

## Contents

<b>Preface</b>	<i>XVII</i>
Preface to the Second Edition	<i>XVIII</i>
<b>Symbols and Abbreviations</b>	<i>XIX</i>
<b>Acknowledgments</b>	<i>XXVII</i>

<b>Part One</b>	<b>Potential and History</b>	<b>1</b>
	<b>General Thoughts about Energy Supply</b>	<b>3</b>
<b>1</b>	<b>Energy Supply—Today and in the Future</b>	<b>5</b>
1.1	Primary Energy Sources	5
1.2	Secondary Energy Sources	7
1.3	End-Point Energy Sources	7
1.4	Effective Energy	7
<b>2</b>	<b>Energy Supply in the Future—Scenarios</b>	<b>9</b>
<b>3</b>	<b>Potential for Transforming Biomass into End-Point Energy Sources</b>	<b>11</b>
3.1	Amount of Available Area	14
3.2	Theoretical Potential	15
3.2.1	C3 Plants (Energy Plants)	17
3.2.2	C4 Plants and CAM Plants	19
3.2.3	Micro-algae	22
3.3	Technical Potential	23
3.4	Economic Potential	25
3.5	Realizable Potential	25
<b>4</b>	<b>History and Status to Date in Europe</b>	<b>31</b>
4.1	First Attempts at Using Biogas	31
4.2	Second Attempts at Using Biogas	34

4.3	Third Attempts at Applying Biogas	35
4.4	Status to Date and Perspective in Europe	36
<b>5</b>	<b>History and Status to Date Worldwide</b>	<b>39</b>
5.1	History and Status to Date in China	40
5.1.1	Period from 1970 to 1983	40
5.1.2	Period from 1984 to 1991	41
5.1.3	Period from 1992 to 1998	41
5.1.3.1	“A Pit with Three Rebuildings”	43
5.1.3.2	“Four in One”	43
5.1.3.3	“Pig–Biogas–Fruits”	43
5.1.4	Period from 1999 Onwards	43
5.2	History and Status to Date in India	44
5.3	Status to Date in America	46
5.4	Status to Date in the CIS States	47
<b>6</b>	<b>General Aspects of the Recovery of Biomass in the Future</b>	<b>49</b>
<b>Part Two</b>	<b>Substrates and Biogas</b>	<b>51</b>
	<b>Introduction</b>	<b>53</b>
<b>7</b>	<b>Substrate</b>	<b>55</b>
7.1	Agricultural Products	55
7.1.1	Liquid Manure and Co-substrates	62
7.1.2	Maize as the Only Main Crop	67
7.1.3	Bioenergy of Forage Beets	68
7.1.4	Grass	68
7.1.5	Sorghum	69
7.1.6	Crop Rotations	69
7.1.6.1	Forage Rye + Maize	71
7.1.6.2	Winter Barley + Maize	71
7.1.6.3	Hybrid Rye + Sorghum	71
7.1.6.4	Rye + Annual Ryegrass + Maize	71
7.1.6.5	Perennial Ryegrass + Sorghum	72
7.2	Biowaste from Collections of Residual Waste and Domestic Waste Like Commercial Waste	72
7.3	Landfill for Residual Waste	75
7.4	Sewage Sludge and Co-substrate	75
7.5	Industrial Waste Water	79
7.6	Waste Grease or Fat	80
7.7	Cultivation of Algae	81
7.8	Plankton	82
7.9	Sediments in the Sea	82
7.10	Wood, Straw	83

<b>8</b>	<b>Biogas</b>	<b>85</b>
8.1	Biogas Compared with Other Methane-Containing Gases	85
8.2	Detailed Overview of Biogas Components	89
8.2.1	Methane and Carbon Dioxide	90
8.2.2	Nitrogen and Oxygen	92
8.2.3	Carbon Monoxide	92
8.2.4	Ammonia	93
8.2.5	Hydrogen Sulfide	93
8.2.6	Water Vapor	94
8.2.7	Chlorine, Fluorine, Mercaptans	95
8.2.8	BTX, PAHs, etc.	95
8.2.9	Siloxanes	95
<b>Part Three</b>	<b>Formation of Biogas</b>	<b>97</b>
<b>9</b>	<b>Biochemistry</b>	<b>99</b>
<b>10</b>	<b>Bioreactions</b>	<b>101</b>
10.1	Hydrolysis	103
10.2	Acidogenic Phase	103
10.3	Acetogenic Phase	105
10.4	Methanogenic Phase	108
<b>11</b>	<b>Process Parameters</b>	<b>111</b>
11.1	Parameter: Hydrogen Partial Pressure	112
11.2	Parameter: Concentration of the Microorganisms (Ensilage, Recirculation of Biomass)	112
11.3	Parameter: Type of Substrate	114
11.4	Parameter: Specific Surface Area of Material	115
11.5	Parameter: Disintegration	116
11.6	Parameter: Cultivation, Mixing, and Volume Load	121
11.7	Parameter: Light	123
11.8	Parameter: Temperature	124
11.9	Parameter: pH	125
11.10	Parameter: Redox Potential	127
11.11	Parameter: Nutrients (C:N:P Ratio)	127
11.12	Parameter: Precipitants (Calcium Carbonate, Magnesium Ammonium Phosphate, Apatite)	129
11.13	Parameter: Biogas Removal	129
11.14	Parameter: Inhibitors	130
11.14.1	Oxygen	131
11.14.2	Sulfur Compounds	131
11.14.3	Organic Acids (Fatty Acids and Amino Acids)	133
11.14.4	Nitrate ( $\text{NO}_3^-$ )	135
11.14.5	Ammonium ( $\text{NH}_4^+$ ) and Ammonia ( $\text{NH}_3$ )	135

11.14.6	Heavy Metals	137
11.14.7	Tannins, Saponins, Mimosine	137
11.14.8	Other Inhibiting Thresholds	140
11.15	Parameter: Degree of Decomposition	142
11.16	Parameter: Foaming and Scum Formation	142

#### **Part Four    Microorganisms in Methanogenic Ecosystems    145**

<b>12</b>	<b>Methanogenic Ecosystems</b>	<b>147</b>
12.1	Ecosystems in the Gastrointestinal Tract of Ruminants	147
12.1.1	The Gastrointestinal Tract	148
12.1.2	Microorganisms in the Rumen	148
12.1.2.1	Environmentally Sensitive Conditions in the Rumen	149
12.1.2.2	Feedstuff-Associated Conditions in the Rumen	149
12.2	Ecosystems in the Gastrointestinal System of Herbivores	151
12.2.1	Gastrointestinal System of Herbivores	151
12.2.2	Microorganisms in the Stomach of Herbivores	151
12.3	Ecosystems in the Intestine of Termites	153
12.3.1	The Intestinal Tract in Termites	154
12.3.2	Microorganisms in the Intestinal Tract of Termites	154
12.4	Ecosystem in the Soil of a Paddy Field	155
12.5	Ecosystems in a Biogas Reactor	156

<b>13</b>	<b>Microorganisms in Methanation</b>	<b>159</b>
13.1	Protists	159
13.2	Fungi	162
13.3	Bacteriophages	163
13.4	Bacteria and Archaea	163
13.4.1	Hydrolyzing Genera	168
13.4.2	Acidogenic Genera	171
13.4.3	Acetogenic Bacteria	171
13.4.4	Methanogens	174
13.4.5	Methanotrophic Microorganisms	184

#### **Part Five    Dangers with Biogas Plants and Laboratory Equipment    185**

<b>14</b>	<b>Guidelines and Regulations</b>	<b>187</b>
14.1	Regulations Relating to the Construction of Plants	188
14.2	Biomass and Residue	189

14.3	Feeding Biogas to the Gas Network	189
14.4	Risk of Explosion	190
14.5	Risk of Fire	198
14.6	Harmful Exhaust Gases	201
14.6.1	Germs	201
14.6.2	Emissions of Smells	202
14.7	Noise Protection	210
14.8	Prevention of Injuries	212
14.9	Protection from Water	213
<b>15</b>	<b>The Biogas Laboratory</b>	<b>217</b>
15.1	Laboratory Digesters with Eudiometers	217
15.2	Pilot Fermenter	217
15.3	Large Pilot Plants for Batchwise or Continuous Fermentation Tests	219
15.4	Analyses	219
15.4.1	Sampling	220
15.4.2	Preparation of Samples	220
15.4.3	Analytics	221
15.4.3.1	Gas Yield of Substrates	221
15.4.3.2	Dry Matter and Organic Dry Matter (TOC), Loss on Ignition	221
15.4.3.3	Degree of Decomposition	222
15.4.3.4	Elution with Water (ISO 11465)	226
15.4.3.5	Quantity of Gas	226
15.4.3.6	Gas Composition	227
15.4.3.7	Acid Value	229
15.4.3.8	FOS/TAC Value	230
15.4.3.9	Determination of Nutrients (Nitrogen and Phosphorus Compounds)	230
15.4.3.10	Sludge Volume Index	230
<b>Part Six</b>	<b>Equipment of a Biogas Plant</b>	<b>231</b>
<b>16</b>	<b>Tanks and Bioreactors</b>	<b>233</b>
16.1	Brick Tanks	235
16.1.1	Brickwork and Mortar	238
16.2	Reinforced Concrete Tanks	239
16.2.1	Surface Protection by Painting	241
16.2.2	Surface Protection by Tanks with Double Walls	242
16.3	Tanks of Normal Steel Sheet Metals with an Enamel Layer or Plastic Coating	242
16.4	Tanks of Stainless Steel	243
16.5	Ground Basin with Plastic Foil Lining	243

<b>17</b>	<b>Equipment for Tempering the Substrate</b>	<b>245</b>
<b>18</b>	<b>Thermal Insulation</b>	<b>249</b>
<b>19</b>	<b>Agitators</b>	<b>251</b>
19.1	Mechanical Agitation	251
19.1.1	Submersible Motor-Propeller Agitators	252
19.1.2	Axial Agitators, Hand-Held Blenders	252
19.1.3	Reel Agitators or Paddle Agitators	254
19.1.4	Grindel Agitators	254
19.1.5	Agitating Chain (Figure 19.4)	254
19.1.6	Screw Conveyor Mixer	255
19.2	Circulation Pumps	256
19.3	Gas Injection into the Digestion Tower	256
19.4	Stirring Effect by Gas Formation	257
<b>20</b>	<b>Mixing of Biomass and Water</b>	<b>259</b>
<b>21</b>	<b>Machines to Separate the Liquid from the Biomass</b>	<b>261</b>
21.1	Belt-type Press	261
21.2	Filter Press	261
21.3	Decanters	262
<b>22</b>	<b>Pipes</b>	<b>265</b>
22.1	Substrate Pipework	265
22.2	Gas Pipes	266
<b>23</b>	<b>Pumps</b>	<b>269</b>
23.1	Submerged Centrifugal Pump, Submerged Motor Centrifugal Pump	269
23.2	Eccentric Screw Pump, Eccentric Rotor Pump	270
<b>24</b>	<b>Measurement, Control, and Automation Technology</b>	<b>271</b>
24.1	Mechanisms for Monitoring and Regulation	271
24.1.1	Quantity of Gas and Gas Composition	272
24.1.2	Temperature	273
24.1.3	pH Value and Redox Potential	273
24.1.4	Organic Dry Matter–Volumetric Loading	273
24.1.5	Biology	274
24.2	Equipment to Guarantee Operating Safety	274
24.2.1	Safety Device in Front of the Gas Flare	274
24.2.2	Safety Devices to Counteract Overpressure and Negative Pressure	275

<b>25</b>	<b>Exhaust Air Cleaning</b>	<b>277</b>
<b>Part Seven</b>	<b>Upstream and Downstream Processing</b>	<b>279</b>
<b>26</b>	<b>Transportation and Storage of the Biomass</b>	<b>281</b>
26.1	Transport and Means of Transport	281
26.2	Storage Silos	281
26.2.1	Transport Within the Plant	284
<b>27</b>	<b>Process Technology for Upstream Processing</b>	<b>285</b>
27.1	Adjustment of the Water Content	285
27.2	Removal of Impurities/Harmful Substances (Figure 27.3)	289
27.3	Comminution	290
27.4	Hygienization	291
27.4.1	Direct Inspection	292
27.4.1.1	Salmonella	293
27.4.1.2	Plasmiodiophora Brassicae	293
27.4.1.3	Tobacco Mosaic Virus	294
27.4.1.4	Tomato Seeds	294
27.4.2	Indirect Process Inspection	294
27.4.3	Control of the Finished Goods	295
27.5	Disintegration	295
27.5.1	Mechanical Processes (Figure 27.8)	301
27.5.2	Ultrasonic Process	303
27.5.3	Chemical Processes	304
27.5.3.1	Hydrochloric Acid	304
27.5.3.2	APTMP- and CTMP-processes	305
27.5.3.3	Chemical Oxidation	305
27.5.4	Thermal Processes	306
<b>28</b>	<b>Feeding</b>	<b>311</b>
28.1	Feeding with Substrate	311
28.2	Feeding with Additives	312
28.2.1	Prebiotics	313
28.2.2	Enzymes	314
28.2.3	Probiotics	315
28.2.4	Chemicals	316
<b>29</b>	<b>Digested Residue</b>	<b>321</b>
29.1	Pressing of the Fermentation Residue	323
29.2	Drying	324
<b>30</b>	<b>Wastewater</b>	<b>325</b>

<b>Part Eight</b>	<b>Fermentation–Agricultural Plant</b>	<b>327</b>
<b>31</b>	<b>Batchwise and Continuous Processes Without Separators</b>	<b>329</b>
31.1	Floating Cup Reactor	330
31.2	Fixed-Dome Reactor	330
31.3	Deenbandhu Model	332
31.4	Plastic Bag Reactor and Plastic Silo Reactor	332
31.5	Cavern Plants	333
31.6	One-Stage Agricultural Biogas Plants	333
31.6.1	Reactor Technology	335
31.6.2	Reactor Size	337
31.6.3	Covering of the Bioreactor	338
31.6.4	Access Door and Inlet	339
31.6.5	Drainage Layer Below the Bioreactor	339
31.6.6	Heat Insulation and Heating	340
31.6.7	Final Depot and Spreading	341
<b>32</b>	<b>Existing Installations from Different Suppliers</b>	<b>343</b>
32.1	WABIO-Vaasa Process	343
32.2	DUT Process	343
32.3	Entec Process	344
32.4	Bigadan™ Process (Formerly Krüger Process)	345
32.5	Valorga™ Process	346
<b>33</b>	<b>Operation of a Plant Without Separation Equipment</b>	<b>349</b>
33.1	Start-up	349
33.2	Start-up of the Plant	350
33.3	Operation of the Plant	351
<b>34</b>	<b>Benefits of a Biogas Plant</b>	<b>353</b>
<b>35</b>	<b>Typical Design Calculation for an Agricultural Biogas Plant</b>	<b>357</b>
<b>36</b>	<b>Economics Calculations for Biogas Plants</b>	<b>365</b>
36.1	Capital-Bound Costs Per Year in US\$	365
36.2	Consumption-Bound Costs Per Year	366
36.3	Operation-Bound Costs Per Year	367
36.4	Other Costs Per Year	367
36.5	Total Costs	367
36.6	Income Per Year	368
36.7	Annual Revenue of the Biogas Plant	368
<b>37</b>	<b>Efficiency</b>	<b>369</b>

<b>Part Nine</b>	<b>Fermentation—Industrial Plants</b>	<b>373</b>
	<b>Fermentation</b>	<b>375</b>
<b>38</b>	<b>Installation with Substrate Dilution and Subsequent Water Separation</b>	<b>377</b>
38.1	Process Engineering	377
38.2	Implemented Installations of Different Manufacturers	377
<b>39</b>	<b>Installation with Biomass Accumulation</b>	<b>381</b>
39.1	Sewage Sludge Digestion Tower Installation	381
39.1.1	Size of the Digestion Tower	382
39.1.2	Internal Phase Separation for Biomass Concentration	385
39.1.3	External Phase Separation for Feedback of Biomass	386
39.1.3.1	Sedimentation Tank	386
39.1.3.2	Lamellar Settler	386
39.1.3.3	Membrane Filter	387
39.1.3.4	Flotation	387
39.1.3.5	Centrifuge	387
39.1.4	Facilities to Prevent Post-Gassing	387
39.1.4.1	Ventilation	388
39.1.4.2	Vacuum Degassing	388
39.1.4.3	Cooling	388
39.1.4.4	Agitators	388
39.1.4.5	Addition of Flocculating Agents and Flocculation-Aiding Agents	389
39.1.5	Operation of the Digestion Tower	389
39.1.5.1	Energy Consumption	391
39.1.6	Plant Installations	392
39.1.6.1	Contact Process (Figure 39.6)	392
39.1.6.2	Uhde–Schwarking Process	392
39.1.6.3	Continuously Stirred Tank Reactor (Figure 39.8)	393
39.2	Sludge-Bed Reactor	394
39.2.1	Reactor Design and Ratings	396
39.2.2	Assumptions for the Operation of a Sludge-Bed Reactor	399
39.2.3	Operation of a Sludge-Bed Reactor	400
39.2.4	Plant Installations	401
39.2.4.1	Hybrid Reactor (UASB/Filters)	401
39.2.4.2	Loop Reactor	401
39.3	Reactors with Immobilized Microorganisms	402
39.3.1	Biofilm	403
39.3.2	Fixed-Bed Reactor, Filter Reactor, Fixed-Film Reactor	405
39.3.3	Expanded-Bed Reactor, Fluidized-Bed Reactor	406

<b>40</b>	<b>Plants with Separation of Non-Hydrolyzable Biomass</b>	<b>409</b>
40.1	Process Engineering and Equipment Construction	410
40.2	Efficiency	411
40.3	Plant Installations	412
40.3.1	Anaerobic Baffled Reactors	412
40.3.2	BTA Process	412
<b>41</b>	<b>Percolation Process</b>	<b>415</b>
41.1	Dry Fermentation Process in a Stack	415
41.2	AN/Biothane™ Process	416
41.3	Prethane™/Rudad™–Biopaq™ Process or ANM Process	417
41.4	Foil Hose Process	418
41.5	IMK Process	418
41.6	Dry Anaerobic Composting	419
41.7	Aerobic–Anaerobic–Aerobic Process (3A Process)	420
41.8	Fermentation Channel Process	421
<b>42</b>	<b>Special Plant Installations</b>	<b>423</b>
42.1	Combined Fermentation of Sewage Sludge and Biowaste	423
42.2	Biowaste Plants	425
42.3	Purification of Industrial Wastewater	430
<b>Part Ten</b>	<b>Biogas Storage and Preparation</b>	<b>431</b>
<b>43</b>	<b>Biogasholder</b>	<b>433</b>
43.1	Biogasholder Types	433
43.1.1	Low-Pressure Biogasholder	435
43.1.1.1	Double-Membrane Biogasholders	435
43.1.1.2	Biogas Bags	435
43.1.1.3	Other Low-Pressure Biogasholders	436
43.1.2	Medium- and High-Pressure Biogasholders	436
43.2	Gas Flares	437
<b>44</b>	<b>Gas Preparation</b>	<b>439</b>
44.1	Removal of Hydrogen Sulfide	442
44.1.1	Biological Desulfurization	442
44.1.1.1	Immobilization in the Bioreactor	445
44.1.2	Sulfide Precipitation	447
44.1.3	Absorption in a Ferric Chelate Solution	447
44.1.4	Adsorption at Iron-Containing Masses	448
44.1.5	Adsorption on Activated Charcoal	449
44.1.6	Chemical Binding to Zinc	450
44.1.7	Surfactants	450
44.1.8	Passing the Biogas Through an Algae Reactor or Addition of Sodium Alginate	450

44.1.9	Direct Oxidation	451
44.1.10	Compressed Gas Scrubbing	451
44.1.11	Molecular Sieves	451
44.2	Removal of the Carbon Dioxide	451
44.2.1	Gas Converter	454
44.2.2	Absorption	455
44.2.3	Absorbents Based on Glycol and Ethanolamines	457
44.2.4	Adsorption with Pressure Swing Technology	458
44.2.5	Adsorption with Pressure Swing Technology Under Vacuum	459
44.2.6	Diaphragm Technology	460
44.2.7	Mineralization and Biomineralization	461
44.2.8	Cryogenic Biogas Purification	461
44.3	Removal of Oxygen	462
44.4	Removal of Water	462
44.5	Removal of Ammonia	463
44.6	Removal of Siloxanes	464

**45 Quantities of Gas and Measurement of Gas Quality 465**

**46 Liquefaction or Compression of the Biogas 467**

46.1	Liquefaction	467
46.2	Compression	469

**Part Eleven Biogas Utilization 471**

**Utilization of Biogas to Generate Electric Power and Heat 473**

**47 Utilization of Gas Exclusively to Generate Heat 475**

**48 Utilization of Gas to Generate Current and Heat 477**

48.1	Supply of Current to the Public Power Network	477
48.1.1	Generators	479
48.1.2	Current-Measuring Instruments	479
48.1.3	Control of the Synchronization	480
48.1.4	Switching Devices	480
48.1.5	Network Failure Registration	480
48.1.6	Short-Circuit Protection	481
48.1.7	Wattless Current Compensation	481
48.2	Heat	482
48.3	Combined Heat and Power Generator (CHP)	483
48.3.1	Engines	483
48.3.1.1	Generation of Electricity in a Four-Stroke Gas Engine and a Diesel Engine	485
48.3.1.2	Generation of Electricity in a Stirling Engine	489
48.3.1.3	Generation of Electricity in a Fuel Cell	491

48.3.1.4	Generation of Electricity in a Gas Turbine	494
48.3.1.5	Generation of Electricity in a Micro Gas Turbine	497
48.3.2	Controlling the CHP	500
48.3.3	Emission Control	501
48.3.3.1	Regulations	502
48.3.3.2	Measures for the Reduction of Emissions	502
48.4	Lessons Learnt from Experience	504
48.5	Economy	507
<b>49</b>	<b>Biogas for Feeding into the Natural Gas Network</b>	<b>509</b>
49.1	Biogas for Feeding into the Natural Gas Network in Switzerland	512
49.2	Biogas for Feeding into the Natural Gas Network in Sweden	513
49.3	Biogas for Feeding into the Natural Gas Network in Germany	514
<b>50</b>	<b>Biogas as Fuel for Vehicles</b>	<b>517</b>
50.1	Requirements on Gas When Used as Fuel	517
50.2	Vehicles	517
50.3	Gasoline Station	518
	<b>Literature</b>	<b>521</b>
	<b>Index</b>	<b>539</b>