Table of Contents

1	Ba	ckground and Motivation	_ 1		
2	Environmental regulations on heavy metal removal for industrial wastewater				
	2.1	Common Waste Water and Waste Gas Treatment / Management Systems in the Chemical Sector BREF (CWW July 2016)	_ 4		
	2.2	Non-Ferrous Metals BREF (NFM October 2014)	_ 7		
	2.3	Waste Incineration BREF (WI August 2006)	8		
3	Drawbacks of BAT for heavy metals removal in wastewater treatment				
	3.1	General information about BAT for heavy metals removal	11		
		3.1.1 Coagulation / flocculation	. 11		
		3.1.2 Electrocoagulation (EC)			
		3.1.3 Chemical precipitation (including neutralization) 3.1.4 Chemical reduction			
		3.1.5 Adsorption			
		3.1.6 Ion exchange			
	3.2	Reagent impurities and its effect on reaction times	. 18		
		pH solubility drawbacks due to amphoterism issues			
		Toxic nature of driving forces behind chemical precipitation			
	3.5	Lack of sustainability in sludge recycling operations	21		
		Drawbacks of filtration technologies for small colloidal particles			
4	Sta	State of the art in electrocoagulation technology			
		Isoelectric conditions of electrocoagulation vs. regular electrolysis			
	4.2	pH relevance in transport phenomena of colloidal systems	. 24		
	4.3	Electrokinetic connection between zeta potential and EC performance _	27		
	4.4	Heavy metal removal mechanisms in electrodeposition reactions	28		
5	Development of continuous electrocoagulation with online process control				
		Materials and methods	29		
	5.2	Hardware development for the electrocoagulation treatment of wastewater			
		5.2.1 Description of old batch setup for electrocoagulation treatment_			
		5.2.2 Description of new inline setup for continuous EC with pH- conditioning	32		
	5.3	Inline reactor design for continuous electrocoagulation treatment	34		



Κ

	5.4	Desig	n of online process control for continuous electrocoagulation	_ 36		
	5.5	Trans	fer function and tuning of PID controller for continuous EC	_ 38		
	5.6	Farad	lay's law and its effect on electrolytic dosage of sacrificial anode_	_ 40		
	5.7	Effect	of electrolytic dosage on zeta potential and EC performance	_ 41		
6			principle of electrocoagulation technology in ode	_43		
	6.1	Indus	trial wastewater from a copper plant	43		
		6.1.1	Effect of electrode material on heavy metals removal Effect of electrode material on power consumption and conductivity	44		
		6.1.3	Effect of electrode material on heavy metals recovery	46		
			Effect of sample concentration on heavy metals recovery			
			Effect of pH-conditioning on heavy metals removal			
		6.1.6	Effect of pH-conditioning on conductivity and power consumption	_ 54		
		6.1.7	Amount of energy released as hydrogen in EC off-gas	_ 56		
	6.2	Indust	trial wastewater from a lead plant	58		
		6.2.1	Effect of pH-conditioning on heavy metals removal	58		
			Potential hazard due to the release of toxic arsine in off-gas	_ 59		
			Effect of pH-conditioning on conductivity and power consumption	_ 62		
		6.2.4	Amount of energy released as hydrogen in EC off-gas	_ 64		
	6.3	Hazar	dous wastewater from a waste incineration facility	_ 65		
		6.3.1	Effect of electrode material on heavy metals removal	65		
			Effect of electrode material on pH and conductivity values	_ 67		
		6.3.3	Effect of electrode material on power consumption and temperature	_ 69		
	6.4	Flue-g	pas FGT wastewater from a waste incineration facility	_ 70		
		6.4.1 6.4.2	Effect of pH-conditioning on electrical conductivity Effect of pH-conditioning on heavy metals removal	_ 71 _ 72		
7	Experimental work with continuous EC using online process control					
	•					
	7.1		vs. inline set-up without closed-loop control (offline)			
		7.1.1 7.1.2	Effect of inline reactor design on heavy metals removal Effect of EC reactor design on power consumption	73		
	7.2	Offline	e results	75		
		7.2.1	Effect of power consumption on electrolytic dosage of sacrificial anode	_ 76		
		7.2.2	Tuning of PID process controller for EC treatment in online mode	- 77		

	7.3	Online results	79	
		7.3.1 Effect of online process control on power consumption	80	
		7.3.2 Amount of energy released as hydrogen in EC off-gas	81	
		7.3.3 Effect of pH-conditioning on electrical conductivity	82	
		7.3.4 Effect of pH-conditioning on heavy metal removal	83	
		7.3.5 Effect of online control on sacrificial anode consumption	84	
	7.4	Techno-economical assessment of continuous EC with online control	86	
8	Conclusions and transfer potentials			
	8.1	Transfer potential of EC technology to municipal wastewater treatment	98	
	8.2	Transfer potential of EC technology to the Oil & Gas industry	100	
	8.3	Zero-waste concept of EC technology towards a circular economy	102	
	8.4	World Heritage Technology WHT Initiative for the transfer of technologies	104	
Ref	ferer	nces	107	
An	nex	1	113	