

Contents

Acknowledgment *XI*

Preface *XIII*

1	Classification of Explosives	1
1.1	Initiation Sensitivity	1
1.2	Size	1
1.3	Usage	2
1.4	Physical Form	2
2	Explosive Science	5
2.1	Introduction	5
2.1.1	Low Explosives	5
2.1.2	High Explosives	5
2.2	Initiation and Detonation	6
2.2.1	Mechanism	6
2.3	Propagation and Detonation	7
2.3.1	Propagation	7
2.3.2	Detonation	8
2.3.2.1	Ideal/Nonideal Detonation/Critical Diameter/Ideal Diameter	9
2.3.2.2	Detonation Pressure and Velocity	9
2.4	Reaction Chemistry in Explosives	11
2.4.1	Heat of Reaction	11
2.4.2	Rules of Hierarchy	12
2.4.3	Calculation of Oxygen Balance and Fuel Values	12
	References	13
3	Ammonium Nitrate Explosives	15
3.1	Introduction	15
3.1.1	Chronology	15
3.2	Design of Commercial Explosives	16
3.2.1	Importance of Oxygen Balance	16
3.2.2	Physical, Performance, and Safety Requirements	17

3.3	Tests	17
3.3.1	Ballistic Mortar Test	18
3.3.2	Trauzl Lead Block Test	19
3.3.3	Velocity of Detonation (VOD)	20
3.3.4	Gap Test and Continuity of Detonation Test	22
3.3.5	Aquarium Test	23
3.3.6	Double Pipe Test	23
3.3.7	Cylinder Test (Crushing Strength)	24
3.3.8	Plate Dent Test	24
3.3.9	Underwater Test (UWT)	24
3.3.10	Crater Test	26
3.4	Assessment of Safety and Stability Characteristics	27
3.4.1	Impact Test	27
3.4.2	Torpedo Friction Test	27
3.4.3	Accelerated Hot Storage (ageing Test)	27
3.4.4	Cold Temperature Storage Test	28
3.4.5	Thermal Stability Tests Using DTA and TGA Procedures	28
3.5	Summary	29
	References	29
4	Ammonium Nitrate and AN/FO	31
4.1	Introduction and History	31
4.2	Physical and Chemical Properties of Ammonium Nitrate	32
4.2.1	Basic Data	32
4.2.2	Decomposition Chemistry of AN	32
4.2.3	Phase Transition in AN and its Importance in Explosives	33
4.3	Manufacture of Ammonium Nitrate	35
4.3.1	Prilled Ammonium Nitrate	36
4.4	Ammonium Nitrate Fuel Oil Explosives	39
4.4.1	Background	39
4.4.2	AN/FO Manufacture	39
4.4.2.1	Mixing Process and Equipment	39
4.4.2.2	Continuous Process	40
4.4.2.3	Bulk Delivery Systems	40
4.4.3	Properties of AN/FO	41
4.4.3.1	Physical	41
4.4.3.2	Oil Absorbency and Porosity/Bulk Density/Crushing Strength	41
4.4.3.3	Resistance to Effect of Temperature Cycling	44
4.4.4	Characteristics of ANFO	45
4.4.4.1	Density/Strength	45
4.4.4.2	Strength of the AN/FO Explosive	46
4.4.4.3	Energy Content of AN/FO	46
4.4.4.4	Velocity of Detonation and Effective Priming	47
4.4.4.5	Mechanism of Detonation Propagation in AN/FO	49
4.4.4.6	Influence of Fuel	50

4.4.4.7	Effect of Moisture/Wet Boreholes/Water-Resistant AN/FO	50
4.4.4.8	Water-Resistant AN/FO	52
4.4.4.9	Increasing the Energy of AN/FO and its Fume Characteristics	52
4.4.5	Safety Considerations in AN/FO	55
4.4.6	Summary – AN/FO Explosives	56
4.4.7	Quality Checks	56
	References	58
	Further Reading	58
5	Slurries and Water Gels	59
5.1	Development	59
5.2	Design	59
5.2.1	Large-Diameter Packaged Product (Water Gels)	60
5.2.2	List of Ingredients	60
5.2.3	Small-Diameter, Cap-Sensitive Water Gels	60
5.2.4	Bulk Delivery Product	61
5.2.5	Basic Concepts of Formulation	61
5.2.5.1	Oxygen Balance	61
5.2.5.2	Thumb Rules for Design	62
5.2.5.3	Role of Water	63
5.2.5.4	Basic Composition and Process	65
5.3	Process Technology	66
5.3.1	Batch Process	66
5.3.2	Continuous Process	68
5.3.3	Packaging Systems	68
5.4	Quality Checks	71
5.4.1	Raw Materials	71
5.4.2	End Product Specification	73
5.4.2.1	Development of New Formulations	73
5.4.3	Role of Aluminum in Water Gels and Slurry Explosives	74
5.4.3.1	Atomized and Flake Powders	74
5.4.3.2	Aluminum Water Reaction	78
5.4.3.3	Important Tests for AL Powder for Use in AN-Based Water Gel Explosives	80
5.4.4	In-Process and Finished Product Checks	84
5.4.4.1	Oxidizer Blend Composition	84
5.4.4.2	Solid Ingredients	85
5.4.4.3	Liquid Ingredients	85
5.4.4.4	Mixing	85
5.4.4.5	Packing	86
5.4.5	Performance Tests	86
5.4.6	Safety Tests	87
5.4.6.1	Gap Test/COD	87
5.4.6.2	COD	87
5.4.7	Storage Tests	87

5.4.8	Gel Condition Evaluation	89
5.4.9	Waterproofness Test	90
5.4.10	Effect of (Hydrostatic) Pressure	90
5.5	Process Hazards (Dust Explosions/Fire Hazards/Health Hazards)	91
5.5.1	Slippery Floor	92
5.5.2	Health Hazard	92
5.6	Role of GG	92
5.6.1	Application in Water Gels and Slurries	93
5.6.2	Specification of Typical GG Used in Water Gels	94
5.6.3	Cross-Linking	95
5.6.4	Mechanism of Hydration	96
5.7	Permissible Explosives	98
5.7.1	Design Criteria	98
5.7.2	Tests for Permissibility	99
5.7.3	Other Tests requirement	100
5.7.3.1	Deflagration Tests	100
5.7.4	Behavior of Water Gels in Permissibility Tests	101
5.7.5	Toxic Fumes and Typical Formulation	104
5.7.6	Strength of Permissible Water Gels	104
5.8	General Purpose Small-Diameter Explosives (GPSD)	105
5.8.1	Design Criteria and Composition	105
5.9	Sensitizers	106
5.9.1	Inorganic	106
5.9.2	Organic Sensitizers	107
5.9.3	Air/Gas/Synthetic Bubble Sensitizers	108
	References	111
	Further Reading	112
6	Emulsion Explosives	113
6.1	Introduction	113
6.2	Concept of Emulsion Explosives	113
6.3	General Composition of Emulsion Explosives	114
6.4	Structure and Rheology	115
6.5	Composition and Theory of Emulsion Explosives	117
6.6	Manufacture	118
6.6.1	Types of Emulsion Explosive Products	118
6.6.2	Manufacturing Process	118
6.6.2.1	Batch Process	119
6.6.2.2	Semicontinuous Operation	119
6.6.2.3	Fully Continuous Process	120
6.6.2.4	Critical Equipment for Production of Emulsion Explosives	121
6.6.2.5	Pumps	122
6.6.2.6	Packaging Equipment for Emulsion Explosives	122
6.6.3	Raw Material for Emulsion	123

6.6.3.1	Fuel Blends	123
6.6.4	Sensitizing in Emulsion Explosives	125
6.6.4.1	Air Entrapment or Occlusion while Emulsification by Mechanical Agitation	125
6.6.4.2	Chemical Gassing	125
6.6.4.3	Hollow Particles	126
6.6.5	Crystal Habit Modifiers	127
6.6.6	Emulsion Promoters	128
6.6.7	Emulsion Stabilizers	128
6.6.8	Emulsion Chemistry and Understanding Emulsifiers: Key to Good Emulsions	129
6.6.9	Concept of HLB and Its Use in Emulsification	133
6.6.9.1	Effect of Factors on Stability of Emulsions	135
6.6.10	Polymer Systems in Emulsion Explosives	138
6.7	Quality Checks	139
6.7.1	Raw Materials	139
6.7.2	Process Audit	140
6.7.3	Special Tests for Emulsions	141
6.8	Explosive Properties of Emulsion Matrix/Explosives	142
6.8.1	Channel Effect	144
6.9	Permissible Emulsions	145
6.10	General Purpose Small-Diameter (GPSD) Emulsion Explosives	147
6.11	Bulk Emulsions	149
6.12	Heavy AN/FO	151
6.13	Packaged Large-Diameter Emulsion Explosives	153
	References	154
	Further Reading	155
7	Research and Development	157
7.1	Areas of Interest	158
7.2	Development Work and Upscaling	159
7.3	Management of R&D	161
8	Functional Safety during Manufacture of AN Explosives	163
8.1	Introduction – Personal View Point on Safety	163
8.2	Safety Considerations in AN Explosives	165
8.2.1	In AN/FO	165
8.2.2	In Slurries and Emulsions	166
8.2.3	Electrostatic Ignition	167
8.2.4	Lightning Protection	168
8.2.5	Runaway Reactions	168
8.2.6	Venting as Means of Protection	170
8.2.7	Explosion Suppression Technology	171
8.3	Explosion Hazards in Equipment	172
8.3.1	Hazards Associated with Pumping of Explosives	172

8.3.2	Possible Hazards during Packing	175
8.4	Concluding Remarks	176
	References	177
9	Economics of AN-Based Explosives	179
9.1	In Manufacture	179
9.2	In Applications	181
9.2.1	Condition of Explosive	182
9.2.2	Coupling and Priming	183
9.2.3	Stemming and Confinement	184
9.2.4	Explosives–Rock Interaction	185
9.2.5	Explosives Energy Optimization in Blasting	185
9.3	Blast Design	186
9.4	Influence of Explosives in Underground Mining	190
	References	193
10	Current Status and Concluding Remarks	195
	Appendix A	199
	Appendix B: Guidelines for Investigation of an Accident	203
B.1	Introduction	203
B.2	Detailed Inspection	204
B.3	Interviewing and Questioning	205
B.4	Collection of Samples	205
B.5	Examination of Witnesses	206
B.6	Examination of Dead/Injured	206
	Index	209