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Thermodynamic Modeling and Experimental Investigation of the System Fe–Ti–O–K for Ilmenite Used as Fluidized Bed Oxygen Carrier

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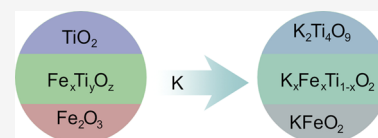
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ABSTRACT: The capability of ilmenite for potassium uptake in a simulated oxygen carrier-aided combustion environment has been investigated. The maximum uptake of potassium and the effect of potassium inclusion on the Fe–Ti–O system was analyzed. Through laboratory experiments and thermodynamic calculations, it was found that a molar ratio of 1:1 can be formed spontaneously for both the K–Ti-system (where the formation of $K_2Ti_2O_5$ was found) and the K–Fe-system (where $KFeO_2$ was found). $K_2Ti_2O_5$ was identified as an unstable phase, undergoing decomposition into $K_2Ti_4O_9$. The study demonstrates that the maximum K uptake, through forming $K_2Ti_4O_9$ and $KFeO_2$, reaches 25 wt %—a notably higher value than ilmenite exposed to biomass in a fluidized bed. The research concludes that the lifetime of ilmenite is therefore rather dependent on its mechanical integrity than its maximum potassium uptake.



BACKGROUND

Oxygen Carrier Aided Combustion (OCAC) is a fluidized bed combustion technology where an Oxygen Carrier (OC) is used as bed material. In addition to the distribution of heat inside the fluidized bed reactor, OCs enhance the distribution of oxygen. This is achieved by undergoing oxidation at high oxygen partial pressures in the reactor and subsequently providing the oxygen at oxygen-lean locations. Therefore, OCAC requires less additional air supply compared to fluidized bed combustion where the bed material is not an OC which increases the efficiency of OCAC.

Oxygen carriers represent materials containing oxides of transition metals that, through continuous oxidation and reduction processes, can transport oxygen in fluidized bed applications. Different materials have been investigated as OCs, for example, the oxides of nickel, copper, iron, manganese, and mixtures thereof.¹ While showing promising results for the combustion process, the limiting factor for these materials has been either the availability, the price, the environmental viability, or the mechanical strength. Therefore, minerals or waste streams containing oxides of transition metals have become the materials of choice for multiple studies using OCs.² Several previous publications have covered the existing knowledge of minerals used as oxygen carriers. Among the tested minerals, ilmenite ($FeTiO_3$) is the mineral that has been most widely studied and the only mineral that has been applied in OCAC at an industrial scale.^{3,4}

Apart from fulfilling the enumerated criteria for oxygen carrier, ilmenite has also been observed to possess another important feature, which is to capture potassium compounds released during fuel conversion.^{5–7} In biomass-based fuels,

potassium is one of the major ash compounds. At high temperatures, present in the combustion reactor, potassium compounds can be found both as solid ash or as gaseous KOH or KCl.⁸ When K interacts with the bed material or with the available downstream surfaces, the bed material may become sticky, resulting in the formation of deposits, resulting in corrosion, and bed material agglomeration.⁹ Thus, the property of ilmenite to capture potassium can decrease the risk of corrosion and agglomeration and lead to fewer unplanned plant stops and lower material consumption. To optimize the combustion process when it comes to the uptake of potassium by ilmenite, a clear understanding of the interactions of potassium with the bed material and the resulting compounds is needed.

Multiple studies have been performed on the interactions of ilmenite with potassium originating from the formed ash by ex situ analysis of solid material. According to most of these studies, iron from ilmenite diffuses outward to the surface of the oxygen carrier forming an iron oxide layer,^{4,5,10} while potassium migrates inward to the segregated Ti-enriched phase of the oxygen-carrying particles, forming potassium titanates.⁵ As a result of the potassium migration and interactions, several potassium titanates have been mentioned as possible products

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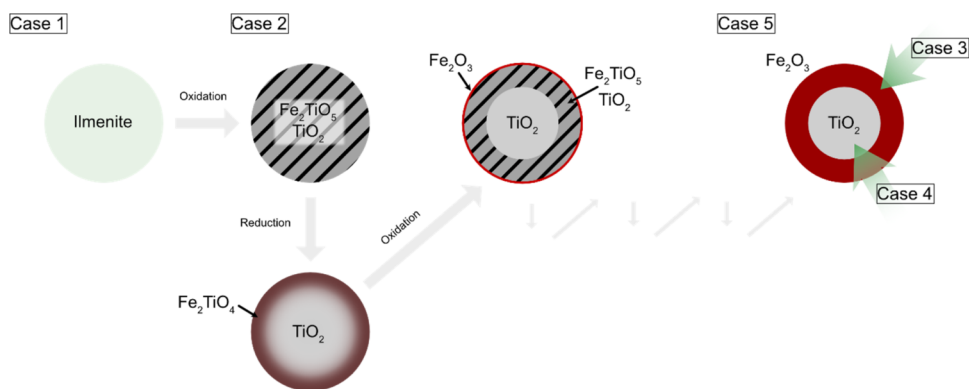


Figure 1. Schematic depiction of the development of the distribution of Fe and Ti in ilmenite over time. The different cases considered in this study are indicated.

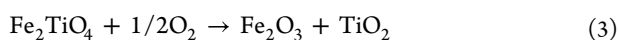
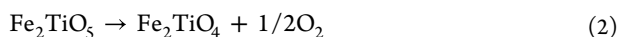
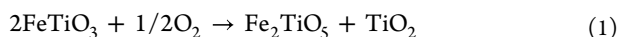
Table 1. Elemental Composition of the Ilmenite Used for This Study^a

Fe	Ti	Mn	Mg	Al	Si	K	Ca	Na	P	Ba
47.5	43.0	0.3	6.1	0.5	1.8	0.1	0.4	0.3	0.1	0.1

^aValues are shown in atom % on an O-free basis.

in the performed studies – $K_{0.4}Fe_{0.4}Ti_{0.6}O_2$, $K_{0.85}Fe_{0.85}Ti_{0.15}O_2$, and different priderites¹¹ with the general formula $K_xTi_{8-x}(Fe^{3+},Ti^{3+})_xO_{16}$ which comprises KTi_8O_{16} ,^{5,12,13} and $K_{1.5}Ti_{7.2}Fe_{0.8}O_{16}$.⁴ In the published investigations the uptake of potassium has been measured and the obtained values vary from 2–4 wt %^{5,6,14} and up to 10 wt %.¹³ From thermodynamic calculations conducted for the interactions of K_2O with ilmenite, $K_2Ti_6O_{13}$ is commonly found as the most stable product,^{13,15,16} while studies using phase analysis with X-ray diffraction (XRD) usually find the formation of priderite.^{4,5,11–13} Even though the existing studies provide a certain understanding of the mechanism of potassium diffusion, they do not provide the mechanism behind the formation of different titanates which could explain the different observed uptake mechanisms of potassium by ilmenite. Understanding potassium diffusion and interactions, as well as predicting maximum potassium uptake is crucial to decide the residence time of the material in the plant and to plan for optimal operational conditions and rate of replacement of bed material.

Fresh ilmenite consists mainly of $FeTiO_3$. During its utilization as an oxygen carrier, the ilmenite particles undergo several changes. Under oxidizing conditions, ilmenite is oxidized to pseudobrookite (Fe_2TiO_5) and rutile (TiO_2) according to Reaction 1. At reducing conditions, pseudobrookite can be reduced to ulvöspinel (Fe_2TiO_4), thereby releasing O_2 available to contribute to fuel conversion, Reaction 2.¹⁷ Ulvöspinel in the surface vicinity will subsequently be oxidized to hematite at oxidizing conditions, shown in Reaction 3, and thereby contributes to the oxygen-carrying effect of the bed material.



Through this process, a gradual migration of iron to the surface of the particles has been observed by multiple studies on ilmenite used for fluidized bed applications.^{6,10,18,19} Outward diffusion of iron increases the metal available for oxygen

carrying and thereby increases the fuel conversion. Analysis of particles exposed to alternating oxidizing and reducing atmospheres has confirmed the presence of a thin layer of iron on the surface, increasing in thickness with time, which was identified as Fe_2O_3 . The formation of Fe_2O_3 leaves behind an increased concentration of TiO_2 in the core of the particles. Continuous oxidation and reduction results thus in a gradient of phases decreasing in Fe-content and increasing in Ti content which follows five main cases schematically shown in Figure 1 and described as follows:

- Case 1 in the figure represents the fresh ilmenite particles prior to their utilization.
- Case 2 represents the ilmenite particles after oxidation where the two phases pseudobrookite (Fe_2TiO_5) and rutile (TiO_2) are present.
- Case 3 represents the layer of Fe_2O_3 which gradually forms on the surface after several oxidation/reduction cycles.
- Case 4 represents the TiO_2 -rich core of used ilmenite particles which is exposed after the Fe-rich layer is removed through attrition.
- Case 5 represents the mixture of Fe_2O_3 and TiO_2 to be equally accessible when utilizing ilmenite as an oxygen carrier.

Each of these stages can result in different interaction pathways for the inward migrating potassium and will therefore lead to a different maximum uptake of potassium and a different lifetime of ilmenite used as bed material. The five main interaction cases can be highly relevant to the different uptake mechanisms of potassium that are presented in the literature. To understand the significance of each of the mentioned stages for the interaction with the potassium, model systems isolating each case need to be used. The present work aims to determine the maximum potassium uptake under laboratory conditions and by thermodynamic modeling, which has not been done before. By decoupling different stages of development and investigating isolated cases as illustrated in Figure 1, a deeper understanding can be obtained of the Fe–Ti–O–K system, which can then be used to predict potassium

interactions under different process conditions. At a later stage, this knowledge can be applied to better understand and predict the lifetime of bed material in the reactor.

MATERIALS AND METHODS

To obtain a better understanding, dedicated experiments of ilmenite-alkali experiments were conducted. Here, solid-state interactions were applied, as this is believed to give a valid view of chemical phenomena. The ilmenite used for the experiments was obtained from Titania A/S from Norway. The elemental composition is shown in Table 1. Ilmenite was used as particles with a particle size of 180–710 μm . The other chemicals were provided as a powder, Fe_2O_3 (97% pure, Riedel-Haën), TiO_2 (>99%, Merck), and K_2CO_3 (>99%, Alfa Aesar).

Experimental Setup. Exposures were conducted to investigate the mechanism of potassium uptake by the different phases present in ilmenite particles during their utilization as an oxygen carrier.

K_2CO_3 was selected as a source of reactive potassium. The exposures were conducted in ambient air and the temperature was set to 1000 °C which represents the expected temperatures for optimal fluidized bed combustion processes. The K interactions with materials from different cases were mimicked by mixing K_2CO_3 with the selected sample as powders inside an alumina crucible. Two parameters were investigated for each of the five cases, namely the effect of exposure time and the effect of additional K addition. For experiments investigating the effect of exposure time, the molar ratio of model oxygen carrier to potassium was chosen to be 2:1. The second investigated parameter was the effect of oversaturation of the K–Ti–O system with K to evaluate the theoretic maximum uptake of K by the particles. For these exposures, two additional doses of K_2CO_3 were added to the crucible after 24 and 48 h, changing the molar ratio of the model oxygen carrier to potassium to 2:3. The addition was done by removing the crucible from the furnace and the salt was added after about five minutes. This continuous addition was performed to simulate the conditions present in a fluidized bed reactor, where fuel ash is continuously added to the bed material. The results were compared to a reference exposure where no K_2CO_3 was added. The reference exposure was conducted for 7 days without the addition of K_2CO_3 . Table 2 provides a summary of the 20 samples that were investigated in this study and introduces the abbreviations that will be used during the results and discussion.

X-ray Diffraction. After the exposures, the samples were investigated with X-ray diffraction (XRD) with a Bruker D8 Discover. Prior to the analysis, the samples were ground to a fine powder and mounted on a Zero-background sample holder. Mo $K\alpha$ radiation ($\lambda = 0.70930 \text{ \AA}$) was used for the samples containing Fe (cases 1, 2, 3, and 5) to minimize high background due to sample fluorescence. The samples containing only TiO_2 and K_2CO_3 (case 4) were analyzed with the commonly used Cu $K\alpha$ radiation ($\lambda = 1.5406 \text{ \AA}$). The acquired diffraction patterns were compared to the PDF 2022 database. Semiquantitative analysis taking the relative intensities of the peaks of the different identified phases into consideration was done to obtain information on the relative amounts of the phases.

Thermodynamic Modeling. Thermodynamic calculations were performed using the software FactSage 8.2 and the module *Equilib*.²⁰ Thermodynamic calculations determine the chemical equilibrium by minimizing Gibbs free energy considering thermodynamic data for various phases and compounds. In this work, the database for pure substances (FactPS), oxide solutions (FToxid), and relevant compounds from other sources were integrated with a user-defined database and utilized along with additional thermal data for compounds previously shown to be important within the potassium–oxygen carrier systems namely, $\text{KTi}_8\text{O}_{16}$ and $\text{K}_x\text{Fe}_x\text{Ti}_{1-x}\text{O}_2$ where $x = 0.85$ or 0.4 .²¹ In case of conflicting data, priority was given to FToxid, FactPS and last the user-defined database.

The calculations were carried out using the *Equilib* module under conditions identical to those of the experiments (1000 °C and oxidizing conditions using air) with the aim of obtaining a better understanding of the phase transitions in the system. The *Reaction*

Table 2. Summary of the Time and Exposed Materials^a

	Fe–Ti–O	time (days)	molar ratio (Fe–Ti)/K	abbreviation
case 1	ilmenite	1	2:1	Ilm1d
	ilmenite	7	2:1	Ilm7d
	ilmenite	3	2:3	Ilm3K
	ilmenite	7		IlmR
case 2	calcined ilmenite	1	2:1	cIlm1d
	calcined ilmenite	7	2:1	cIlm7d
	Calcined ilmenite	3	2:3	cIlm3K
	calcined ilmenite	7		cIlmR
	Fe ₂ O ₃	1	2:1	Hem1d
case 3	Fe ₂ O ₃	7	2:1	Hem7d
	Fe ₂ O ₃	3	2:3	Hem3K
	Fe ₂ O ₃	7		HemR
	TiO ₂	1	2:1	Rut1d
case 4	TiO ₂	7	2:1	Rut7d
	TiO ₂	3	2:3	Rut3K
	TiO ₂	7		RutR
	Fe ₂ O ₃ /TiO ₂	1	2:1	HeRu 1d
case 5	Fe ₂ O ₃ /TiO ₂	7	2:1	HeRu7d
	Fe ₂ O ₃ /TiO ₂	3	2:3	HeRu3K
	Fe ₂ O ₃ /TiO ₂	7		HeRuR

^aCases 1 and 2 were done with mineral particles of ilmenite before and after calcination respectively. Cases 3, 4, and 5 were done with pure chemicals. Exposure conditions for all set-ups were done in air at 1000 °C.

module was used to study in more detail. Lastly, the module *Phase Diagram* was utilized to generate phase diagrams for the K–Fe–Ti–O system to provide a better view of how variations in concentration within the sample can impact the results. The following solution phases were selected in the calculations; spinel, monoxide, corundum, rutile, ilmenite, pseudobrookite, and titania spinel. Considering that there was no indication of the formation of molten phases during exposures, the molten solution phase was not included in the model.

While available thermodynamic databases provide data for a wide range of materials there are materials and phases which are missing from databases. In these cases, it is possible to expand the thermodynamic database using first-principles calculations. The method used in this article has been published separately,¹⁵ and entails computing the reaction energies by using density functional theory (DFT) and calculating the phononic contribution to the heat capacity using harmonic approximation. Using the procedure presented by Benisek and Dachs,²² the results from the first-principles calculations were combined with experimental data from NIST-JANAF thermochemical tables. This combination makes it possible to determine the enthalpy and entropy at room temperature as well as the temperature dependence of the heat capacity. The method has been used previously and provided results in excellent agreement with experimental data for other iron-oxides, especially FeTiO_3 .^{15,16}

FactSage requires that the temperature dependence of the specific heat capacity is provided as the sum of power functions

$$C_p(T) = \sum_{i=1}^8 k_i T^i \quad (4)$$

Most materials in FactSage use an expression of the specific heat capacity with four terms, which has also been employed in this study.

$$C_p(T) = k_1 + k_2 T^{-2} + k_3 T^{-0.5} + k_4 T^{-3} \quad (5)$$

RESULTS

Experimental Results. All the exposed samples were characterized by XRD to identify the formed phases. The

Table 3. Composition of the Samples after Exposure Based on Semi-Quantitative XRD Results (Results Shown in mol %)

	hematite	$K_xFe_xTi_{1-x}O_2$ ($x = 0.4$)	$K_xFe_xTi_{1-x}O_2$ ($x = 0.85$)	TiO_2	$K_xTi_{8-x}(Fe,Ti)_xO_{16}$ (priderite)	$K_2Ti_6O_{13}$	$K_3Ti_8O_{17}$	$K_2Ti_4O_9$	$K_2Ti_2O_5$	$KFe_{11}O_{17}$	$KFeO_2$	Fe_2TiO_5
case 1	Ilm1d	37	15									
	Ilm7d	32	11									
	Ilm3K	55	45									
	IlmR			16								84
case 2	clIm1d	16	75		8							
	clIm7d	21	71		8							
	clIm3K	17	83									
	clImR			12								88
case 3	Hem1d	20								4	76	
	Hem7d	21								14	65	
	Hem3K										100	
	HemR	100										
case 4	Rut1d			26				23	43			
	Rut7d			49				31				
	Rut3K			11								
	RutR			100								
case 5	HeRu 1d	32								12		
	HeRu7d	43			20					10		
	HeRu3K	27										
	HeRuR	44		49								7

D

Table 4. Thermodynamic Properties at 298.15 K^a

compound	$\Delta_f H$ (J/mol)	S (J/(molK))	k_1 (J/(molK))	k_2 (JK/mol)	k_3 (J/(molK ^{0.5}))	k_4 (JK ² /mol)
KFe ₁₁ O ₁₇	-4.87×10^6	570.88	553.14	-1.48×10^8	13,820.07	2.38×10^{10}
K ₂ Fe ₁₀ O ₁₆	-2.15×10^6	249.43	321.33	-5.76×10^7	4600.90	9.05×10^9

^aThe formation enthalpy, entropy, and coefficients in the expression for heat capacity, eq 5, are listed for the two compounds KFe₁₁O₁₇ and K₂Fe₁₀O₁₆.

Table 5. Phases Formed at Equilibrium for Each Exposure^a

system	case	$\frac{\text{Fe}-\text{Ti}}{\text{K}}$	predicted phases	observed phases	exposure
K–Fe–Ti	1	2:1	K₂Ti₆O₁₃ + K₂Ti₃O₇ + KFe₁₁O₁₇	priderite + K _{0.4} Fe _{0.4} Ti _{0.6} O ₂	Ilm1d, Ilm7d
	2			K₂Ti₆O₁₃ + K_{0.4}Fe_{0.4}Ti_{0.6}O₂	cIlm1d, cIlm7d
K–Fe–Ti	1 + 2	2:3	K₈Ti₅O₁₄ + K₂Ti₂O₅ + KFe₁₁O₁₇	K_{0.4}Fe_{0.4}Ti_{0.6}O₂ + K_{0.85}Fe_{0.85}Ti_{0.15}O₂	Ilm3K, cIlm3K
K–Fe	3	2:1	KFeO₂ + KFe₁₁O₁₇	KFe₁₁O₁₇ + KFeO₂	Hem1d, Hem7d
K–Fe	3	2:3	KFeO₂	KFe₁₁O₁₇ + KFeO₂	Hem3K
K–Ti	4	2:1	K₂Ti₆O₁₃ + K₂Ti₃O₇	K₂Ti₆O₁₃ + K₂Ti₄O₉ + K₂Ti₂O₅^(Rut1d)	Rut1d, Rut7d
K–Ti	4	2:3	K₂Ti₂O₅ + K₈Ti₅O₁₄	K₂Ti₂O₅	Rut3K
K–Fe–Ti	5	2:1	K₂Ti₆O₁₃ + K₂Ti₃O₇ + KFe₁₁O₁₇	K₃Ti₈O₁₇ + K_{0.4}Fe_{0.4}Ti_{0.6}O₂ + priderite ^(HeRu7d)	HeRu 1d, HeRu7d
K–Fe–Ti	5	2:3	K₈Ti₅O₁₄ + K₂Ti₂O₅ + KFe₁₁O₁₇	K_{0.4}Fe_{0.4}Ti_{0.6}O₂ + K_{0.85}Fe_{0.85}Ti_{0.15}O₂	HeRu3K

^aPhases that form due to interaction, that are both predicted and observed, are presented in bold.

results of XRD are shown in Table 3. The peak intensities of the matched phases were used to assign semiquantitative values to estimate the respective amount of each phase in the sample.

Case 1 describes the interaction between fresh ilmenite particles and K₂CO₃. As expected, the reference case IlmR (without the addition of K₂CO₃) contains Fe₂TiO₅ and TiO₂ which are formed through the oxidation of ilmenite as shown in Reaction 1. The amount of Fe₂TiO₅ was higher than the theoretical value of 50% that is obtained through the reaction, which can be explained by the pseudobrookite solid solution extending between a cationic content of 30 and 70% of Fe (with between 70 and 30% Ti accordingly).^{17,23} The addition of K₂CO₃ to ilmenite in this case leads to the disappearance of pseudobrookite through the reaction of Ti with K to priderite (K_xTi_{8-x}(Fe³⁺,Ti³⁺)_xO₁₆) and K_{0.4}Fe_{0.4}Ti_{0.6}O₂ (Ilm1d and Ilm7d). This leaves the remaining Fe as Fe₂O₃ due to the lack of a reaction partner, which is why it was found as a separate phase. Increasing the amount of K available for reaction (Ilm3K) yields K_{0.4}Fe_{0.4}Ti_{0.6}O₂ and K_{0.85}Fe_{0.85}Ti_{0.15}O₂ as stable phases. This suggests that if there is a sufficient K amount and Fe₂O₃ is available for reaction, mixed K–Fe–Ti-oxides will form that are more stable than K-titanates which are commonly observed when studying ilmenite interactions with biomass ash.^{5,12,13}

Similar observations were made in **Case 2**, where ilmenite was calcined before the exposure to K₂CO₃. XRD results suggest that the interaction between calcined ilmenite and K₂CO₃ proceeds further than with fresh ilmenite, as the relative share of interaction products is larger than with fresh ilmenite. Furthermore, K₂Ti₆O₁₃ is found in Case 2 at 2:1 concentrations of K₂CO₃ (cIlm1d and cIlm7d) which is the K-titanate that is expected to form at equilibrium.^{13,16}

Case 3 describes the reaction that is expected to take place on the surface of ilmenite particles which have been activated by several redox cycles and have thereby formed a Fe₂O₃ (hematite) rich surface layer. At lower K₂CO₃ additions (Hem1d and Hem7d), the main product of the reaction is KFeO₂, with small amounts of KFe₁₁O₁₇ and approximately 20% unreacted Fe₂O₃. This indicates that the possible uptake of K by ilmenite is not only dependent on the availability of

TiO₂, but it can also form stable compounds with available Fe₂O₃. Adding further K₂CO₃ to Fe₂O₃ (Hem3K) yields 100% KFeO₂ as a final product which shows the maximum of K that can be taken up by Fe₂O₃.

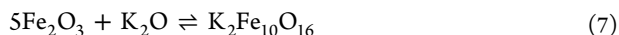
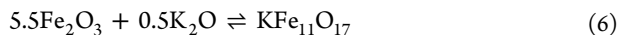
Case 4 explores the reactions that occur with TiO₂ (rutile) and K₂CO₃ without the presence of Fe in the system. Lower additions of K₂CO₃ to rutile and an interaction time of 24 h (Rut1d) lead to the formation of three different K-titanates with different ratios of K:Ti. The highest ratio is reached in K₂Ti₂O₅ indicating that this phase represents the highest possible amount of K which can be taken up by TiO₂. However, increasing the interaction time to 7 days causes the disappearance of this phase in favor of titanates containing lower ratios of K/Ti. This suggests a lack of stability of K₂Ti₂O₅ and indicates a K release from K₂Ti₂O₅, most likely as KOH(g). Continuous addition of K₂CO₃ to the system (Rut3K) stabilizes this phase, and it becomes almost the only detectable phase.

Case 5 investigates the interactions between Fe₂O₃ (hematite), TiO₂ (rutile), and K₂CO₃, which represents the case of complete phase-separated ilmenite. The interaction is similar to Cases 1 and 2, where the addition of small amounts of K₂CO₃ (HeRu 1d and HeRu7d) leads to the formation of K_{0.4}Fe_{0.4}Ti_{0.6}O₂, while after the addition of three times as much (HeRu3K), K_{0.85}Fe_{0.85}Ti_{0.15}O₂ is formed. The only difference is observed in the K-titanates which are detected. K₃Ti₈O₁₇ is detected in this case while priderite is only found after 7 days of interaction time (HeRu7d).

Modeling. Database Expansion. Correlating the experimental observation with the initial thermodynamic model showed that the phases K₃Ti₈O₁₇, K₂Ti₄O₉, KFe₁₁O₁₇, and K₂Fe₁₀O₁₆ did not have thermodynamic entries in the available databases, meaning that the model could not account for these compounds. Consequently, thermal data was derived from first-principles calculations and incorporated into the user-defined database. The selected compounds were KFe₁₁O₁₇ and K₂Fe₁₀O₁₆, and they were selected as it was difficult to distinguish them in the diffractogram.

The estimations of thermodynamic properties of the interesting phases are dependent on the thermodynamic data of known binary oxides which was used as reference together

with the results of the first-principles calculations. Fe_2O_3 and K_2O were deemed to be the best fit as reference materials which made the following reactions the most suitable for each system



The thermodynamic data of Fe_2O_3 and K_2O was taken from NIST-JANAF. The thermodynamic properties and constants used in eq 5 for $\text{KFe}_{11}\text{O}_{17}$ and $\text{K}_2\text{Fe}_{10}\text{O}_{16}$ are shown in Table 4.

Thermodynamic Model. The thermodynamic phase stability for each exposure was investigated in air at 1000 °C. The anticipated phases after exposures are outlined in Table 5. Additionally, since the calculations are independent of time and are solely based on the molar ratio between the components, the findings in Table 5 can be valid across multiple exposures. Given that the temperature, gaseous conditions, and molar ratio in the K–Fe–Ti–O systems were similar across the exposures, it is anticipated that these systems will eventually reach the same equilibrium state.

The ternary phase diagram for Fe_2O_3 – TiO_2 – K_2CO_3 in air, at 1 atm and 1000 °C, is presented in Figure 2. The phase

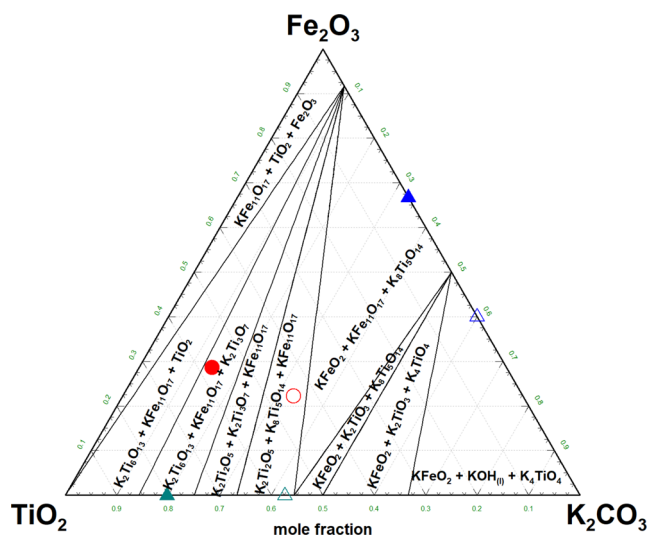
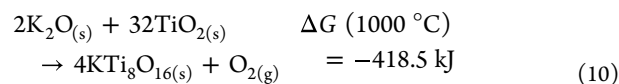
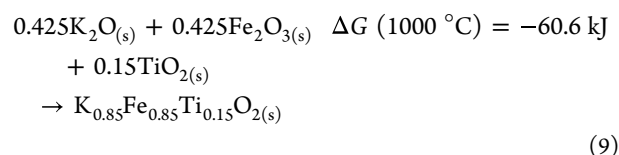
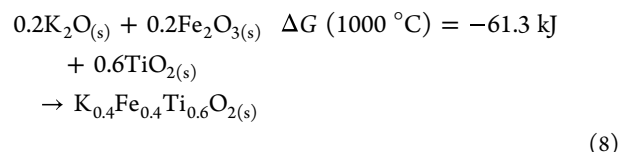


Figure 2. Ternary phase diagram of Fe_2O_3 – TiO_2 – K_2CO_3 in air, with 0.1% moisture, at 1000 °C, and 1 atm. Experimental conditions representing the ratio $[\text{Fe-Ti}]/\text{K} = 2:1$ and $2:3$ are indicated by the filled and half-filled symbols, respectively. The red, blue, and green colors symbolize experiments within the systems K–Fe–Ti, K–Fe, and K–Ti, respectively.

diagram was constructed to present all possible transformations within the K–Fe–Ti–O system. A small amount of moisture ($p_{\text{H}_2\text{O}} = 0.01$ atm) was included to account for the possible presence of KOH. It was observed that moisture promoted the formation of KOH. The carbon from K_2CO_3 is present as CO_2 across the whole diagram. The experimental conditions are illustrated in Figure 2 with filled and half-filled symbols representing different loadings of K_2CO_3 . Due to the homogeneous composition of Fe–Ti–O in cases 1, 2, and 5, the thermodynamic outcome is identical. For these systems, it can be observed that the presence of K_2CO_3 facilitates the separation of Fe and Ti, due to the formation of K-titanates and K-ferrites.

The introduction of the new data set improved the predictability of K–Fe-based systems. For example, evident from Table 3 is that thermodynamic equilibrium is reached in cases 3 and 4 since the experimental observations for the systems K–Fe and K–Ti are well aligned with the equilibrium phases. However, even with the provided data for compounds such as $\text{KTi}_8\text{O}_{16}$ and $\text{K}_x\text{Fe}_x\text{Ti}_{1-x}\text{O}_2$ ($x = 0.85$ or 0.4), these phases did not form under equilibrium conditions within the specified systems. A more in-depth investigation was conducted to elucidate the behavior of these specific phases. The Gibbs free energy for shows that the reactions forming $\text{KTi}_8\text{O}_{16}$ and $\text{K}_x\text{Fe}_x\text{Ti}_{1-x}\text{O}_2$ are spontaneous. It is thus probable that when these compounds form, they can prevent the formation of equilibrium phases due to limitations in mixing.



Looking at the stability of K–Ti-phases it is observed that increasing the amount of K_2CO_3 to the system leads to an increase in the K/Ti-ratio. The evolution of phases is as follows; $\text{K}_2\text{Ti}_6\text{O}_{13}$ – $\text{K}_2\text{Ti}_3\text{O}_7$ – $\text{K}_2\text{Ti}_2\text{O}_5$ – $\text{K}_8\text{Ti}_5\text{O}_{14}$ – K_2TiO_3 – K_4TiO_4 , where the K/Ti ratio increases from 0.33 to 4. The highest K/Ti-ratio is achieved in K_4TiO_4 , which forms when the concentration of K_2CO_3 exceeds 50 atom %. However, these conditions are not reached during biomass conversion. A more likely scenario is in the region where the phase $\text{K}_2\text{Ti}_2\text{O}_5$ is experimentally observed. The phase $\text{K}_2\text{Ti}_3\text{O}_7$ could provide a higher capability for potassium uptake, but unfortunately, $\text{K}_2\text{Ti}_2\text{O}_5$ is not stable with a longer increasing exposure time. Therefore, the phase with the highest stability and maximum potassium uptake is $\text{K}_2\text{Ti}_6\text{O}_{13}$.

DISCUSSION

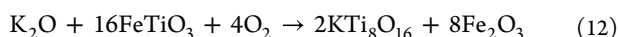
In the current study, K–Fe–Ti–O systems were selected to follow the maximum potassium uptake by isolating different stages during the lifetime of ilmenite. Both model system compounds exposed in laboratory conditions and thermodynamic modeling studies were used to follow the possible interactions. This allowed for a systematic investigation of the K–Fe–Ti–O system. Ilmenite was used as a system boundary defining conditions and the selected model compounds were based on phases observed to form during continuous redox cycles. The study shows that potassium will preferably interact with titanium in systems that contain iron and titanium oxides. Experiments consistently reveal the interaction between K_2CO_3 and TiO_2 is favored over the reaction with Fe_2O_3 . The detected phases in laboratory tests are further supported by modeling. In cases where both hematite and rutile are available, the reaction products at low K concentrations are

different K-titanates and $K_{0.4}Fe_{0.4}Ti_{0.6}O_2$ with around 20–50% hematite remaining. Only after further addition of K to the system is the hematite consumed in favor of the formation of $K_{0.85}Fe_{0.85}Ti_{0.15}O_2$.

Calcined ilmenite, Case 2, represents particles after oxidation where both pseudobrookite (Fe_2TiO_5) and rutile (TiO_2) are present. Interestingly, calcined ilmenite forms $K_2Ti_6O_{13}$ instead of the commonly observed priderite, which was found to form during the exposure of fresh ilmenite.^{5,6,13} This could be an indication that the outward migration of Fe which occurs during calcination inhibits the formation of priderite. This agrees with the fact that in industrial applications, the ilmenite particles are usually not precalcined, and priderite is commonly observed.⁵ It also means that through the segregation of Fe_2O_3 by its migration to the surface allows for a higher uptake of K by TiO_2 to form $K_2Ti_6O_{13}$. This suggests that with increasing exposure time, ilmenite would form $K_2Ti_6O_{13}$ if a continuous flow of K is provided. However, this phase is not found during XRD analysis of ilmenite particles that have interacted with K-rich biomass. An important difference between the experiments done in this study compared to biomass ash is the presence of Ca, which forms Ca-rich layers on the surface of ilmenite particles. The Ca-rich layer which is usually observed in these cases contains $CaTiO_3$ and could participate in limiting the supply of additional K toward the Ti-rich core of aged ilmenite particles, inhibiting the formation of $K_2Ti_6O_{13}$.

The spontaneous formation of $KFeO_2$ and $KFe_{11}O_{17}$ occurring in the system representing the surface of aged ilmenite could represent a first step for the interaction of ilmenite with alkali species. This would mean that in a fluidized bed reactor, Fe_2O_3 -covered ilmenite particles pick up alkali species through the formation of $KFeO_2$. As the K-titanates are thermodynamically more stable, they are formed through the interaction between $KFeO_2$ and TiO_2 .

This study allows several conclusions to be drawn regarding the maximum potential uptake of potassium by ilmenite. Both rutile and hematite spontaneously take up K in a molar ratio of K/Fe and K/Ti of 1:1, as in $KFeO_2$ and $K_2Ti_2O_5$. Although $KFeO_2$ appears to be stable over time, $K_2Ti_2O_5$ seems to dissociate to $K_2Ti_4O_9$ which possibly is associated with the release of gaseous KOH through the reaction with air-derived moisture. Based on the formation of $KFeO_2$ and $K_2Ti_4O_9$, the total maximum uptake of K by ilmenite is therefore 25 wt % (see Reaction 11). However, as mentioned previously, ilmenite particles utilized in fluidized bed applications usually contain significantly lower amounts of K (around 4 wt %) and priderite is commonly observed with XRD. The products of the corresponding Reaction 12 contain around 3 wt % K. Particle fragmentation is commonly observed for ilmenite utilized for prolonged times in fluidized bed applications which is why fresh material is regularly added to the reactors.^{4,24} With the results from the current study, it can be concluded that the mechanical properties are more decisive for the maximum lifetime of ilmenite than its capability of K uptake.



CONCLUSIONS

This study explored the interaction between different cases formed during the lifetime of ilmenite used as an oxygen

carrier with high concentrations of K_2CO_3 . The maximum uptake of K by ilmenite was assessed.

- A molar ratio of 1:1 was found to spontaneously form for both K/Ti ($K_2Ti_2O_5$) and K/Fe ($KFeO_2$). $K_2Ti_2O_5$ was found to be unstable and to decompose to $K_2Ti_4O_9$.
- $KFeO_2$ could be a primary interaction product of the interaction of aged ilmenite with alkali species.
- The maximum uptake of K through the formation of $K_2Ti_4O_9$ and $KFeO_2$ is 25 wt %, which is significantly higher than what is measured for ilmenite exposed to biomass in a fluidized bed.
- The maximum lifetime of ilmenite is dependent on its mechanical properties rather than its total K uptake capacity.

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Notes

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