Contents

Graphical Abstract xi Preface xiii

1 Introduction to Sustainability and Green Chemistry 1

|v

- 1.1 Introduction 1
- 1.2 Defining "Sustainability" 2
- 1.3 Dimensions of Sustainability 3
- 1.4 New Conceptual Frameworks to Define Sustainability 5
- 1.4.1 Five Dimension Framework 5
- 1.4.2 Four Force Model 5
- 1.4.3 Corporate Sustainable Management 7
- 1.5 Green Value Stream Mapping (GVSM) 7
- 1.6 "Greening the Waste" 8
- 1.7 Green Chemistry Terminology 10
- 1.8 Green Ways of Metal Extraction: Core of the Book *11* Questions *13*

2 Waste Handling and Pre-treatment 15

- 2.1 Introduction 15
- 2.2 Waste Categorization 17
- 2.2.1 Waste Electrical and Electronic Equipment (WEEE) 17
- 2.2.2 Agro-Residue Waste 20
- 2.2.3 Industrial Waste 21
- 2.3 Legislations and Regulations for Hazardous Wastes 27
- 2.4 Handling/Management of Hazardous Waste 28
- 2.4.1 Secured Landfilling 29
- 2.4.2 Incineration 30
- 2.4.3 Recycling of Hazardous Waste 31
- 2.5 A Call for Metal Recovery from Waste 31
- 2.5.1 Threat to Human Health and Environment 31
- 2.5.2 Waste: An Artificial Ore 32
- 2.5.3 "Waste" to Wealth 33

vi Contents

- 2.6 Pretreatment of Waste 34
- 2.6.1 Disassembling the Waste 34
- 2.6.2 Size Reduction (Comminution) 34
- 2.6.3 Screening/Sieving 35
- 2.6.4 Classification 36
- 2.6.5 Segregation 36
- 2.6.6 Calcination and Chemical Pretreatment 37
- 2.7 Summary and Outlook 37
 - Questions 38

3 Conventional Technologies for Metal Extraction from Waste 39

- 3.1 Introduction 39
- 3.2 Pyrometallurgical Operations 40
- 3.2.1 Pyrometallurgical Treatment of Industrial Waste 40
- 3.2.2 Pyrometallurgical Treatment of WEEE 45
- 3.2.3 Major Challenges Associated with Pyrometallurgical Operations 49
- 3.3 Hydrometallurgical Treatment of Waste 50
- 3.3.1 Leaching of Metals in Acidic Medium 50
- 3.3.2 Leaching of Metals in Alkali Medium 57
- 3.3.3 Leaching with Lixiviants (Cyanide, Thiourea, Thiosulfate) 60
- 3.3.4 Halide Leaching 66
- 3.4 Summary and Outlook 69 Questions 70

4 Emerging Technology for Metal Extraction from Waste: I. Green Adsorption 71

- 4.1 Introduction 71
- 4.2 Adsorption 71
- 4.2.1 Hydrophilic Compounds 72
- 4.2.2 Hydrophobic Compounds 72
- 4.2.3 Polymer Matrix 73
- 4.3 Green Adsorption 74
- 4.4 Parameters Affecting the Adsorption Capacity of Green Adsorbents 75
- 4.4.1 Influence of pH 75
- 4.4.2 Influence of Temperature 76
- 4.4.3 Effect of Initial Concentration 76
- 4.4.4 Effect of Adsorbent Dosage 76
- 4.4.5 Effect of Co-ions 77
- 4.5 Adsorption Kinetic Models 77
- 4.6 Mechanism of Metal Uptake 78
- 4.7 Green Adsorbents: Relevant Literature 79
- 4.7.1 Agricultural Resources 79
- 4.7.2 Zeolites 81
- 4.7.3 Clay 84

- 4.7.4 Industrial Waste 85
- 4.7.5 Modified Biopolymers 88
- 4.8 Innovative Applications of Adsorption 88
- 4.9 Case Study 89
- 4.10 Summary and Outlook 90 Questions 91

5 Emerging Technologies for Extraction of Metals from Waste II. Bioleaching 93

- 5.1 Introduction 93
- 5.2 Bioleaching Process Description 94
- 5.3 Factors Affecting the Process Efficiency 95
- 5.3.1 Types of Microorganisms 95
- 5.3.1.1 Mesophiles 95
- 5.3.1.2 Thermophiles 96
- 5.3.1.3 Heterotrophic Microbes 97
- 5.3.2 Affinity Between Microorganisms and Metal Surfaces 97
- 5.3.3 Physicochemical Factors 98
- 5.3.3.1 Surface Properties 98
- 5.3.3.2 Oxygen and Carbon Dioxide Content 98
- 5.3.3.3 pH Value of Solution 99
- 5.3.3.4 Temperature 99
- 5.3.3.5 Mineral Substrate 99
- 5.3.3.6 Surface Chemistry of Metals 99
- 5.3.3.7 Surfactant and Organic Extractants 100
- 5.3.4 Reactor Design 100
- 5.4 Mechanism of Bioleaching Process 101
- 5.4.1 Biochemical Reaction (Direct vs. Indirect) Mechanism 102
- 5.4.2 Mechanism of Metal Sulfide Dissolution (Polysulfide Pathway) 103
- 5.5 Engineering Practices in Bioleaching Process 104
- 5.5.1 Batch Process 105
- 5.5.2 Continuous Process 106
- 5.5.3 Hybrid Processes 110
- 5.6 Application of Bioleaching in Extracting Metals from Waste 110
- 5.6.1 Extraction of Metals from WEEE 111
- 5.6.2 Extraction of Metals from Industrial Waste 115
- 5.6.3 Extraction of Metals from Mineral Waste 118
- 5.6.4 Extraction of Metals from Municipal Sewage Sludge 119
- 5.7 Technoeconomic Opportunities and Challenges *119*
- 5.8 Summary and Outlook *121* Questions *122*
- 6 Future Technology for Metal Extraction from Waste: I. Chelation Technology 123 Abbreviations 123
- 6.1 Introduction 123

- 6.2 Defining "Chelation" 124
- 6.3 Classification of Ligands 124
- 6.4 Chemistry Associated with Chelation 127
- 6.4.1 Theories Derived for Metal–Ligand Complexation 127
- 6.4.2 Attributes of Metal Ions for Complexation 129
- 6.4.3 Metal–Chelate Complex Formation 130
- 6.4.4 The Chelate Effect 132
- 6.5 Chelation Process for Extraction of Metals 133
- 6.5.1 Framework for Chelating Agent Assisted Metal Extraction from Solid Waste 133
- 6.5.2 Process Parameters Affecting the Metal Extraction Process 135
- 6.5.2.1 Effect of Reaction pH 135
- 6.5.2.2 Effect of Molar Concentration of Chelating Agent 138
- 6.5.2.3 Effect of Reaction Temperature 140
- 6.5.2.4 Presence of Competing Ions in Reaction Zone 141
- 6.5.3 Factors Affecting Stability of Metal–Ligand Complex 142
- 6.6 Novel Applications of Chelating Agents 143
- 6.6.1 Chelating Agents Used for Metal Extraction from Metal-Contaminated Soil 144
- 6.6.1.1 Hydrometallurgical Route of Chelation Process (Direct Use) 144
- 6.6.1.2 Phyto-remediation of Soils in Presence of Chelating Agents 145
- 6.6.2 Chelating Agents Used for Metal Extraction from Industrial Waste 147
- 6.6.3 Chelating Agents Used for Metal Extraction from WEEE 149
- 6.7 Ecotoxicological Concerns and Biodegradability 151
- 6.8 Summary and Outlook 155 Questions 155

7 Future Technology for Metal Extraction from Waste: II. Ionic Liquids 157

- Abbreviation 157
- 7.1 Introduction 158
- 7.2 What Are Ionic Liquids? *158*
- 7.3 Characteristic Properties of Ionic Liquids 161
- 7.3.1 Melting Point 162
- 7.3.2 Vapor Pressure and Nonflammability 162
- 7.3.3 Thermal Stability 163
- 7.3.4 Density 164
- 7.3.5 Viscosity 164
- 7.3.6 Polarity 166
- 7.3.7 Coordination Ability 166
- 7.3.8 Conductivity 167
- 7.3.9 Solubility 167
- 7.4 Classification of Ionic Liquids 169
- 7.5 Environmental Scrutiny of Ionic Liquids 171
- 7.6 Applications of Ionic Liquids 173

Contents ix

- 7.6.1 Extraction of Metals from Aqueous Media 173
- 7.6.2 Extraction of Metals from Industrial Solid Waste/Ores 176
- 7.6.3 Extraction of Metals from WEEE 177
- 7.7 Summary and Outlook 179 Questions 179

8 Scale-up Process for Metal Extraction from Solid Waste 181

Nomenclature 181

- 8.1 Introduction 182
- 8.2 Process Intensification 183
- 8.3 Intensification of Metal Extraction Processes 185
- 8.3.1 Centrifugation 185
- 8.3.2 Liquid–Liquid Extraction 185
- 8.3.3 Mixing 186
- 8.3.4 Reactors 188
- 8.3.5 Comminution 188
- 8.3.6 Drying 189
- 8.4 Scaling Up from Batch to Continuous Process 189
- 8.4.1 Process Design Fabrication 190
- 8.4.2 Designing of Pilot Plant 191
- 8.4.2.1 Material Balance 191
- 8.4.2.2 Development of Comminution Circuit 193
- 8.4.3 Reactor Sizing and Agitator Selection 197
- 8.4.4 Design of Filtration System 199
- 8.4.5 Design of Heat Exchanger 201
- 8.4.6 Design of Precipitator Unit 202
- 8.4.7 Batch Scheduling 203
- 8.5 Summary and Outlook 204 Ouestions 205
 - Questions 205
- 9 Process Intensification for Micro-flow Extraction: Batch to Continuous Process 207 Jogender Singh, Loveleen Sharma, and Jamal Chaouki

Abbreviations 207

- 9.1 Introduction 208
- 9.2 Miniaturized Extraction Devices 208
- 9.2.1 Intensification in Miniaturized Extraction Devices 209
- 9.2.2 Application of Miniaturized Extraction Devices 211
- 9.3 CFI for Continuous Micro-flow Extraction 212
- 9.3.1 Designing CFI as an Extractor 216
- 9.3.2 Extraction Parameters 218
- 9.3.3 Methodology and Setup for Micro-flow Extraction 218
- 9.3.4 Liquid–Liquid Micro-flow Extraction 220
- 9.3.4.1 Typical Flow Patterns 220

x Contents

- 9.3.4.2 Extraction Efficiency 222
- 9.3.4.3 Effect of Aqueous Phase Volume Fractions on Extraction Efficiency 223
- 9.3.5 Micro-flow Extraction of Co and Ni 225
- 9.3.5.1 Effect of pH 225
- 9.3.5.2 Effect of Residence Time 225
- 9.3.5.3 Effect of Extractant Concentration 229
- 9.4 Summary and Future Challenges 229 Questions 229

Bibliography 231

Index 273