CONVERSION OF SRI LANKAN IRON ORE INTO HIGH QUALITY PELLETS TO BE USED IN IRON MAKING

Sudath Peiris Guluwita

(08/8034)



Degree of Master of Philosophy

Department of Materials Science and Engineering

University of Moratuwa Sri Lanka

February 2014

DECLARATION

"I certify that this thesis does not incorporate without acknowledgement any material previously submitted for a Degree or Diploma in any University, and to the best of my knowledge and belief it does not contain any material previously published, written or orally communicated by another person except where due reference is made in the text."

Signature of Candidate	Date:

The above candidate has carried out research for the Master of Philosophy under our supervision.

Signature of the supervisors: University of Moraluwa, Sri Lanka. 1.

- www.lib.mrt Date:
- 2. Date:

Name of the supervisors:

- 1. Prof. W. L. W. Fernando
- 2. Prof. R. G. N. De S. Munasinghe

ABSTRACT

Iron ores and lime are two of the available raw materials in Sri Lanka for iron making. However, proven reserves of iron ore deposits in Sri Lanka have not been scientifically estimated as yet. There is no indication of the occurrence of coal deposits in Sri Lanka for the utilization to produce iron using the blast furnace. Therefore, it is important to investigate the possibility of producing high quality iron ore pellets using locally available resources as a substitute for sponge iron which is imported to use in the cupola furnace.

In this study it was aimed at obtaining high quality iron ore pellets with required strength, porosity and degree of reduction by varying pellet compositions, firing temperature and soaking time.

The pellets prepared with 100 parts of Dela Iron ore, 7 parts of Aruwakkalu lime and 7 parts of coke which was sintered at 1250°C for 10 min gave the optimum crushing strength, apparent porosity and degree of reduction. The subsequent melting of these pellets in the lab scale cupola recovered iron as "metallic pigs", which conformed to alpha iron having high purity.

ACKNOWLEDGMENT

It is a great pleasure to acknowledge the assistance and co-operation received from many people in carrying out this research work. However, it is impossible to give adequate recognition to many individuals who have contributed substantially to make this research a success.

First of all, I would like to express my deepest gratitude to my supervisors, Emeritus Professor W. L. W. Fernando and Professor R. G. N. De. S. Munasinghe, Department of Materials Science and Engineering for their encouragement, guidance and valuable ideas rendering to a successful completion of this research. In addition, I also take this opportunity to thank Dr. (Mrs.) N. M. V. K. Liyanage, Head of Department of Materials Science for her encouragement. Also, my sincere thanks go to Dr. M. Jayaratne and Dr. S. U. Adikary for the assistance extended to me as the Post Graduate Research Coordinators.

I would like to express my gratitude to all the academic staff members of the Department of Materials Science and Engineering for their assistance and contribution to this research. Also, I extend my gratitude to Mrs. Dammika Rathnayaka and Mr. J. M. Unagolla for their support.

I am also grateful to Mr. S. Chandrapala, Mr. D. F. Ranasinghe, Mr. S. M. Punchibanda, Mr. G. D. Chandrakumara and other non-academic staff members of the Department of Materials Science and Engineering for their assistance. The support given by the staff of Earth Resources Department is also highly appreciated.

My sincere thanks go to Mr. Wasantha Abeygoonarathne of Highway Engineering, Polgasowita for fabricating the cupola in their workshop, which I later modified in our laboratory.

I like to express my sincere thanks to Mrs. Y. P. S. Siriwardena, Chemist at the GSMB for her assistance in the chemical analysis of ore and other materials. Also, Mr. M. V. K. Perera of Chemistry Department, University of Peradeniya for his assistance on X-Ray Diffraction.

This research was supported by the University of Moratuwa, Senate Research Grant-Number 323 and I am indebted to the Senate Research Committee for awarding this Research Grant.

Sudath Peiris Guluwita,
B.Sc. (Engineering), M.Sc., CEng., MIE(SL)
Department of Materials Science and Engineering
University of Moratuwa
March 2014.



TABLE OF CONTENTS	Page No
Declaration	i
Abstract	ii
Acknowledgement	iii
Table of Contents	V
List of Figures	vii
List of Tables	ix
1 Introduction	1
2 Literature Survey	3
2.1 Iron ore	3
2.2 Ore Minerals	
2.3 Brief History of Ferrous Metallurgy in the World	
2.4 Iron Ores in Sri Lanka	
2.4.1 Hydrated Iron Oxide Deposits	
2.4.2 Magnetite Deposits	
2.4.3 Seruwila Copper-Magnetite Deposit	
2.5 History of Iron Extraction in Sri Lanka	
2.5.1 Ancient Iron making	
2.5.1.1 Iron Bloom	
2.5.2 Ancient Steel making	
2.5.3 Recent Studies on Ancient Iron Extraction	13
2.5.3.1 Studies on Ancient Iron Smelting Technology in Sign	
2.5.3.2 Studies on Ancient Wind Powered Iron Smelting in	
	15
2.6 Iron Ore Preparation	17
2.7 Agglomeration	17
2.7.1 Pelletizing	18
2.8 History of iron Ore Agglomeration	10
,	
Ç	
Theoretical Background	23
3.1 Formation of Green Pellets- Mechanisms of formation	23
3.2 Importance of Apparent Porosity of Pellets	
3.3 Iron Extraction by Direct Reduction	
3.3.1 Selection of a Suitable Reducing Agent	
3.4 Theory of Iron Ore Reduction	
3.4.1 Stepwise Iron Ore Reduction	26

	3.4.1.1 Iron Oxygen System	26
	3.4.1.2 Partial Pressure of CO vs. Temperature Diagram	29
	3.4.2 Reduction Mechanism	30
4	Materials and Apparatus	32
	4.1 Materials	32
	4.1.1 Chemical Composition of Raw Materials	
	4.2 Apparatus	34
	4.2.1 Laboratory Cupola	36
5	Experimental Work	39
	5.1 Preparation of iron ore pellets	39
	5.2 Testing of Pellets	45
6	Results	48
	6.1 Variation of Pellet Strength and Apparent Porosity with Firing	
	Temperature using Dolomitic Lime as the binder	48
	6.2 Variation of Pellet Strength and Apparent Porosity with Firing	
	Temperature using Aruwakkalu Lime as the binder	55
	6.3 Variation of Percentage Weight Loss with Soaking Time at 900° C	
	temperature of pellets during reduction in coke bed using Dolomitic Lime as the	
	binder	58
	6.4 Variation of Percentage Weight Loss with Soaking Time at 900° C temperature of pellets during reduction in coke bed using Aruwakkalu Lime as	
	binder	
	X ray diffraction AnalysisMicro-hardness of 'Metallic Pigs' obtained from the cupola	
	6.7 Microstructure of 'Metallic Pigs' obtained from the cupola	
7	Discussion	
8		
9	Suggestions for Future Work	
	eferences	
	ppendix A: Availability of Iron Ore deposits in Sri Lanka	
	ppendix B: Ancient tools and implements of various kinds	87
A	ppendix C: Part of Ellingham Diagram - Free Energies of formation of some	00
Δ	Oxidesppendix D: Phase Diagrams	
	ppendix E: FeO-CaO-SiO ₂ component diagram, showing surface tension conto	
. 1	as a function of temperature	93

List of Figures

Figure 2.1 Combined plan of double furnace at Hatarabage at the three levels I,II a	and
III of Figure 2.2	9
Figure 2.2 Sections of furnace, along KL and MN of Figure 2.1	10
Figure 2.3 Plan of steel making furnace	12
Figure 2.4 Drawing of series of furnaces	15
Figure 2.5 Reconstruction drawing of well preserved furnace at Dehigaha-ala Kan	ıda
Figure 2.6 Drawing of a furnace found during the implementation of Smanalavew	a
Project	16
Figure 2.7 Comparison of Sinter, Pellets and Briquettes	18
Figure 3.1 Mechanism of pellet making inside a rotory drum pelletizer (top) and d	lisc
pelletizer (bottom)	23
Figure 3.2 Stepwise formation of pellets from iron ore powder	24
Figure 3.3 Reducing gas penetration through pores of the pellet	24
Figure 3.4 Iron – Oxygen Phase Diagram	27
Figure 3.5 The crystal strucure of spinel AB ₂ O ₄	28
Figure 3.6 Equilibrium diagram for iron and its oxides, C and a gaseous phase	
consisting of CO and CO ₂	30
Figure 4.1 Drawing of Laboratory Cupola (Dimensions are in centimeters)	37
Figure 4.2 Steel shell of Laboratory Cupola	38
Figure 4.3 Refractory lining of the laboratory cupola	38
Figure 5.1 Cylindrical ceramic container packed inside with coke	42
Figure 5.2 (a) Components of the ceramic crucible (b) Crucible packed with coke	. 42
Figure 5.3 Charging pellets into the cupola	43
Figure 5.4 View from the top of the cupola while melting via a mirror reflection	44
Figure 6.1 Crushing Strength vs. Firing Temperature at constant soaking time of	
10min of pellets having 100 parts of Iron Ore, 5 parts of Coke and 4 to 10 parts of	2
Dolomitic Lime	49
Figure 6.2 Apparent Porosrity vs. Firing Temperature at constant soaking time of	
10min of pellets having 100 parts of Iron Ore, 5 parts of Coke and 4 to 10 parts of	:
Dolomitic Lime	50
Figure 6.3 Crushing Strength vs. Firing Temperature at constant soaking time of	
10min of pellets having 100 parts of Iron Ore, 5 parts of Dolomitic Lime and 5 to	10
parts of Coke	51
Figure 6.4 Apparent Porosity vs. Firing Temperature at constant soaking time of	
10min of pellets having 100 parts of Iron Ore, 5 parts of Dolomitic Lime and 5 to	10
parts of Coke	52
Figure 6.5 Crushing Strength vs. Firing Temperature at constant soaking time of	
10min of pellets having 100 parts of Iron Ore, 6 parts of Dolomitic Lime and 5 to	8
parts of Coke	53

Figure 6.6 Apparent Porosity vs. Firing Temperature at constant soaking time of
10min of pellets having 100 parts of Iron Ore, 6 parts of Dolomitic Lime and 5 to 8
parts of Coke54
Figure 6.7 Crushing Strength vs. Firing Temperature at constant soaking time of
10min of pellets having 100 parts of Iron Ore, 7 parts of Coke and 5 to 10 parts of
Aruwakkalu Lime56
Figure 6.8 Apparent Porosity vs. Firing Temperature at constant soaking time of
10min of pellets having 100 parts of Iron Ore, 7 parts of Coke and 5 to 10 parts of
Aruwakkalu Lime57
Figure 6.9 Weight Loss vs. Soaking Time of primary optimized pellets (Dolomitic
Lime) subjected to coke bed reduction at 900° C59
Figure 6.10 Weight Loss vs. Soaking Time of primary optimized pellets
(Aruwakkalu Lime) subjected to coke bed reduction at 900° C
Figure 6.11 X ray diffraction pattern of Dela Iron Ore
Figure 6.12 X ray diffraction pattern of 7AL7C1250 ore pellets
Figure 6.13 X ray diffraction pattern of 7AL7C1250 ore pellets reduced for 60 min
at 900° C
Figure 6.14 X ray diffraction pattern of 7AL7C1250 ore pellets reduced for 120 min
at 900° C66
Figure 6.15 X ray diffraction pattern of 7AL7C1250 ore pellets reduced for 150 min
at 900° C67
Figure 6.16 X ray diffraction pattern of 7AL7C1250 ore pellets reduced for 180 min at 900° C
at 900° C68
Figure 6.17 X ray diffraction pattern of 'Metallic Pigs 'obtained from the cupola
after smelting the sample pellets (optimized) - 7AL7C1250
Figure 6.18 Microstructures of 'Metallic Pigs' obtainted from the cupola after
smelting the sample pellets (optimized) - 7AL7C1250 (x 200)71
Figure 7.1 Sketch of partially reduced sphere (pellet) of Iron oxide showing layers
and kinetic steps77
Figure 7.2 Process Flow Chart of preparation of optimized pellet and obtaining
'Metallic Pigs'

List of Tables

Table 2.1 Principal Ore minerals, their composition and approximate iron percent	ntage
	4
Table 4.1 Chemical Analysis of Dela ron Ore	32
Table 4.2 Chemical Analysis of Metallurgical coke	33
Table 4.3 Chemical Analysis of Dolomitic lime	33
Table 4.4 Chemical Analysis of Aruwakkalu lime	34
Table 5.1 Mixing combinations of pellets with Dolomitic Lime as the binder	40
Table 5.2 Mixing combinations of pellets with Aruwakkalu Lime as the binder	40
Table 6.1 Details of samples selected for reduction treatment with Dolomitic Lin	me as
the binder	58
Table 6.2 Details of samples selected for reduction treatment with Aruwakkalu	Lime
as the binder	60
Table 6.3 Micro hardness values on 'Metallic Pigs'	70

