

Contents

1	Introduction	1
1.1	Motivation and problem statement	1
1.2	Research objective and work structure	2
2	Fundamentals on environmentally sustainable recycling systems of LIBs	5
2.1	Lithium-ion battery design and production	5
2.1.1	Lithium-ion battery design	5
2.1.2	Lithium-ion battery production	7
2.1.3	Production scrap	10
2.2	Recycling process design	11
2.2.1	R-strategies and relevance of material recycling	11
2.2.2	Collection and disassembly	12
2.2.3	Mechanical recycling	14
2.2.4	Pyrometallurgical recycling	15
2.2.5	Hydrometallurgical recycling	15
2.2.6	Other recycling technologies	16
2.2.7	Recycled material quality in industry	17
2.3	Recycling market design	19
2.3.1	Recycling market and business archetypes	19
2.3.2	European political strategy and legislation on environmental sustainable batteries	21
2.4	Environmental assessment methods	24
2.4.1	Environmental sustainability	25
2.4.2	Life Cycle Assessment	25
2.4.3	Environmental assessment in recycling	30
2.4.4	Life Cycle Engineering	33
3	Approaches for environmental assessment of LIB recycling systems	35
3.1	Identification of relevant approaches	35
3.2	Definition of evaluation criteria	36
3.2.1	Product-related evaluation criteria	36
3.2.2	Process-related evaluation criteria	38
3.2.3	Market-related evaluation criteria	39
3.2.4	Environment-related evaluation criteria	40
3.3	Review and evaluation of research contributions	42
3.3.1	Contributions to product assessment in battery recycling systems	42
3.3.2	Contributions to process assessment in battery recycling systems	45
3.3.3	Contributions to market assessment in battery recycling systems	48
3.3.4	Generic assessment and engineering approaches	50
3.4	Findings and derivation of research demand	52

4	Concept for environmental assessment and engineering of LIB recycling systems	55
4.1	Common understanding of battery recycling systems	55
4.2	Derivation of objectives and requirements	58
4.3	Framework development	59
4.4	Module 1: Stakeholder analysis and decision situation	60
4.5	Module 2: Goal and scope definition	63
4.5.1	Goal and scope definition procedure	63
4.5.2	Aligned goal and scope for expert strategies	64
4.6	Module 3: Life cycle inventory modeling	65
4.6.1	Life cycle inventory modeling procedure	65
4.6.2	Market model	70
4.6.3	Product model	75
4.6.4	Process model	79
4.7	Module 4: Life cycle impact assessment	84
4.7.1	Life cycle impact assessment procedure	84
4.7.2	Extended Kaya identity for secondary materials and multi-material products	86
4.8	Module 5: Life cycle engineering	90
4.9	Guide for implementation	92
5	Exemplary applications	95
5.1	Goal and scope definition for exemplary application	95
5.2	Decision support for product expert	99
5.3	Decision support for process expert	105
5.4	Decision support for market expert	117
6	Summary, critical review, and outlook	123
6.1	Summary	123
6.2	Critical review	124
6.3	Outlook	126
	Bibliography	129
A	Appendix	151