

TABLE OF CONTENTS

	Page
SYNOPSIS	i
ACKNOWLEDGEMENTS	ix
LIST OF FIGURES	xviii
LIST OF TABLES	xxv
LIST OF SYMBOLS	xxvii
CHAPTER 1: INTRODUCTION	1. 1
1.1 The nature of sewage sludge	1. 1
1.2 Regulations regarding usage of sludge	1. 2
1.3 Sludge stabilization and disinfection processes	1. 4
1.4 The dual digestion process	1. 5
1.5 Dual digestion research requirements	1. 7
CHAPTER 2: REVIEW OF THEORY AND LITERATURE PERTAINING TO BIOLOGICAL HEAT GENERATION IN THE AEROBIC STAGE OF DUAL DIGESTION	2. 1
2.1 Introduction – sludge digestion	2. 1
2.2 The process design of conventional aerobic digestion	2. 3
2.3 Thermophilic aerobic digestion	2. 4
2.3.1 The justification for thermophilic operation	2. 4
2.3.2 Heat generation in thermophilic aerobic digestion	2. 6
2.4 The stoichiometry of biological heat generation	2. 8
2.4.1 Definition of biological heat generation in aerobic digestion	2. 8
2.4.2 Steady state energy balance	2. 9
2.4.3 The specific heat yield	2. 9
2.4.4 Substitute measures of energy used in quantifying biological heat generation	2.10
2.4.4.1 <i>Heat of combustion</i>	2.10
2.4.4.2 <i>Chemical oxygen demand</i>	2.11
2.4.4.3 <i>Volatile solids</i>	2.11
2.4.4.4 <i>Practical drawbacks of the three parameters</i>	2.12

2.5	The kinetics of biological heat generation	2.12
2.6	The aerobic stage of the dual digestion process	2.18
2.6.1	Process objectives	2.18
2.6.1.1	<i>Sludge disinfection</i>	2.18
2.6.1.2	<i>Sludge pretreatment</i>	2.18
2.6.2	Biological heat generation in the aerobic stage of dual digestion	2.19
2.7	Biological heat generation stoichiometry and kinetics as a function of oxygen utilization	2.20
2.7.1	Predicting biological heat generation using bio-energetics	2.21
2.7.1.1	<i>Discussion</i>	2.21
2.7.1.2	<i>Derivation of a specific heat yield equation</i>	2.22
2.7.1.3	<i>Predicted values of Y_H</i>	2.25
2.7.2	Measurements of biological heat generation and oxygen consumption in human physiology	2.26
2.7.3	Measurements of biological heat generation and oxygen consumption in microbiology	2.26
2.7.4	Measurements of biological heat generation and oxygen consumption in thermophilic aerobic digestion	2.27
CHAPTER 3: OPERATION AND MEASUREMENTS METHODS FOR EVALUATION OF AEROBIC REACTOR PERFORMANCE		
		3. 1
3.1	The Potsdam waste water treatment works	3. 1
3.2	Dual digestion plant layout and operation	3. 3
3.3	Aerobic reactor operation and monitoring	3. 6
3.3.1	Sludge collection and thickening	3. 6
3.3.2	Sludge feeding and level control	3. 7
3.3.3	Oxygenation system	3. 9
3.3.4	Temperature measurement	3.10
3.3.4.1	<i>Equipment and monitoring points</i>	3.10
3.3.4.2	<i>Batch cycle temperature profile</i>	3.11
3.3.4.3	<i>Sludge temperatures and reactor mixing</i>	3.11
3.4	Oxygen mass and heat balances over the reactor	3.14
3.4.1	The oxygen mass balance	3.14
3.4.1.1	<i>Influent oxygen measurement</i>	3.15
3.4.1.2	<i>Effluent oxygen measurement</i>	3.16

3.4.2	Heat balance across the reactor	3.20
3.4.3	Measuring the heat balance terms	3.23
3.4.3.1	<i>Rate of sludge enthalpy increase (H_{net})</i>	3.23
3.4.3.2	<i>Mechanical heat input rate (H_{mi})</i>	3.24
3.4.3.3	<i>Wall heat loss rate (H_{we})</i>	3.25
3.4.3.4	<i>Vent gas water vapour heat loss rate, (H_{ve})</i>	3.26
3.5	Sample specific heat yield calculation	3.28
3.5.1	The rate of increase in reactor sludge enthalpy, H_{net}	3.28
3.5.2	Mechanical heat input rate, H_{mi}	3.29
3.5.3	Wall heat loss rate, H_{we}	3.29
3.5.4	Vent gas vapour heat loss rate, H_{ve}	3.29
3.5.5	Biological heat generation rate, H_{bi}	3.31
3.5.6	Mass oxygen consumption rate, O_c	3.31
3.5.7	The specific heat yield, Y_H	3.31
3.6	Vent gas analysis calculations	3.31
3.6.1	The oxygenation efficiency, O_{eff}	3.32
3.6.2	The respiration quotient, Y_{CO_2}	3.32
3.6.3	The degree of water vapour saturation in the vent gas	3.32
3.7	Flow rate and chemical analyses of the sludge	3.33
3.7.1	VS and COD balance	3.34
3.7.2	Sludge flow rate measurement	3.34
3.7.3	Sludge sampling and analysis	3.34
3.7.4	Solids concentration measurement	3.35
3.7.5	COD concentration measurement	3.36
CHAPTER 4: DESCRIPTION AND DISCUSSION OF RESULTS MEASURED ON AEROBIC REACTOR		4. 1
4.1	Introduction	4. 1
4.2	The biological heating rate H_{bi}	4. 4
4.2.1	The rate of increase of reactor sludge enthalpy, H_{net}	4. 4
4.2.2	The mechanical heat input rate, H_{mi}	4. 6
4.2.3	The wall heat loss rate, H_{we}	4. 8
4.2.4	Vent gas vapour heat loss rate, H_{ve}	4. 9
4.2.5	The biological heating rate, H_{bi}	4.12

4.3	The biological oxygen consumption rate, O_c	4.12
4.4	The specific heat yield, Y_H	4.14
4.4.1	Comparison between Y_H and similar values reported in literature	4.14
4.4.2	Statistical evaluation of the Y_H data	4.17
4.4.3	Effect of reactor operating conditions on Y_H	4.20
4.4.3.1	<i>Effect of reactor sludge temperature, T_{se} on Y_H</i>	4.20
4.4.3.2	<i>Effect of retention time R_H on Y_H</i>	4.20
4.4.3.3	<i>Effect of oxygen consumption rate O_c on Y_H</i>	4.22
4.4.3.3.1	<i>Effect of oxygen supply rotameter calibration on Y_H</i>	4.23
4.4.3.3.2	<i>Effect of oxygen limitation on Y_H</i>	4.26
4.4.4	The sensitivity of the specific heat yield, Y_H , to experimental error	4.26
4.4.5	Conclusion regarding the specific heat yield Y_H	4.30
4.5	Oxygen utilization efficiency (O_{EFF})	4.30
4.6	The respiration quotient (Y_{CO_2})	4.32
4.7	Degree of water vapour saturation	4.34
4.8	Evaluation of oxygen limitation in the aerobic reactor	4.36
4.9	The steady state heat balance across the aerobic reactor	4.42
4.9.1	The mechanical heat input rate, H_{mi} , and wall heat loss rate, H_{we}	4.45
4.9.2	Vent gas water vapour heat loss rate, H_{ve}	4.48
4.9.3	The biological heat generation rate, H_{bi}	4.48
4.10	VS and COD reduction	4.50
4.10.1	VS removal	4.51
4.10.1.1	<i>Analytical error</i>	4.55
4.10.1.2	<i>Sampling error</i>	4.57
4.10.1.3	<i>Conclusion</i>	4.58
4.10.2	COD removal	4.58
4.10.2.1	<i>Sampling error</i>	4.59
4.10.2.2	<i>Analytical error</i>	4.62
4.10.2.3	<i>Conclusion</i>	4.62
4.10.3	Influent and effluent COD/VS ratio	4.63
4.10.4	The mass of oxygen consumed per kg COD removed	4.63
4.10.4.1	<i>The stoichiometry of oxygen and COD removal</i>	4.63
4.10.4.2	<i>Imprecision of the measured ratio ratio kgO/(kgCOD removed)</i>	4.64
4.10.5	Conclusion	4.65

CHAPTER 5: CONSIDERATIONS IN THE PROCESS DESIGN OF THE AEROBIC REACTOR OF A DUAL DIGESTION SYSTEM	5. 1
5.1 Introduction	5. 1
5.2 The objectives for the design of the reactor	5. 2
5.3 Heat generation in the reactor	5. 4
5.4 The steady state heat balance across the reactor	5. 5
5.4.1 The biological heat generation rate, H_{bi}	5. 9
5.4.2 The rate of mechanical heat input, H_{mi}	5.11
5.4.3 The net rate of sensible heat loss in the vent gas, H'_{ge}	5.12
5.4.4 The rate of wall heat loss from the reactor surfaces, H_{we}	5.14
5.4.5 The rate of heat loss due to the vaporization of water from the reactor sludge by the vent gas, H_{ve}	5.14
5.5 Maximizing heat sources and minimizing heat sinks	5.16
5.5.1 The relative significance of oxygen transfer rate (OTR) and oxygen transfer efficiency (OTE)	5.17
5.5.2 Pure oxygen versus air	5.18
5.5.3 The degree of water vapour saturation in the vent gas	5.19
5.5.4 Supplementary heat sources	5.19
5.6 Graphical examination of the design inter-relationships	5.21
5.6.1 Retention time as a function of oxygen transfer rate for different values of oxygen transfer efficiency	5.22
5.6.2 The effect of reducing the rate of mechanical heat input, H_{mi} , on retention time	5.24
5.6.3 The degree of saturation of the water vapour in the vent gas	5.24
5.6.4 Heat exchange	5.25
5.7 Discussion of the design inter-relationships	5.26
5.8 Conclusions	5.35
CHAPTER 6: A MATHEMATICAL MODEL TO SIMULATE THE CHANGE OF TEMPERATURE WITH TIME IN A BATCH FED AEROBIC STAGE OF A DUAL DIGESTION SYSTEM	6. 1
6.1 Introduction	6. 1

6.2	The batch cycle	6.4
6.2.1	The phases of a batch cycle	6.4
6.2.2	Qualitative information derived from the saw tooth profile	6.4
6.2.2.1	<i>Steady state operation</i>	6.4
6.2.2.2	<i>Biological heat generation and biological death in the reactor</i>	6.5
6.2.2.3	<i>Reactor sludge mixing</i>	6.5
6.2.3	Quantitative information derived from the saw tooth profile	6.7
6.2.3.1	<i>The batch fraction, f_b and sludge temperature decrease during phase 2</i>	6.7
6.2.3.2	<i>The cycle time, t_c and sludge pasteurization</i>	6.7
6.2.3.3	<i>The cycle time, t_c and hydraulic retention time, R_H</i>	6.8
6.3	The procedure for simulating the temperature-time profile of the reactor sludge	6.8
6.3.1	The reactor sludge enthalpy at time t , $H_s(t)$	6.9
6.3.2	The change in the reactor sludge enthalpy over the time interval Δt , ΔH_s	6.10
6.3.2.1	<i>The biological heat generation rate, H_{bi}</i>	6.11
6.3.2.2	<i>The mechanical heat input rate, H_{mi}</i>	6.13
6.3.2.3	<i>The wall heat loss rate, H_{we}</i>	6.13
6.3.2.4	<i>The rate of vent gas water vapour heat loss, H_{ve}</i>	6.14
6.3.2.5	<i>The rate of vent gas sensible heat loss/gain, $H_{ge} - H_{gi}$</i>	6.16
6.3.2.6	<i>The sensible heat loss/gain due to sludge leaving/entering the reactor, $H_{se} - H_{si}$</i>	6.17
6.3.3	The reactor sludge enthalpy at time $t + \Delta t$, $H_s(t + \Delta t)$	6.17
6.3.4	The reactor sludge temperature at time $t + \Delta t$, $T_{se}(t + \Delta t)$	6.18
6.3.5	Performing the four calculation steps	6.19
6.3.5.1	<i>The duration of the time interval, Δt</i>	6.19
6.3.5.2	<i>The initial values of T_{se} and V_p</i>	6.19
6.3.5.3	<i>The initial time, t</i>	6.20
6.3.5.4	<i>The reference temperature, T_{ref}</i>	6.20

6.3.5.5	<i>The design and operating specifications</i>	6.20
6.4	The use of a computer program to simulate the change of temperature with time in the reactor	6.21
6.5	Features of the computer simulation model	6.21
CHAPTER 7: CONCLUSIONS		7. 1
7.1	Introduction	7. 1
7.2	Research into dual digestion	7. 2
7.3	Conclusions from the aerobic reactor investigation	7. 3
7.3.1	Biological heat generation and oxygen consumption	7. 3
7.3.2	Maximum biological heat generation rate	7. 4
7.3.3	Oxygen limitation	7. 5
7.3.4	Reactor temperature control	7. 5
7.3.5	Maximum oxygen transfer rate of oxygenation system (OTR_{max})	7. 6
7.3.6	Biological heat generation and VS and COD removal	7. 7
7.3.7	The respiration quotient, Y_{CO_2}	7. 7
7.3.8	Degree of vent gas water vapour saturation	7. 8
7.4	Design and Simulation of the aerobic reactor	7. 9
7.5	Evaluation of aerobic reactor investigation	7.12
7.6	Evaluation of dual digestion investigation	7.13
7.7	Exploitation of supplementary heat sources	7.15
<u>APPENDIX 3A</u>	: The calibration of the oxygen supply rotameters and the vent gas meter.	
<u>APPENDIX 3B</u>	: Calculations to determine the reactor vent gas composition	
<u>APPENDIX 3C</u>	: Determination of the heat input from the Vitox recirculation pump (H_{mi})	
<u>APPENDIX 3D</u>	: Determination of the reactor wall heat losses (H_{we}).	
<u>APPENDIX 4A</u>	: The results of the 116 unsteady state heat and oxygen mass balances.	