

### FORMATION OF GORDAITE AS A PRODUCT OF FLY ASH DURING HIGH TEMPERATURE OXIDATION OF GALVANIZED STEEL PARTS

#### ABSTRACT

Fly Ash, a solid waste (particulate matter) generated from a steel smelting plant was analyzed and characterized. Physical and chemical investigations of the fly ash from a steel manufacturing company was conducted using X-ray diffraction (XRD), Scanning electron microscopy (SEM) and Hot stage Microscopy (HSM) to determine its properties. The fly ash sample comprised mainly of Fe, Zn, Mg, Si and Na. Zinc and Iron, the most abundant elements in the fly ash were found to be in the oxides. The amorphous nature of the ash had some distinct compounds and minerals, which had Gordaite being formed as one of the major phases as a result of the high temperature oxidation of galvanized steel auto parts. The other phases formed were  $\text{Si}_5\text{O}_{15}$  and Zinc Ferrite. From the analysis, it was found out that Zinc Ferrites compounds were formed from the reaction of iron oxides and zinc oxide at high temperatures. Technologies can be developed for gainful utilization of the fly ash in the manufacture of new products.

Keywords: *Fly ash, X-ray diffraction, Hot Stage Microscopy, Chemical analysis*

#### 1 INTRODUCTION

Fly ash (FA) is a solid waste ( $<630\mu\text{m}$ ) generated in the collection of particulate material during the smelting process in steel industry. During production of steel, considerable amount of different types of solid wastes (blast furnace slag, fly ash, blast furnace flue dust, LD-Slag, coke breeze, tar sludge etc.) are generated. The composition of these waste materials varies widely depending on their source of generation, the quality of raw materials and the metallurgical operations. The main contents of fly ash derived from steel production are oxides of metals such as Fe, Cu, Zn, Mn, and Pb. Globally a million metric tons of fly ash are produced per annum during smelting processing [1].

The wastes (blast furnace slag and fly ash) produced from steel plants in Ghana are generally disposed of by dumping in landfills or used to reinforce the ground in waterlogged areas during construction, which may have environmental repercussions when not managed properly. Currently, environmental legislations and economics force steel industries to minimize generation of wastes and maximize its recycling or utilization in accordance to the Sustainable Development Goals (SDG) 12 (responsible production and consumption). Recycling or utilization of waste is necessary because it affords efficient use of storage space, waste becomes a resource for secondary production thus mitigating the effect of fast depletion of natural resources. Hence recycling and reuse of materials in industrial practice have social, environmental and economic advantages [2]

Recycled steel accounts for about 100% of Ghana's steel production. It is produced by recycling scrap-based steel in an electric arc furnace (EAF). The main by-products in recycled steel production are slag, dusts (fly ash) and sludge. [3]. The high temperature processes give these by-products of unique thermal and mechanical stability which can be exploited as useful raw materials for secondary processes where mechanical strength and thermal stability is desired. Zinc ferrites can be used as pigments because of their high opacity, especially in applications requiring heat stability (above 177°C). When added to high corrosion-resistant coatings, the corrosion protection increases with an increase in the concentration of zinc ferrite [4]

Awareness of the harmful solid waste from the steel making plant has increased over the years in the world and many researchers have discussed the potential reuse treatments of these various wastes including fly ash [5].

The problem of steel FA disposal is only expected to get worse as the demand for steel/metal products grows. FA poses serious problems to the industries and is also considered a hazardous waste due to the probable leaching of potentially toxic substance into the surface water, ground water and soil. Also, the release of fine particles into the atmosphere can cause upper respiratory diseases or occasion allergies. Recycling of FA prevents air, water and soil pollution, saves energy and raw materials and reduce greenhouse gas emissions. [6]. Utilization of FA can result not only in reducing the magnitude of the environmental problems, but be exploited as a raw material (conserve traditional materials) for a secondary production cycle [7].

This paper seeks to analyze the chemical, thermal and morphological characteristics of fly ash from a steel making plant in Ghana, which has its source of raw materials being scrap ferrous metals. These ferrous metals are part of municipal solid waste from automotive servicing garages and other decommissioned equipment which are frequently stored on the bare ground.

## 2 MATERIALS AND METHODS

The steel fly ash used in this experiment was obtained from the bag house unit of the rotary hearth furnace of a Steel Company in Ghana. 500 g of the ash sample was oven dried at 105°C for 12h to remove any moisture after which it was sectioned into smaller quantities and analyzed using X-Ray Diffraction (XRD), Scanning Electron Microscopy (SEM), Hot Stage Microscopy (HSM) and physico-chemical determined.

### 2.1 Particle Size

The particle size distribution was determined with a FRITSCH analysette 3 PRO particle size analyzer. The particle size distribution of fly ash can vary considerably depending on how the smelting plant is operated. However, many smelting plants operate some base load generation, reducing the potential variation of the resulting fly ash [8]. The sieves were arranged with sizes 63 $\mu$ , 90 $\mu$ , 355 $\mu$ , 500 $\mu$  and 630 $\mu$  with smallest mesh size at the bottom. The FA was introduced unto the 630 $\mu$  and shaken for 20 mins. according to ASTM C 136-01.

## 2.2 pH

The pH of the fly ash was determined using a Suntext pH/ meter SP-701. One part of the dry sample was weighed to 2.5ml of water and then stirred continuously for 30mins. The leachate was then tested with the pH meter.

## 2.3 Analysis of Chemical composition of Fly ash

The chemical composition of the FA was determined using WDXRF Axios mAX spectrometer with a 4kW RH lamp and PANalytical software to determine the major constituents and minor constituents in the fly ash.

## 2.4 Electrical Conductivity

The Electrical conductivity was determined using Loviband SensoDtract Con 200. One part of the dry sample was weighed to 2.5 ml of water and then stirred continuously for 30 mins. The leachate was tested with the equipment.

## 2.5 Microscopy

A susceptibility to thermal expansion was investigated on the fly ash taken from the steel smelting plant. Adequate observation of the fly ash sample was examined under a Hot Stage Microscope (HSM) (type 3, Misura) to determine the characteristic temperatures corresponding to the changes of the shape and the cross-sectional area of the samples being heated.

They are based on observing and analyzing images of the fly ash recorded with the growth of its temperature.

## 2.6 X- ray Diffraction

X-ray diffraction (XRD) measurements were conducted using standard powder diffraction procedures. X-ray diffraction pattern of the fly ash was done using (D2 Phaser, 2<sup>nd</sup> Generation) at 30 kV and 10 mA. X-ray diffraction (XRD) measurements were conducted using standard powder diffraction procedures. The FA samples were smear-mounted on a glass slide and analyzed at a scan rate of 4°(2 $\theta$ ) min<sup>-1</sup> using monochromatic Cu K $\alpha$  radiation to determine the crystalline phases and the various mineral and compounds present in the fly ash.

## 2.7 Scanning Electron Microscope (SEM)

SEM is one of the best and most widely used techniques for the chemical and physical characterization of fly ash. It uses a focused electron beam to scan the surface of the sample to generate a variety of signals [9] The morphology of the fly ash was analyzed by scanning electron microscopy (Nova Nano SEM 200; FEI EUROPE Company) equipped by EDS analyze (EDAX).

### 3 Results and Discussion

#### 3.1 Physico Chemical Properties of the Fly ash

##### 3.1.1 Physical features

Generally, the colour of FA can vary from tan to gray to black, depending on its chemical, mineral constituents and other elemental composition. A brownish colour is typically associated with high iron content. The as collected FA was very dark brown in colour. The dark hue of the fly ash could thus be as a result of high iron content or from the different chemical composition [10]. Fly ash was finely-grained upon physical examination but also consisted of traces of coarse particles of different shapes (regular and irregular) and sizes.

##### 3.1.2 Particle Size Distribution

Particle size distribution is probably one of the most important characteristics which influence the activity of fly ash more than any physical properties [11].

The fly ash particle size, shape and distribution play vital roles in determining the physical properties of any composite matrix with it. Figure 1 shows the results of the particle size analysis for fly ash particles for this study. From the graph the median of the particles lies above 400  $\mu\text{m}$ . The lower and higher values of 63 $\mu\text{m}$  and 650 $\mu\text{m}$  had 0.4% and 7.8% of the fly ash particle size respectively. The highest particle size was 500 $\mu\text{m}$  with 86% of the FA ash retained in it. The particle size distribution of fly ash can vary considerably depending on how the smelting plant is operated. However, many smelting plants operate some base load generation at a temperature of 1600°C- 1700°C [5], reducing the potential variation of the resulting fly ash [8]. Generally, literature gives that, the particle size of fly ash up to 45 $\mu\text{m}$  is more suitable as fillers for construction materials. Results from research conducted with FA showed that the addition of FA filler increases the stiffness of a plastic formulation but, like different fillers, their resistance impact is minimized [12]. The particle size distribution of the Fly ash from the recycle steel production plant is depicted in Figure 1.

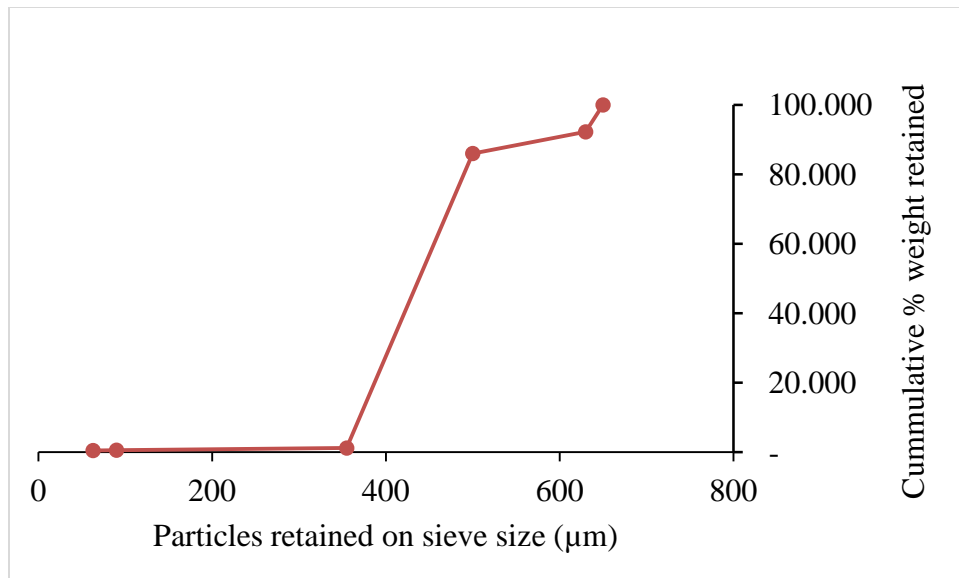


Figure 1 Particle Size Distribution of fly ash indicates the median size of the fly ash of about 440 microns

### 3.1.3 pH

Leaching of trace elements from fly ash in any aqueous medium is one of the important aspects to be considered in environment contamination. Recently fly ash disposal problem has been reviewed by various authors [13]. Ashes may be acidic or alkaline depending on its chemical constituents of its source. The pH was found to be 8.01 which is distinctly alkaline in nature hence the propensity to leach into water is weak.

### 3.1.4 Electrical Conductivity

The electrical conductivity of the fly ash from the steel plant was determined to be 36200 S/m. It is generally inferred that a higher value of electrical conductivity, the lower the resistance to the flow of current in the material. The high conductivity of the FA could be due to the presence of zinc salts which is as a result of electroplating and galvanizing of iron for the production of the steel. Hence, the FA might be useful for fabrications where electrical conductivity is expected to be high. This is because metals (fused in the fly ash) are dry and good conductors of electricity.

### 3.1.5 Chemical Composition of Fly ash

The chemical composition of the FA was determined using WDXRF Axios mAX spectrometer. The analysis of the fly ash as shown in Table 1 indicates the most abundant elements were Fe and Zn with relative abundance to be 21.506% and 40.442% respectively. The high levels of Fe and Zn are as a result of the sources of materials being scrap metals for the production of steel. Also, the high level of the  $\text{Na}_2\text{O}$  can be explained from literature due to the fuels used in the production of steel. Soda ash also known as trona is added to alumina during processing [14].

Table 1 Chemical Composition of the Fly Ash

ANALYTE	COMPOUND FORMULA	CONCENTRATION%
Na	Na <sub>2</sub> O	10.920
Mg	MgO	2.661
Al	Al <sub>2</sub> O <sub>3</sub>	0.632
Si	SiO <sub>2</sub>	4.562
P	P <sub>2</sub> O <sub>5</sub>	0.264
S	SO <sub>3</sub>	3.201
K	K <sub>2</sub> O	2.144
Ca	CaO	2.177
Ti	TiO <sub>2</sub>	0.095
Cr	Cr <sub>2</sub> O <sub>3</sub>	0.554
Mn	MnO	3.171
Fe	Fe <sub>2</sub> O <sub>3</sub>	21.506
Ni	NiO	0.021
Cu	CuO	0.218
Zn	ZnO	40.442
Nb	Nb <sub>2</sub> O <sub>5</sub>	0.245
Cd	CdO	2.317
Sn	SnO <sub>2</sub>	0.201
Ba	BaO	0.131
W	WO <sub>3</sub>	0.184
Pb	PbO	2.077
Bi	Bi <sub>2</sub> O <sub>3</sub>	0.014
F	F	0.289
Cl	Cl	5.349
Br	Br	0.265
I	I	0.056

### 3.2 Morphological characterization of Fly Ash

#### 3.2.1 SEM/ EDX

Extensive microscopic observation of the fly ash shows particles of both regular and irregular shapes. The Fig.2a, b and c show the FA at three different magnification at 10,000x, 5,000x and 20,000x respectively. The backscattering electron images give low gray colour showing darker and lighter regions, which corresponds to areas with lighter and heavier elements from the Periodic Table [15]. Three different shapes of the FA particles were identified to be (1) cuboidal with an average size and standard deviation of  $0.8 \pm 0.4$ , (2) rod-like with an average size and standard deviation of  $1.62 \pm 0.57$  and (3) spherical with an average size and standard deviation of  $1.07 \pm 0.38$ . Fly ash from coal has previously been identified with spherical shape particles [16]. These spherical features were attributed to the presence of certain granular deposits possibly of some iron oxide or even unburnt carbon [11]. The elements that were predominant from the EDS analysis were Pb, Zn, O, Cl, Si, S and Fe. Closer inspection at higher magnification Fig 2c shows three different crystals shapes

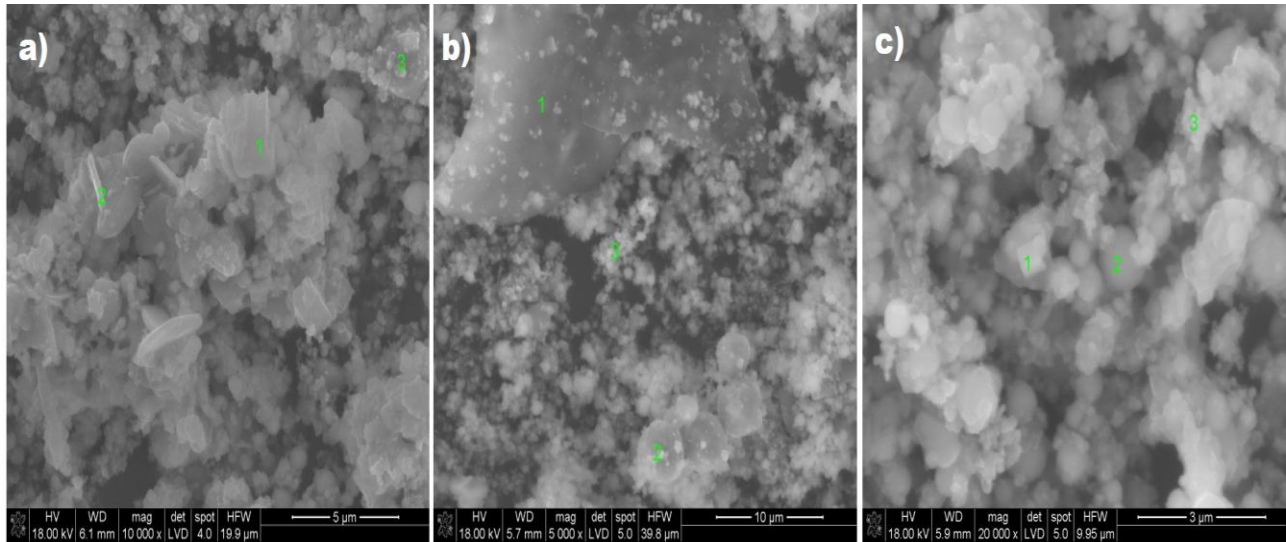


Figure 2 A Scanning Electron Micrograph of the fly ash magnification a) 10,000x, b) 5,000x and c) 20,000x

### 3.2.2 XRD

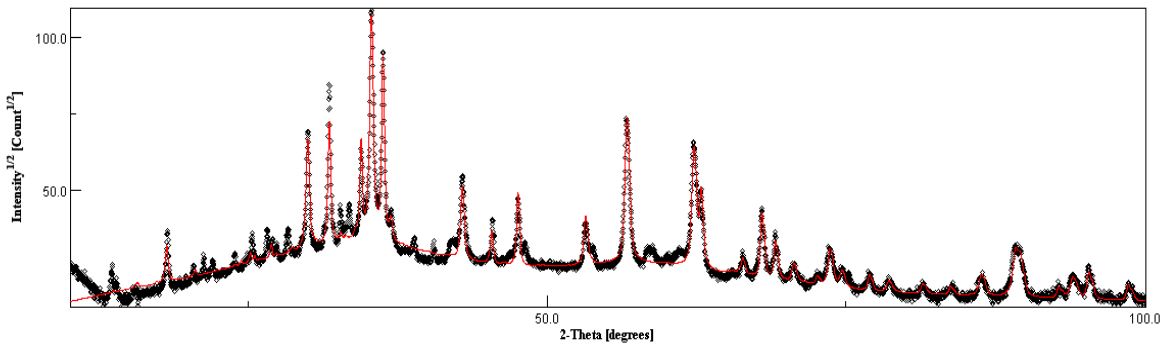


Figure 3 X-ray diffractogram of the fly ash from an Electric arc furnace in Ghana using Materials Analysis Using Diffraction (MAUD)

The results from the XRD analysis gives information of the compounds that were possibly formed during combustion. The black peaks are in reference to the red peaks from MAUD. It can also be seen from the image that the fly ash had an amorphous nature with some distinct compounds and minerals. The compounds formed are listed in Table 2. The phase with the highest fraction by both weight (72.2%) and volume (81.6%) is Gordaite. The crystallite size of

the Gordaite as calculated from the XRD using the Scherrer's equation was 425.94 nm. The chemical composition of Gordaite comprises of elements such as zinc, sodium and Sulphur and the chemical formula is  $\text{NaZn}_4(\text{SO}_4)(\text{OH})_6\text{Cl}\cdot 6\text{H}_2\text{O}$ . This mineral occurs naturally in oxidized deposits of Cu-Zn sulphide which is found in the mines of San-Francisco and Chile [17]. It was produced during the high temperature oxidation of galvanized steel auto parts and Cu contaminants from alloys in the scrap ferrous raw materials. The second highest phase by weight is Zinc Ferrite 18.2%. Zinc ferrites are a series of synthetic inorganic compounds of zinc and iron (ferrite) with the general formula of  $\text{Zn}_x\text{Fe}_{3-x}\text{O}_4$ . The chemical composition is  $\text{Fe}_{1.78}\text{O}_{3.71}\text{Zn}_{0.945}$ . Zinc ferrite compound are formed through the reaction of iron oxide and zinc oxide at high temperatures ranging between  $920^\circ\text{C} - 960^\circ\text{C}$  [18].

The compounds  $\text{ZnO}$ ,  $\text{Fe}_2\text{MgO}_4$ ,  $\text{SiO}_2$  and  $\text{Fe}_2\text{SiO}$  confirms the presence of the elements found in the SEM results of the fly ash sample of which Zn and Fe were in higher percentages of 46.4% and 38.6% respectively.

Table 2 Mineralogical composition of the FA from XRD

Phase	Gordaite	$\text{Si}_5\text{O}_{15}$	Zinc Ferrite	$\text{Fe}_3\text{Si}$	Disodium Oxide	Antimony
Wt Fraction	0.722	0.001	0.182	0.005	0.002	$9.61 \times 10^{-4}$

### 3.2.3 Hot Stage Microscopy (HSM) analysis of fly ash

HSM has found its applicability to studying various raw materials and products as well as to solving some technological problems such as finding the characteristic temperature corresponding to the changes of the shape in the ceramic, glass and energy industries as well as in metallurgy and foundry engineering [19]. It affords a combination of microscopy and thermal analysis to enable the study of the material as a function of temperature and time. Figure 4 shows the result of the Hot Stage Microscopy of the FA. The sintering process of the steel FA was investigated in order to have information with regards to the melting point and other transformations which occur during heating. When conducting investigations of raw materials, their susceptibility to expansion on heating is often expressed as the changes of the coefficient of thermal expansion (S). The coefficient is calculated on the basis of the cross-section area changes of the solid body that is an equivalent of the sample volume at the given temperature [20]. The plot of the graph is characterized by a long plateau. The contraction around  $890^\circ\text{C} - 900^\circ\text{C}$  (Fig.4) may have been as a result of sintering or collapsing of a lattice structure. Expansion may also be as a result of formation of new lattice structure from the formation of new crystals during the heating process. The melting process starts at the end of the plateau with a gradual drop in the sintering percentage. After the shrinkage stage, the curve starts to show a gradual expansion around  $1200^\circ\text{C}$ . There is a short plateau after which the expansion increases due to the formation of Zincite and MagnesioFerrite in the Fly Ash which has melting points of  $1977^\circ\text{C}$  and  $1750^\circ\text{C}$  respectively.



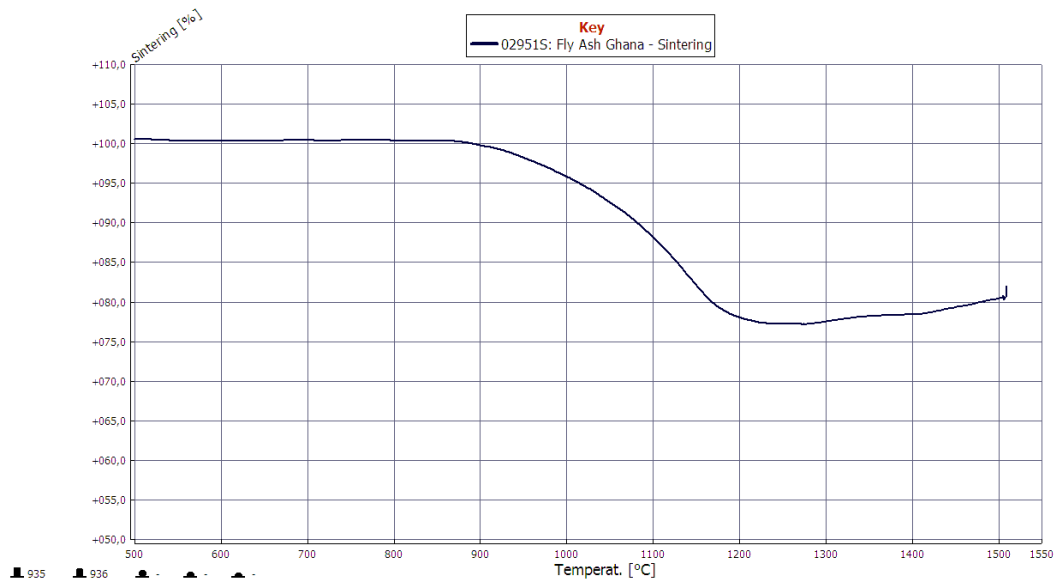


Figure 4 HSM of the Fly Ash

#### 4 CONCLUSIONS

The FA from typical scrap ferrous metal smelting using a rotary hearth furnace has high carbon content, alkaline pH and high electrical conductivity. The FA particles gives shapes which are predominantly spherical, some rod-like and cuboidal with irregular particle size. The average particle size comprised mainly of Zn, Fe, Si, Na and Mg with other elements in the minority. The particle size was less than 630um and XRD confirmed the presence that ZincFerrites compounds were formed from the reaction of iron oxides and zinc oxide at high temperatures. The HSM showed the FA sintering at 890°C-900°C showing a possible formation of new lattice or expansion of the ash. Technologies can be developed for gainful utilization of the fly ash in the manufacture of new products in the construction industry and also in the extraction of Zn from the FA.

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