

CONTENTS

<table style="width: 100%; border-collapse: collapse;"> <tr> <td>FOREWORD</td> <td style="text-align: right;">xi</td> </tr> <tr> <td>PREFACE</td> <td style="text-align: right;">xiii</td> </tr> <tr> <td>1 Introduction</td> <td style="text-align: right;">1</td> </tr> <tr> <td> Nomenclature</td> <td style="text-align: right;">1</td> </tr> <tr> <td> 1.1. General Principles of MHD Power Generation</td> <td style="text-align: right;">1</td> </tr> <tr> <td> 1.2. Possible MHD Cycles</td> <td style="text-align: right;">3</td> </tr> <tr> <td> 1.2.1. Open-cycle System</td> <td style="text-align: right;">4</td> </tr> <tr> <td> 1.2.2. Closed-cycle System</td> <td style="text-align: right;">7</td> </tr> <tr> <td> 1.2.3. Liquid-metal Cycles</td> <td style="text-align: right;">9</td> </tr> <tr> <td> 1.3. Factors Leading to the Proposed Cycle</td> <td style="text-align: right;">10</td> </tr> <tr> <td> References</td> <td style="text-align: right;">17</td> </tr> <tr> <td>2 Directly Fired Air Heaters</td> <td style="text-align: right;">18</td> </tr> <tr> <td> Nomenclature</td> <td style="text-align: right;">18</td> </tr> <tr> <td> Types of Air Heater</td> <td style="text-align: right;">19</td> </tr> <tr> <td> 2.1. Checker Brick Regenerator</td> <td style="text-align: right;">28</td> </tr> <tr> <td> 2.1.1. Design of Regenerator</td> <td style="text-align: right;">29</td> </tr> <tr> <td> 2.1.2. Switchover Valves</td> <td style="text-align: right;">37</td> </tr> <tr> <td> 2.1.3. High-temperature Ducts</td> <td style="text-align: right;">41</td> </tr> <tr> <td> 2.1.4. Cost Estimates of the Checker Brick Regenerator</td> <td style="text-align: right;">44</td> </tr> <tr> <td> 2.2. Liquid Slag Regenerator</td> <td style="text-align: right;">44</td> </tr> <tr> <td> 2.2.1. Flow and Physical Properties of Potassium Sulphate and Coal Ash</td> <td style="text-align: right;">46</td> </tr> <tr> <td> 2.2.2. Atomization of Slag</td> <td style="text-align: right;">54</td> </tr> <tr> <td> 2.2.3. Transportation of Liquid Slag</td> <td style="text-align: right;">73</td> </tr> <tr> <td> 2.2.4. Heat and Mass Transfer in the Heat Exchange Chambers</td> <td style="text-align: right;">89</td> </tr> <tr> <td> 2.2.5. Aerodynamics of Heat Exchangers</td> <td style="text-align: right;">100</td> </tr> <tr> <td> 2.2.6. Transfer of Granular Particles from Air-heating to Slag-heating Chamber</td> <td style="text-align: right;">109</td> </tr> <tr> <td> 2.2.7. Layout and Cost of Liquid-slag Regenerator</td> <td style="text-align: right;">111</td> </tr> <tr> <td> 2.3. Miscellaneous Air Heaters</td> <td style="text-align: right;">120</td> </tr> <tr> <td> 2.3.1. Chemical Regeneration of Enthalpy</td> <td style="text-align: right;">120</td> </tr> <tr> <td> 2.3.2. Moving Fluidized Bed Regenerator</td> <td style="text-align: right;">129</td> </tr> <tr> <td> 2.4. Materials for Directly Fired Air Heaters</td> <td style="text-align: right;">131</td> </tr> <tr> <td> 2.4.1. Corrosion</td> <td style="text-align: right;">132</td> </tr> <tr> <td> 2.4.2. Mechanical Properties</td> <td style="text-align: right;">141</td> </tr> <tr> <td> 2.4.3. Seed Penetration</td> <td style="text-align: right;">154</td> </tr> <tr> <td> 2.4.4. Valves for Directly Fired Air Heaters</td> <td style="text-align: right;">156</td> </tr> <tr> <td> 2.4.5. Metals for Air-heater Construction</td> <td style="text-align: right;">157</td> </tr> <tr> <td> References</td> <td style="text-align: right;">158</td> </tr> <tr> <td>3 Separately Fired Air Heaters</td> <td style="text-align: right;">162</td> </tr> <tr> <td> Nomenclature</td> <td style="text-align: right;">162</td> </tr> <tr> <td> Introduction</td> <td style="text-align: right;">163</td> </tr> <tr> <td> 3.1. Ceramic Recuperator</td> <td style="text-align: right;">164</td> </tr> <tr> <td> 3.1.1. Tube Matrix Design</td> <td style="text-align: right;">164</td> </tr> <tr> <td> 3.1.2. Ceramic Tube Joints</td> <td style="text-align: right;">176</td> </tr> </table>	FOREWORD	xi	PREFACE	xiii	1 Introduction	1	Nomenclature	1	1.1. General Principles of MHD Power Generation	1	1.2. Possible MHD Cycles	3	1.2.1. Open-cycle System	4	1.2.2. Closed-cycle System	7	1.2.3. Liquid-metal Cycles	9	1.3. Factors Leading to the Proposed Cycle	10	References	17	2 Directly Fired Air Heaters	18	Nomenclature	18	Types of Air Heater	19	2.1. Checker Brick Regenerator	28	2.1.1. Design of Regenerator	29	2.1.2. Switchover Valves	37	2.1.3. High-temperature Ducts	41	2.1.4. Cost Estimates of the Checker Brick Regenerator	44	2.2. Liquid Slag Regenerator	44	2.2.1. Flow and Physical Properties of Potassium Sulphate and Coal Ash	46	2.2.2. Atomization of Slag	54	2.2.3. Transportation of Liquid Slag	73	2.2.4. Heat and Mass Transfer in the Heat Exchange Chambers	89	2.2.5. Aerodynamics of Heat Exchangers	100	2.2.6. Transfer of Granular Particles from Air-heating to Slag-heating Chamber	109	2.2.7. Layout and Cost of Liquid-slag Regenerator	111	2.3. Miscellaneous Air Heaters	120	2.3.1. Chemical Regeneration of Enthalpy	120	2.3.2. Moving Fluidized Bed Regenerator	129	2.4. Materials for Directly Fired Air Heaters	131	2.4.1. Corrosion	132	2.4.2. Mechanical Properties	141	2.4.3. Seed Penetration	154	2.4.4. Valves for Directly Fired Air Heaters	156	2.4.5. Metals for Air-heater Construction	157	References	158	3 Separately Fired Air Heaters	162	Nomenclature	162	Introduction	163	3.1. Ceramic Recuperator	164	3.1.1. Tube Matrix Design	164	3.1.2. Ceramic Tube Joints	176	xi xiii 1 1 3 4 7 9 10 17 18 18 19 28 29 37 41 44 44 46 54 73 89 100 109 111 120 120 129 131 132 141 154 156 157 158 162 162 163 164 164 176
FOREWORD	xi																																																																																						
PREFACE	xiii																																																																																						
1 Introduction	1																																																																																						
Nomenclature	1																																																																																						
1.1. General Principles of MHD Power Generation	1																																																																																						
1.2. Possible MHD Cycles	3																																																																																						
1.2.1. Open-cycle System	4																																																																																						
1.2.2. Closed-cycle System	7																																																																																						
1.2.3. Liquid-metal Cycles	9																																																																																						
1.3. Factors Leading to the Proposed Cycle	10																																																																																						
References	17																																																																																						
2 Directly Fired Air Heaters	18																																																																																						
Nomenclature	18																																																																																						
Types of Air Heater	19																																																																																						
2.1. Checker Brick Regenerator	28																																																																																						
2.1.1. Design of Regenerator	29																																																																																						
2.1.2. Switchover Valves	37																																																																																						
2.1.3. High-temperature Ducts	41																																																																																						
2.1.4. Cost Estimates of the Checker Brick Regenerator	44																																																																																						
2.2. Liquid Slag Regenerator	44																																																																																						
2.2.1. Flow and Physical Properties of Potassium Sulphate and Coal Ash	46																																																																																						
2.2.2. Atomization of Slag	54																																																																																						
2.2.3. Transportation of Liquid Slag	73																																																																																						
2.2.4. Heat and Mass Transfer in the Heat Exchange Chambers	89																																																																																						
2.2.5. Aerodynamics of Heat Exchangers	100																																																																																						
2.2.6. Transfer of Granular Particles from Air-heating to Slag-heating Chamber	109																																																																																						
2.2.7. Layout and Cost of Liquid-slag Regenerator	111																																																																																						
2.3. Miscellaneous Air Heaters	120																																																																																						
2.3.1. Chemical Regeneration of Enthalpy	120																																																																																						
2.3.2. Moving Fluidized Bed Regenerator	129																																																																																						
2.4. Materials for Directly Fired Air Heaters	131																																																																																						
2.4.1. Corrosion	132																																																																																						
2.4.2. Mechanical Properties	141																																																																																						
2.4.3. Seed Penetration	154																																																																																						
2.4.4. Valves for Directly Fired Air Heaters	156																																																																																						
2.4.5. Metals for Air-heater Construction	157																																																																																						
References	158																																																																																						
3 Separately Fired Air Heaters	162																																																																																						
Nomenclature	162																																																																																						
Introduction	163																																																																																						
3.1. Ceramic Recuperator	164																																																																																						
3.1.1. Tube Matrix Design	164																																																																																						
3.1.2. Ceramic Tube Joints	176																																																																																						

3.1.3. Vibration of Tubes in a Tubular Counterflow Ceramic Recuperator	172
3.1.4. Recuperative Air-heater System Layout and Operation	183
3.1.5. Cost Estimates	184
3.2. Rotary Regenerator	184
3.2.1. Matrix Design	185
3.2.2. Matrix Dimensions	189
3.2.3. Design of Rotary Regenerator	190
3.2.4. Air-heating Scheme and Cost Estimates of the Rotary Regenerator	193
3.3. Falling Cloud Regenerator	194
3.3.1. Heat Transfer Material	194
3.3.2. Heat-exchanger Configuration	196
3.3.3. Chamber Dimensions	200
3.3.4. Method of Conveying Particles between Heat-exchanger Vessels	206
3.3.5. Construction Details and Cost Estimate	209
3.4. Stationary Matrix Regenerator	212
3.4.1. General Description of Plant	214
3.4.2. Aerodynamic Modelling of Heat-exchanger Assembly	221
3.4.3. Matrix Optimization—Test Facility	227
3.4.4. Switchover Valves	231
3.4.5. High-temperature Ducting	236
3.4.6. Cost Estimates of the Stationary Matrix Pebble Bed Regenerator	240
3.5. Separately Fired Air-heater Construction Materials	241
3.5.1. Corrosion	241
3.5.2. Mechanical Properties	249
3.5.3. Valves for Separately Fired Air Heaters	255
3.5.4. Materials for Combustion Chambers for Separately Fired Air Heaters	255
3.5.5. Heat Transfer Properties of Refractory Materials	256
3.6. Conclusion	258
References	258
4 Combustion	261
Nomenclature	261
4.1. Coal Combustion	262
4.1.1. Introduction	262
4.1.2. Pilot-scale Combustors	268
4.1.3. Test Equipment	272
4.1.4. Slag-flow Behaviour	276
4.1.5. Volatilization of Mineral Matter	280
4.1.6. Heat Transfer to the Walls of the Pilot-scale Combustors	284
4.1.7. Electrical Conductivity of the Gases in the Pilot-scale Combustors	290
4.1.8. The Space Needed to Burn the Coal	293
4.1.9. Layout and Estimated Performance of a "60 MW" Combustor	304
4.2. Oil Combustion—Fundamental Studies	308
4.2.1. Introduction	308
4.2.2. Experimental Plant	310
4.2.3. Development of Air–Fuel Mixer	324
4.2.4. Measurement of Flame Temperature	333
4.2.5. Measurement of Gas Electrical Conductivity	344
4.2.6. Heat Fluxes and Combustion Intensity Using a Plug Flow Combustion Chamber	350

4.2.7. Heat Fluxes and Combustion Intensity Using a Well-stirred Combustion Chamber	355
4.3. Large-scale Combustors	374
4.3.1. Reduction of Heat Transferred to the Chamber Walls	374
4.3.2. Design of the 2000 MW (T) Combustion Chamber	389
References	391
5 Duct Physics	393
Nomenclature	393
5.1. Physical Principles and One-dimensional Equations	395
5.2. Gas Properties	397
5.2.1. Thermodynamic Properties of Combustion Gases	397
5.2.2. Electrical Properties of Combustion Gases	403
5.3. Types of Generator and Loading Parameters	405
5.4. Heat Transfer and Friction Effects	407
5.5. Performance of Power Station MHD Ducts	416
5.5.1. Assumptions and Boundary Conditions	416
5.5.2. Methods of Analysis	419
5.5.3. Parameter Values for Duct Calculations	421
5.5.4. Design of a Segmented Electrode Faraday Generator	422
5.5.5. Optimum Design of a Single-load, Cross-connected Generator	425
5.5.6. Practical Single-load Generator Designs	429
5.6. Effects due to Finite Segmentation and Non-uniformities	433
5.6.1. Finite Segmentation: Basic Equations	434
5.6.2. Evaluation of the Coefficients	436
5.6.3. Numerical Methods	437
5.6.4. Conformal Mapping	437
5.6.5. Leakage Currents	442
5.6.6. Current and Voltage Distributions on the Wall	443
5.6.7. End Effects and Non-uniformities	444
5.6.8. The Effect of Swirl	449
5.6.9. Application of Results	449
5.7. Instabilities	450
5.7.1. Introduction	450
5.7.2. Outline of the Theory	451
5.7.3. Two-dimensional Instabilities	453
5.7.4. Absolute Instabilities in Two Dimensions	454
5.7.5. Conclusions	456
5.8. Some Supersonic Flow Problems	456
5.8.1. Characteristics of a Supersonic MHD Duct	456
5.8.2. Shock Electrodynamics	458
5.8.3. Boundary-layer Behaviour	460
References	462
6 MHD Test Facilities and Diagnostics	463
Nomenclature	463
6.1. Survey of Rigs Used for Multi-purpose Tests	467
6.1.1. The English Electric and International Research and Development Companies' Low-power Rigs	467
6.1.2. The Associated Electrical Industries' and Central Electricity Research Laboratories' Medium-power Rigs	469
6.1.3. Central Electricity Research Laboratories' Long-duration Rig	471

viii	<i>Contents</i>	ix		
6.2.	Large Oxygen-fired MHD Rigs 6.2.1. Factors Influencing the Design 6.2.2. Design of the 200 MW Subsonic Cross-connected Generator 6.2.3. Design for a 100 MW Supersonic Hall Generator	473 476 482	8.3.2. Cost Comparison 8.3.3. Iron	616 617
6.3.	Diagnostics 6.3.1. Sodium D-line Temperature Measurement 6.3.2. Conductivity Measurement 6.3.3. c^* Measurement	486 487 491 494	8.4. The Use of Superconductors 8.4.1. General Considerations 8.4.2. Stabilization by Parallel Normal Conductor 8.4.3. Protection	618 619 623
	References	497	8.5. Superconducting MHD Generator Magnets 8.6. Assessment of Superconducting Magnets	627 634
	7 Electrodes and Insulators	499	References	637
	Nomenclature	499		
7.1.	Introduction	499		
7.2.	Metal Electrodes 7.2.1. Introduction 7.2.2. Erosion of Transverse Tubular Electrodes 7.2.3. Erosion of Planar Copper 7.2.4. Erosion of Other Electrode Materials 7.2.5. Supporting Theoretical Work 7.2.6. Electrode Capability under Generation Operating Conditions 7.2.7. Assessment of Metal Electrodes	506 506 507 510 514 520 524 531	9. Nomenclature 9.1. Introduction 9.2. Impurities in Recycled Seed 9.2.1. Build-up of Condensable Impurities 9.2.2. Impurities from the Fuel 9.2.3. Impurities from Plant Surfaces 9.2.4. The Composition of Recovered Seed 9.2.5. The Effect of Partial Purification of Recovered Seed 9.2.6. Phase Separation in Molten Steady-state Seed 9.2.7. "Steady-state Seed" Composition for Use in Experiments with Seed	638 638 639 640 640 641 642 642 643 643 645
7.3.	Ceramic Electrodes 7.3.1. General Survey 7.3.2. Conduction Mechanisms in Zirconia Electrodes 7.3.3. Electrode Design Problems 7.3.4. Electrode Tests Using Ceramic Blocks 7.3.5. Brush and Mesh Electrodes 7.3.6. Ceramic Insert Electrodes 7.3.7. Electrode Replenishment 7.3.8. Lanthanum Chromite as an Electrode Material 7.3.9. Assessment of Ceramic Electrodes	532 532 539 548 550 554 558 566 568 570	9.3. The Evaporation of Seed Particles 9.3.1. Enthalpy Required for Seeding 9.3.2. Theoretical Calculation of the Evaporation Rate of Potassium Sulphate 9.3.3. Shock Wave Heating of Seed Particles 9.3.4. Measurement of the Diffusion Coefficient of Potassium Sulphate through Nitrogen 9.3.5. Spectroscopic Observation of the Evaporation and Decomposition of Potassium Sulphate in Flames 9.3.6. Evaporation of Captive Drops of Potassium Sulphate	645 645 645 647 650 652 654 656
7.4.	Some Fundamental Erosion Experiments 7.4.1. Erosion in Pure Gases 7.4.2. Electrolytic Attack on Metals 7.4.3. Electrolytic Erosion of Some Ceramics	571 575 583	9.4. The Chemical Behaviour of Potassium Seed in a MHD System 9.4.1. Theoretical Basis of the Calculations 9.4.2. Sources of Data 9.4.3. Fuel Composition and Seeding Levels 9.4.4. The Behaviour of Potassium 9.4.5. Behaviour of Nitrogen	658 659 660 662 663 667
7.5.	Protected Electrodes 7.5.1. Arc Electrodes 7.5.2. Quenched Arc Electrodes	586 586 590	9.5. Seed Condensation Temperatures 9.5.1. Vapour Pressure Measurements by the Effusion Technique 9.5.2. The Mass Spectroscopic Examination of K_2SO_4 Vapour 9.5.3. The Vapour Pressure of K_2SO_4 by the Transpiration or Flow Technique 9.5.4. The Effect of CO_2 and H_2O on the Evaporation of K_2SO_4 9.5.5. Practical Condensation Temperatures	668 669 672 672 674 674
7.6.	Insulators 7.6.1. Requirements 7.6.2. Materials Properties 7.6.3. Designs 7.6.4. Tests on Individual Insulators	597 597 598 600 601	9.6. The Chemistry of Seed Deposits on Heat Exchange Surfaces 9.6.1. The Nature of the Deposit 9.6.2. Experimental Procedure 9.6.3. The $K_2SO_4-SO_3$ System 9.6.4. Effect of Adding V_2O_5 to the $K_2SO_4-SO_3$ System	676 676 677 678 679
	References	603	9.7. The Handling of Potassium in a Coal-fired System 9.7.1. Outline of the Problems 9.7.2. The Absorption of Potassium by Coal-ash Slag 9.7.3. Miscibility of Potassium Sulphate-Silicate System	680 680 680 683
	8 Magnets	606		
	Nomenclature	606		
8.1.	Magnetic Field Configuration Required	607		
8.2.	Electromagnetic Calculations 8.2.1. Fields, Forces and Stored Energy in Iron-free Coils 8.2.2. Effects with Iron	610 610 613		
8.3.	Choice of Materials 8.3.1. Possible Conductors	614 614		

Contents

9.8. The Rate of Deposition of Potassium Sulphate	685
9.8.1. The Rate of Condensation of Potassium Sulphate Vapour from Unsaturated Flue Gas	686
9.8.2. The Transport of Fume across the Boundary Layer and the Effect of Deposits on Heat Transfer	690
9.8.3. Combined Thermal Precipitation and Vapour Diffusion	696
9.8.4. Deposition of Seed in a Large Boiler	701
9.9. The Collection of Seed Fume from Exhaust Gases	701
9.9.1. Electrostatic Precipitation	702
9.9.2. The Nature of the Seed Collected in the Precipitator	703
9.9.3. Electrical Conditions	704
9.9.4. Dust Deposits on Electrodes	704
9.9.5. Collection Efficiency in Electrostatic Precipitators	705
9.9.6. The Effect of Rapping on Collection Efficiency	707
9.9.7. Comparison of Pilot and Full-scale Precipitators	707
9.9.8. Costs of Electrostatic Precipitators	710
9.9.9. Bag filters	711
9.10 The Purification of MHD Seed	712
References	714
10 Steam Plant Equipment	716
10.1. Boiler Metals	716
10.1.1. Modified Seed Composition	720
10.1.2. Interpretation of Corrosion Results above 700°K	720
10.1.3. Metals for Use below 700°K	721
10.1.4. Present Conclusions on Metals in Seed-contaminated Boiler Plant	721
10.2. Design of Steam Cycle Equipment for a 2000 MW (T) Plant	722
10.2.1. Comparison with Conventional Oil-fired Conditions	722
10.2.2. Proposed Steam Cycle	723
10.2.3. General Design Features	725
10.2.4. Relationships between the Steam Plant and Other Components	727
10.2.5. Steam Plant Components	728
References	751
11 Cycle Analysis and Appraisal	752
Nomenclature	752
11.1. Cycle Efficiency Calculations	753
11.1.1. Summary of Boundary Conditions	753
11.1.2. Analysis of a Directly Fired Air-heater Cycle	759
11.1.3. Analysis of Separately Fired Air-heater Cycles	761
11.1.4. Effect of Parameter Variation: All Low-grade Heat Absorbed	763
11.1.5. Effect of Parameter Variation: Excess Low-grade Heat Rejected	770
11.1.6. Integration of MHD with Existing Power Stations: a Method that Increases the Effective MHD Efficiency	773
11.1.7. Oxygen Enrichment	778
11.2. Economic Assessment	780
References	784
AUTHOR INDEX	785
SUBJECT INDEX	787