installations	303
4.5.2	Percolation process	305
4.5.2.1	Process engineering and equipment construction	305
4.5.2.2	Plant installations	306
4.6	Residue storage tank and distribution	311

- 5 Special plant installations 313**
 - 5.1 Combined fermentation of sewage sludge and bio waste 313
 - 5.2 Bio waste plants 315
 - 5.3 Purification of industrial waste water 322
 - 5.3.1 Process engineering and equipment construction 322
 - 5.3.2 Plants for industrial waste water fermentation 322
- Part VI Biogas to energy 323**
 - 1 Gas pipelines 325**
 - 2 Biogasholder 327**
 - 2.1 Biogasholder types 327
 - 2.1.1 Low-pressure biogasholder 327
 - 2.1.2 Medium- and high-pressure biogasholders 330
 - 2.2 Gas flares 330
 - 3 Gas preparation 333**
 - 3.1 Removal of hydrogen sulfide 335
 - 3.1.1 Biological desulfurization 335
 - 3.1.2 Sulfide precipitation 339
 - 3.1.3 Absorption in a ferric chelate solution 340
 - 3.1.4 Adsorption at iron-containing masses 341
 - 3.1.5 Adsorption on activated charcoal 342
 - 3.1.6 Chemical binding to zinc 343
 - 3.1.7 Surfactants 343
 - 3.1.8 Passing the biogas through an algae reactor or addition of sodium alginate 344
 - 3.1.9 Direct oxidation 344
 - 3.1.10 Compressed gas scrubbing 344
 - 3.1.11 Molecular sieves 344
 - 3.2 Removal of the carbon dioxide 345
 - 3.2.1 Absorption 345
 - 3.2.2 Absorbents based on glycol and ethanolamines 348
 - 3.2.3 Adsorption with pressure swing technology (PSA) 349
 - 3.2.4 Adsorption with pressure swing technology (VPSA) under vacuum 351
 - 3.2.5 Diaphragm technology 351
 - 3.2.6 Mineralization and biomineralization 353
 - 3.2.7 Cryogenic biogas purification 353
 - 3.3 Removal of oxygen 354
 - 3.4 Removal of water 354
 - 3.5 Removal of ammonia 355
 - 3.6 Removal of siloxanes 355

4	Liquefaction or compression of the biogas	357
4.1	Liquefaction	357
4.2	Compression	358
5	Utilization of biogas for the generation of electric power and heat	361
5.1	Supply of current to the public electricity network	361
5.1.1	Generators	363
5.1.2	Current-measuring instruments	363
5.1.3	Control of the synchronization	363
5.1.4	Switching devices	364
5.1.5	Network failure registration	364
5.1.6	Short-circuit protection	365
5.1.7	Wattless current compensation	365
5.2	Heat	365
5.3	Combined heat and power generator (CHP)	367
5.3.1	Engines	367
5.3.1.1	Generation of electricity in a four-stroke gas engine and a Diesel engine	367
5.3.1.2	Generation of electricity in a Stirling engine	372
5.3.1.3	Generation of electricity in a fuel cell	373
5.3.1.4	Generation of electricity in a gas turbine	378
5.3.1.5	Generation of electricity in a micro gas turbine	379
5.3.2	Controlling the CHP	381
5.3.3	Emission control	382
5.3.3.1	Regulations	382
5.3.3.2	Measures for the reduction of emissions	383
5.4	Lessons learnt from experience	386
5.5	Economy	388
5.6	CHP manufacturers	388
6	Biogas for feeding into the natural gas network	389
6.1	Biogas for feeding into the natural gas network in Switzerland	392
6.2	Biogas for feeding into the natural gas network in Sweden	393
6.3	Biogas for feeding into the natural gas network in Germany	394
7	Biogas as fuel for vehicles	397
7.1	Example project: “chain of restaurants in Switzerland”	397
7.2	Example projects in Sweden	398
Part VII	Residues and waste water	401
1	Residues	403
2	Waste water	405

Attachment I	Typical design calculation for an agricultural biogas plant	407
Attachment II	Economy of biogas plants for the year 2007 (Calculation on the basis of the example of Attachment I)	415
Literature		419
Index		429