

# 10,000 h of Chemical-Looping Combustion Operation –

## Where Are We and Where Do We Want to Go?

Anders Lyngfelt<sup>1\*</sup>, Anders Brink<sup>2</sup>, Øyvind Langørgen<sup>3</sup>, Tobias Mattisson<sup>1</sup>, Magnus Rydén<sup>1</sup> And Carl Linderholm<sup>1</sup>

<sup>1</sup> *Dept of Space, Earth and Environment, Div. Energy Technology,  
Chalmers University of Technology, S-412 96 Göteborg, Sweden*

<sup>2</sup> *Åbo Akademi, Process Chemistry Center (CMC), Tuomiokirkontori 3, 20500 Turku, Finland*

<sup>3</sup> *SINTEF Energy Research, NO-7465 Trondheim, Norway*

*\*Corresponding Author, Anders.Lyngfelt@chalmers.se*

### Abstract

A key for chemical-looping combustion (CLC) is the oxygen carrier. The ultimate test is obviously the actual operation, which reveals if turns to dust, agglomerates or loses its reactivity or oxygen carrier capacity. The CLC process has been operated in 46 smaller chemical-looping combustors, for a total of more than 11,000 h. The operation involves both manufactured oxygen carriers, with 70% of the total time of operation, and less costly materials, i.e. natural ores or waste materials. Among manufactured materials, the most popular materials are based on NiO with 29% of the operational time, Fe<sub>2</sub>O<sub>3</sub> with 16% and CuO with 13%. Among the monometallic oxides there are also Mn<sub>3</sub>O<sub>4</sub> with 1%, and CoO with 2%. The manufactured materials also include a number of combined oxides with 11% of operation, mostly calcium manganites and other combined manganese oxides. Finally, the natural ores and waste materials include ilmenite, FeTiO<sub>3</sub> with 13%, iron ore/waste with 9% and manganese ore with 6%. In the last years a shift towards more focus on CuO, combined oxides and natural ores has been seen.

The operational experience shows a large variation in performance depending on pilot design, operational conditions, solids inventory, oxygen carrier and fuel. However, there is at present no experience of the process at commercial or semi-commercial scale, although oxygen-carrier materials have been successfully used in commercial fluidized-bed boilers for Oxygen-Carrier Aided Combustion (OCAC) during more than 12,000 h of operation.

The paper discusses strategies for upscaling as well as the use of biomass for negative emissions. A key question is how scaling-up will affect the performance, which again will determine the costs for purification of CO<sub>2</sub> through e.g. oxy-polishing. Unfortunately, the conditions in the small-scale pilots do not allow for any safe conclusions with respect to performance in full scale. Nevertheless, the experiences from pilot operation shows that the process works and can be expected to work in the large scale and gives important information, for instance on the usefulness of various oxygen-carriers. Because further research is not likely to improve our understanding of the performance that can be achieved in full scale, there is little sense in waiting with the scale-up.

A major difficulty with the scaling-up of a novel process is in the risk. First-of-its-kind large-scale projects include risks of technical mistakes and unforeseen obstacles, leading to added costs or, in the worst case, failure. One way of addressing these risks is to focus on the heart of the process and build it with maximum flexibility for future use. A concept for maximum flexibility is the Multipurpose Dual Fluidized Bed (MDFB). Another is to find a suitable existing plant, e.g. a dual fluidized-bed thermal gasifier.

With present emissions the global CO<sub>2</sub> budget associated with a maximum temperature of 2°C may be spent in around 20-25 years, whereas the CO<sub>2</sub> budget for 1.5°C is may be exhausted in 10 years. Thus, the need for both CO<sub>2</sub> neutral fuels and negative emissions will become increasingly urgent as we are nearing or transgressing the maximum amount of CO<sub>2</sub> that can be emitted without compromising the global climate agreement in Paris saying we must keep “well below” 2°C and aim for a maximum of 1.5°C. Thus, biomass may turn out to be a key fuel for Carbon Capture and Storage (CCS), because CO<sub>2</sub>-free power does not necessarily need CCS, but negative emissions will definitely need Bio-CCS.

## 1 Introduction

### 1.1 Previous reviews on chemical-looping

The purpose of this paper is not to reiterate previous review papers concerning chemical-looping combustion (CLC), with detailed descriptions of basic concepts. However, for readers not acquainted with these concepts a number of previous reviews can be recommended.

Among the most comprehensive reviews of chemical-looping is a paper by Adánez et al. [1] and a book edited by Fennel and Anthony, [2], containing chapters on fundamentals and reactor design, oxygen carriers, gaseous fuels, liquid fuels, solid fuels and hydrogen production. Additional reviews on chemical-looping combustion can be found in [3],[4], [5],[6],[7].

There are a number of reviews with more focus on oxygen carriers, e.g. [8],[9]. An overview of laboratory examinations, [10], includes 600 oxygen-carrier materials and an update of this study includes another 300 materials, [11]. Material overviews can also be found in PhD theses, e.g. [12-15].

Reviews with focus on chemical-looping combustion of solid fuels are found in, [16], [17], [18], [19], [20], [21].

There are also papers showing the design of existing chemical-looping combustors and the results from operation of these using various oxygen-carrier materials e.g. [22], [1],[23].

Further, there are reviews with more focus on process concepts, [24], including one book on chemical-looping systems [25].

An important aspect of oxygen carriers is the thermodynamic properties, [26], these have also been examined for the more complex combined manganese materials, [27]. These materials have the ability to release oxygen to the gas phase, albeit to varying extent. This variety of the chemical-looping reaction mechanism is commonly referred to as CLOU or Chemical-

Looping with Oxygen Uncoupling, and was first proposed by Mattisson et al., [28], and has later been reviewed [29], [30].

The mechanical integrity is an important property. In two papers with very similar approach, lifetime of oxygen carrier particles derived from actual operation, has been compared to data from attrition testing and crushing testing, [31], [32]. The main conclusion from these papers is the same: Although attrition testing and crushing testing may provide a reasonable idea on which materials to exclude from further testing, the results from these tests are not very well correlated to actual performance. Thus, to show the usefulness of a material there seems to be no other way than prolonged operation in an actual chemical-looping combustor.

This paper will focus on the operational experiences with oxygen carriers and also discuss the future development of CLC technology.

## 1.2 Principal definition and subdivisions of chemical-looping combustion

In this work, chemical-looping or chemical-looping combustion is used solely in connection with processes that transfer oxygen in connection with fuel conversion at high temperatures, which is in accordance with convention. Chemical-looping combustion can be used for both gaseous, liquid and solid fuels, Fig. 1. The definition used here is based on the state of the fuel entering the chemical-looping process. Thus, gas from gasification belongs with Gas-CLC, as long as the gasification step is external to the actual CLC process.

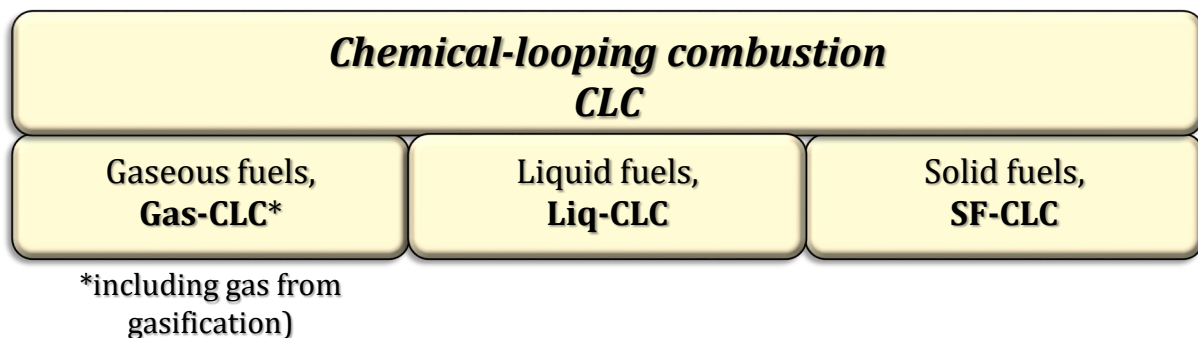


Figure 1. Subdivision of chemical-looping combustion related to fuel.

The reaction mechanism for oxidation of fuel in the fuel reactor could proceed either via heterogeneous reactions, i.e. combustible gases reacting with the oxygen carrier particles, hence called heterogeneous CLC, or by release of oxygen from the oxygen carrier to the gas phase that subsequently reacts with the gaseous, liquid or solid fuel, i.e. Chemical-Looping with Oxygen Uncoupling. Both reaction mechanisms may also happen in parallel, Fig. 2.

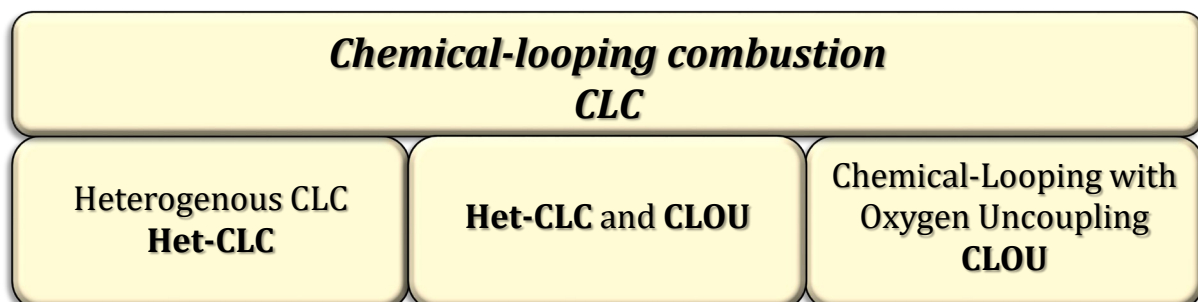


Figure 2. Different reaction mechanisms in the fuel reactor.

Here, CLOU is seen as a possible mechanism of CLC that may improve the conversion of gaseous, liquid and solid fuel. For oxygen carriers with CLOU properties, it is in practice difficult to distinguish between the two mechanisms, so the existence of a pure CLOU mechanism would be difficult to be verify, except for a fuel with absolutely no volatiles. Even if a CLOU material is able to release its oxygen rapidly, can we be sure no heterogeneous reactions take place locally in high concentrations of volatiles or gaseous fuel? Also, the distinction between heterogeneous CLC and mixed CLOU/Het-CLC may not be so clear at times. Thus, a number of materials, normally considered to be non-CLOU materials, have shown minor releases of oxygen. One example is ilmenite, [33].

In conclusion, it is recommended that CLOU is not seen as a different process, but rather as a reaction mechanism that may take place in parallel with heterogeneous CLC. The fraction of each mechanism may be difficult to establish and will be dependent on the fuel, the temperature, the oxygen carrier as well as reactor design and other operational conditions.

Often iG-CLC (in-situ Gasification CLC), is used with the same meaning as SF-CLC, but other times it is used to indicate chemical-looping of solid fuels in a process where no CLOU takes place, i.e. Het-CLC. The name in-situ Gasification CLC could be confusing, as it gives associations to gasification processes, although it is a combustion process where the gasification is not a process step, but rather a mechanism. Further, iG-CLC should not be confused with Integrated Gasification Chemical-Looping Combustion (IGCLC). Therefore, iG-CLC is not used as a term in this paper.

Finally, chemical looping combustion can be divided between different purposes, i.e. energy production and fuel production, Fig. 3. The latter case may involve partial combustion/oxidation, for instance Autothermal Chemical-Looping Reforming, CLR-A, where gaseous or liquid hydrocarbons are partially oxidized to produce a syngas, or Chemical-Looping Gasification, CLG, where solid fuel is converted to combustible gases. Finally, full oxidation CLC may be combined with conventional steam reforming, by using the off-gas from the reforming process for heating the endothermic steam reforming, CLR-S. CLR-S appears to have significant advantages as compared to CLR-A, [34].

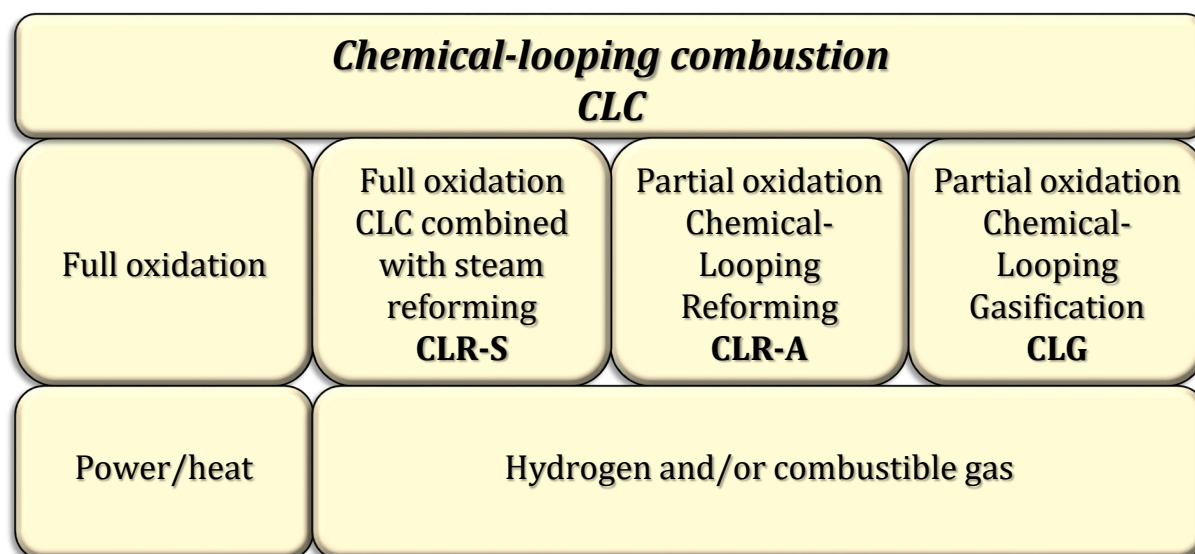


Figure 3. Different applications of chemical-looping.

## 2 Chemical-Looping Operational Experiences

### 2.1 Oxygen carrier materials

#### 2.1.1 Overview of oxygen carrier operation

An overview of operation with oxygen carrier materials as summarized from 213 publications is given in Table 1. A comparison is made to a previous overview where data were collected in the spring of 2014, [9], i.e. four years before the present data. The review from 2014 covers the first ten years of operation of CLC pilot units.

Firstly, it can be noted that the total time of operation is more than 11 000 h. The majority of this operational time is with manufactured materials, i.e. 70%. Manufactured materials are most often used with gaseous and liquid fuels, whereas less than half of the operation with solid fuels uses manufactured materials. For manufactured materials, oxides of Ni dominate the use with gaseous fuels, followed by oxides of copper and combined oxides. For solid fuels the most used materials are manufactured iron oxides, followed ilmenite and iron ores. Thus, gaseous fuels are associated with the most expensive materials, oxides of Ni and Cu, whereas solid fuels are associated with the cheapest materials, i.e. iron oxides, ores and waste materials, together exceeding 80% of all operation with solid fuels. Among the natural/waste materials the most used oxygen carrier is ilmenite, followed by iron ores/waste and manganese ores.

Table 1: Overview of hours of chemical-looping operation with different oxygen carrier materials.

Type	Oxygen carrier	Gaseous fuel	Liquid fuel	Solid fuel	Total 2018	Total 2018, %	Total 2014	2014-2018	increase '14-'18, %
Manufactured	NiO	2677	377	237	<b>3291</b>	29%	2800	491	18%
	CuO	1130	122	173	<b>1425</b>	13%	627	798	127%
	Mn <sub>3</sub> O <sub>4</sub>	74	17	0	<b>91</b>	1%	91	0	0%
	Fe <sub>2</sub> O <sub>3</sub>	617	77	1072	<b>1766</b>	16%	1077	689	64%
	CoO	178	0	0	<b>178</b>	2%	178	0	0%
	Combined oxides	918	10	289	<b>1217</b>	11%	545	672	123%
Natural ore or waste material	Fe ore	488	0	576	<b>1064</b>	9%	404	660	163%
	Ilmenite	538	150	788	<b>1496</b>	13%	810	686	85%
	Mn ore	354	0	381	<b>735</b>	6%	148	587	397%
	CaSO <sub>4</sub>	0	0	75	<b>75</b>	1%	75	0	0%
Total manufactured		5594	603	1771	<b>7968</b>	70%	5318	2650	50%
Total natural/waste		1380	150	1820	<b>3370</b>	30%	1437	1933	135%
<b>Total</b>		6974	753	3591	<b>11338</b>	100%	6755	4583	68%
<b>Publications</b>					212		115	97	84%

The table also shows the increase during the latest four to five years, i.e. 2014-2018. Here an increase by less than appr. 40-50% would signify a reduced activity as compared to the previous ten years. This is clearly the case with Ni oxides, which dominated the first ten years. In absolute numbers, copper oxides were the most used in the last four-year period, followed by iron oxides, ilmenite, iron ore and combined oxides in fierce competition, and with manganese ore lagging slightly behind. Percentagewise the greatest increase was for manganese ore, followed by iron ore, copper oxide and combined oxides. These four have in common that they are of interest for solid fuels, either being low-cost materials or, in the case of copper oxide, having CLOU properties. Manufactured materials increased by 50% which does not really indicate an increased activity. On the other hand, the natural/waste materials have more doubled their operation in the last four years, having a share of 43% of the total operation in this period.

In total, operation time has increased by 68% the last four years and the number of publications on operation has increased by 84%, see Table 1. The yearly number of publications on CLC operation shows a steady increase during the last eight years, see Fig. 4, with bi-annual peaks associated with the CLC and the GHGT (Greenhouse Gas Control Technologies) conferences. The same trend of increase also generally applies to publications on chemical-looping, i.e. publications with “chemical-looping” in title (Scopus), Fig. 4.

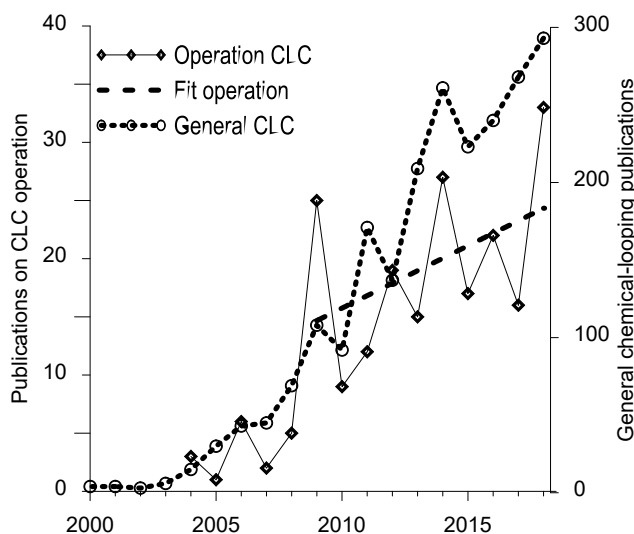


Figure 4. Publications on CLC operation,  $\diamond$ , and “chemical-looping” in title (Scopus),  $\circ$ , vs year published.

An overview of the operation of these oxygen carrier groups will be given in more detail below, starting with Ni-based materials.

### 2.1.2 Ni-based materials

The oxidized and reduced forms are NiO and Ni. Nickel oxide materials were early identified as the oxygen carrier being most reactive with methane, and is also the most studied material. Metallic nickel, the reduced form, is a methane reforming catalyst which likely explains the high reactivity towards methane. This is also supported by laboratory batch experiments, where an initial peak of methane can be seen, i.e. when little Ni has formed,[35].

Important disadvantages with nickel materials are HSE (health, safety and environment) concerns and high costs. Moreover, thermodynamics restrict the gas conversion of CH<sub>4</sub> to CO<sub>2</sub> to 99-99.5%, [26]. Table 2 gives an overview of operation with Ni materials.

Table 2: Operation with nickel-based oxides. For details on locations see Table 11.

Location	Unit	Active oxide/support, prod. method	Time, h	Fuel	Ref.
Chalmers	10 kW	NiO/NiAl <sub>2</sub> O <sub>3</sub> 40/60, FG	100	NG	[36, 37]
Chalmers	10 kW	NiO/NiAl <sub>2</sub> O <sub>4</sub> 60/40, SF	165	NG	[38]
Chalmers	10 kW	NiO/NiAl <sub>2</sub> O <sub>4</sub> 40/60, SD NiO/NiAl <sub>2</sub> O <sub>4</sub> /MgAl <sub>2</sub> O <sub>4</sub> 40/42/18 SD	1000	NG	[39]
KIER	50 kW	NiO/bentonite 60/40, MDCC	3	NG	[40]
Chalmers	0.3 kW	NiO/MgAl <sub>2</sub> O <sub>4</sub> 60/40, FG	30	NG	[41]
Chalmers	0.3 kW	NiO/NiAl <sub>2</sub> O <sub>3</sub> 40/60, FG NiO/MgAl <sub>2</sub> O <sub>4</sub> 60/40, FG	8	NG/SG	[42]
Chalmers	0.3 kW	NiO/MgAl <sub>2</sub> O <sub>4</sub> 60/40, FG	41	NG	[43]
Chalmers	0.3 kW	NiO/MgAl <sub>2</sub> O <sub>4</sub> 20/80, FG	160	NG	[44]
Chalmers	0.3 kW	NiO/ZrO <sub>2</sub> (Mg) 40/60, FG	40	NG	[45]
Chalmers	0.3 kW	NiO/NiAl <sub>2</sub> O <sub>4</sub> 40/60, SD NiO/NiAl <sub>2</sub> O <sub>4</sub> /MgAl <sub>2</sub> O <sub>4</sub> 40/42/18 SD NiO/α-Al <sub>2</sub> O <sub>3</sub> 18/82, HI	84	NG	[46]
CSIC	0.5 kW	NiO/α-Al <sub>2</sub> O <sub>3</sub> 18/82, HIWI	70	CH <sub>4</sub>	[47]
CSIC	0.5 kW	NiO/α-Al <sub>2</sub> O <sub>3</sub> 19/81, HIWI	40	LHC	[48]
CSIC	0.5 kW	NiO/α-Al <sub>2</sub> O <sub>3</sub> 19/81, HIWI	35	CH <sub>4</sub> + H <sub>2</sub> S	[49]
CSIC	0.5 kW	NiO/γ-Al <sub>2</sub> O <sub>3</sub> 21/79, HIWI NiO/α-Al <sub>2</sub> O <sub>3</sub> 18/82, HIWI	50	CH <sub>4</sub>	[50] [51]
CSIC	0.5 kW	NiO/α-Al <sub>2</sub> O <sub>3</sub> 18/82, HIWI	50	SG	[52]
CSIC	0.5 kW	NiO/α-Al <sub>2</sub> O <sub>3</sub> 19/81, HIWI	35	CH <sub>4</sub>	[53]
CSIC	0.5 kW	NiO/CaAl <sub>2</sub> O <sub>4</sub> 12/88, WI [54] NiO/α-Al <sub>2</sub> O <sub>3</sub> 18/82, HIWI	90	CH <sub>4</sub> , H <sub>2</sub> , CO, SG, LHC	[55]
CSIC	0.5/1 kW-LF	NiO/α-Al <sub>2</sub> O <sub>3</sub> 18/82, HIWI	120	ethanol	[56]
CSIC	0.5/1 kW-LF	NiO/γ-Al <sub>2</sub> O <sub>3</sub> 21/79, HIWI	53	ethanol	[54]
CSIC	0.5/1 kW-LF	NiO/α-Al <sub>2</sub> O <sub>3</sub> 18/82 NiO/γ-Al <sub>2</sub> O <sub>3</sub> 21/79	50	ethanol	[57]
CSIC	0.5/1 kW-LF	NiO/α-Al <sub>2</sub> O <sub>3</sub> 18/82	50	Diesel, oil	[58, 59]
CSIC	0.5/1 kW-LF	NiO/α-Al <sub>2</sub> O <sub>3</sub> 18/82 HIWI NiO/γ-Al <sub>2</sub> O <sub>3</sub> 21/79 WII	50	bioethanol	[60]
KAIST	1 kW	NiO/bentonite 60/40 NiO/Fe <sub>2</sub> O <sub>3</sub> /bent. 45/15/40 NiO/Fe <sub>2</sub> O <sub>3</sub> /bent. 30/30/40	6	CH <sub>4</sub>	[61]
Vienna UT	140 kW	NiO/NiAl <sub>2</sub> O <sub>4</sub> 40/60, SD NiO/NiAl <sub>2</sub> O <sub>4</sub> /MgAl <sub>2</sub> O <sub>4</sub> 40/42/18 SD NiO/α-Al <sub>2</sub> O <sub>3</sub> 18/82, HIWI	appr. 240*	NG, CO, H <sub>2</sub> \	[62-72]
Vienna UT	140 kW	NiO/NiAl <sub>2</sub> O <sub>4</sub> 40/60, SD + NiO/NiAl <sub>2</sub> O <sub>4</sub> /MgAl <sub>2</sub> O <sub>4</sub> 40/42/18 SD	32	NG +H <sub>2</sub> S	[73]
Alstom	15 kW	NiO/NiAl <sub>2</sub> O <sub>3</sub> 40/60, FG NiO/NiAl <sub>2</sub> O <sub>4</sub> 40/60, SD NiO/NiAl <sub>2</sub> O <sub>4</sub> /MgAl <sub>2</sub> O <sub>4</sub> 40/42/18 SD NiO/α-Al <sub>2</sub> O <sub>3</sub> 18/82, HIWI	100	NG	[74]
Nanjing	10 kW –SF	NiO/NiAl <sub>2</sub> O <sub>4</sub> 33/67, impr	30	coal	[75]
Nanjing	10 kW –SF	NiO/Al <sub>2</sub> O <sub>3</sub> 35/65, CP	100	coal	[76]
Nanjing	10 kW –SF	NiO/Al <sub>2</sub> O <sub>3</sub> 35/65	100	sawdust	[77]
KIER	50 kW new	NiO/?? 70/30, SD	100-200	NG, SG	[78]
Nanjing	1 kW – SF	NiO/Al <sub>2</sub> O <sub>3</sub> 35/65, CP	30	coal	[79]
Nanjing	1 kW – SF	NiO/NiAl <sub>2</sub> O <sub>4</sub> /Al <sub>2</sub> O <sub>3</sub> 20/39/41, CP	?	coal	[80]
IFP-Lyon	10 kW-GSF	NiO/NiAl <sub>2</sub> O <sub>4</sub> 60/40, Pr	18	CH <sub>4</sub>	[81]
Chalmers	0.3 kW LF	NiO/ZrO <sub>2</sub> (Mg) 40/60, SD	54	kerosene	[82]
Nanjing	25 kW-SF	NiO/Al <sub>2</sub> O <sub>3</sub> 60/40 + sand	>7	rice straw	[83]
KIER	200 kW	70% NiO SD	100	NG, SG	[84]

\*Personal communication.

Abbreviations used in Tables 2-11:

*CLC units:* SF solid fuel, LF liquid fuel, GSF gaseous, liquid and solid fuel; *Materials:* w with (added to particle), + physically mixed.; letters within parenthesis indicate origin, e.g. country or company. *Production methods:* FG freeze granulated, SD spray-dried, HIWI=hot incipient wet impregnation; WII=wet incipient impregnation; WI=wet impregnation; impr=impregnation; CP=coprecipitation; Pr=precipitation; WM=waste material. *Fuels:* NG natural gas, SG syngas, PC petroleum coke, LHC lower hydrocarbons, e.g. ethane, propane, PSA-OG pressure swing adsorption off-gas.

### 2.1.3 3.3 Cu-based materials

The oxidised form is CuO and the fully reduced form is Cu. Moreover, copper can be used as a CLOU material, with the reduced form Cu<sub>2</sub>O, [85]. This was not considered or realized in earlier studies of copper materials, using low temperatures e.g. 800-850°C, where the CLOU effect is small. Low temperatures were used to avoid agglomerations, which were common in laboratory testing at higher temperatures because these normally involved reduction all the way to Cu, which has a low melting temperature, 1079°C.

After the potential advantages with CLOU were realized, most studies have used higher temperatures, and agglomerations have not been noted. This is likely because complete reduction of the oxygen carrier all the way to Cu has been avoided. Both CuO and Cu<sub>2</sub>O have considerably higher melting temperatures as compared to Cu. Operation with methane using higher temperatures has shown excellent gas conversion.

An advantage with copper materials is that the reactions in the fuel reactor are exothermic. Thus, it is possible to use lower material circulation as compared to the other oxygen carrier materials where the circulation needs to be sufficient to avoid large temperature difference between air and fuel reactor. Although copper materials have been used in a number of operational studies, there are still uncertainties regarding the material lifetime, [86-88]. Copper materials are costly which means long lifetimes are needed. It should be said that copper oxide impregnated on materials based on  $\gamma$ -Al<sub>2</sub>O<sub>3</sub> has shown low attrition, [89]. Unfortunately, the copper oxide reacts with the support to CuAl<sub>2</sub>O<sub>4</sub>, which is still a good oxygen carrier but without the excellent CLOU properties of CuO, [90-92]. But so far only a limited number of copper oxides have been examined, and the unique performance of copper-CLOU materials makes it worthwhile to pursue the investigation of copper-based materials. Operation with copper-based materials is shown in Table 3.

Table 3: Operation with copper-based oxides.

Location	Unit	Active oxide/support, prod. method	Time, h	Fuel	Ref.
CSIC	10 kW	CuO/Al <sub>2</sub> O <sub>4</sub> 14/86, WI	120	NG	[93] [94]
Chalmers	0.3 kW	CuO/ZrO <sub>2</sub> 40/60, SD CuO/ZrO <sub>2</sub> -Y 40/60, SD CuO/CeO 40/60, SD	23	NG	[87]
CSIC	0.5 kW	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> 14/86, IWI	40	SG	[95]
CSIC	0.5 kW	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> 14/86, IWI	30	LHC	[96]
CSIC	0.5 kW	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> 14/86, IWI	60	CH <sub>4</sub>	[90]
CSIC	0.5 kW	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> 14/86, IWI CuO/ $\alpha$ -Al <sub>2</sub> O <sub>3</sub> 15/85, IWI CuO/MgAl <sub>2</sub> O <sub>4</sub> 12/88, IWI CuO/ $\alpha$ -Al <sub>2</sub> O <sub>3</sub> /NiO 13/84/3, IWI	176	CH <sub>4</sub>	[97]

CSIC	0.5 kW	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> 14/86, IWI	40	Sour gas	[98]
CSIC	0.5 kW	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> 14/86, IWI	23	Acid gas	[99]
CSIC	0.5 kW	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> 14/86, IWI	125	CH <sub>4</sub>	[89]
CSIC	0.5 kW	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> 14/86, IWI	65	CH <sub>4</sub>	[100]
CSIC	1 kW-LF	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> 14/86, IWI	27	ethanol	[54]
CSIC	0.5/1 kW-LF	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> 14/86, IWI	50	Diesel, oil	[58]
Vienna UT	140 kW	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> +CuAl <sub>2</sub> O <sub>4</sub> 9/91, IWI	10	syn	[101]
Vienna UT	140 kW	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> 14/86 DI	70	NG	[102] [103]
TU-Vienna	120 kW	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> 14/86 DI	50	NG, (H <sub>2</sub> S)	[104]
CSIC	0.5/1.5 kW-SF	CuO/MgAl <sub>2</sub> O <sub>4</sub> 60/40, SD	18	coal	[105]
CSIC	0.5/1.5 kW-SF	CuO/MgAl <sub>2</sub> O <sub>4</sub> 60/40, SD	40	coal	[86]
CSIC	0.5/1.5 kW-SF	CuO/MgAl <sub>2</sub> O <sub>4</sub> 60/40, SD	40	coals	[106]
CSIC	0.5/1.5 kW-SF	CuO/MgAl <sub>2</sub> O <sub>4</sub> 60/40, SD	15	lignite	[107]
CSIC	0.5/1.5 kW-SF	CuO/MgAl <sub>2</sub> O <sub>4</sub> 60/40, SD	10	biomass	[108]
CSIC	0.5/1.5 kW-SF	CuO/Fe <sub>2</sub> O <sub>3</sub> /MgAl <sub>2</sub> O <sub>4</sub> 50/10/40, SD	35	lignite	[109]
CSIC	0.5/1.5 kW-SF	CuO/MgAl <sub>2</sub> O <sub>4</sub> 60/40, SD	10	olive stone, sawdust, almond shell	[110]
Chalmers	0.3 kW LF	CuO/ZrO <sub>2</sub> (Mg) 20/80, SD	45	kerosene	[88]
WKentuU	10 kW	Cu-based	24	NG, syn	[111]
IFP	10 kW	Cu-based	270	CH <sub>4</sub>	[112] [92]
SINTEF	150 kW	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub> 14/86 DI	4	CH <sub>4</sub>	[113]
Hamburg	25 kW -SF	CuO/ $\gamma$ -Al <sub>2</sub> O <sub>3</sub>	5	hard wood, lignite	[114]

#### 2.1.4 Mn-based materials

The oxidized form is Mn<sub>3</sub>O<sub>4</sub> and the reduced form is MnO. MnO cannot be further reduced, not even with very high concentration of reducing gas. Thus, in contrast to the other monometallic oxygen carriers the metallic form will never occur. Thermodynamic calculations show manganese materials could be possible CLOU materials. The oxidized and reduced forms would then be Mn<sub>2</sub>O<sub>3</sub> and Mn<sub>3</sub>O<sub>4</sub>. Unfortunately, the air reactor would need to be at a temperature lower than 800°C to be able to oxidize this material at outlet oxygen concentration of e.g. 5%. In practice, it has not been possible to accomplish the oxidation to Mn<sub>2</sub>O<sub>3</sub> at these temperatures.

Despite the fairly high reactivity and the moderate cost, manganese materials have generally received little attention, and Mn is less studied than Ni, Cu and Fe. Thus, only a few manufactured manganese materials have been used in operation. Operation with manganese materials have shown very high reactivity with CO and H<sub>2</sub>, as well as reasonable reactivity with methane. Manganese materials also appears to be the least likely to form agglomerates, such as has been seen at times with both iron, copper and nickel materials, which is possibly associated with the fact that metallic Mn never forms. Operation with manufactured Mn-based materials is shown in Table 4. Operational data are also available for combined manganese oxides as well as for manganese ores, see subsequent sections.

Table 4: Operation with manufactured manganese-based oxides.

Location	Unit	Active oxide/support, prod. method	Time, h	Fuel	Ref.
Chalmers	0.3 kW	Mn <sub>3</sub> O <sub>4</sub> /ZrO <sub>2</sub> -Mg 40/60, FG	70	NG/SG	[115]
Chalmers	0.3 kW	Mn <sub>2</sub> O <sub>3</sub> /Fe <sub>2</sub> O <sub>3</sub> 33/67, SD	4	NG	[116]
Chalmers	0.3 kW LF	Mn <sub>3</sub> O <sub>4</sub> /ZrO <sub>2</sub> (Mg) 40/60, SD	17	kerosene	[88]

### 2.1.5 Fe-based materials

The oxidized form is Fe<sub>2</sub>O<sub>3</sub>, whereas the reduced form is Fe<sub>3</sub>O<sub>4</sub>. Further reduction to FeO or even Fe, is possible, but reduction to these lower states of oxidation is not thermodynamically possible under conditions of full fuel conversion, at least not at well-mixed conditions. However, formation of FeO or Fe locally, where fuel concentration is high, cannot be excluded, although these would be re-oxidized in other zones. In processes for direct hydrogen production, these lower forms are desired, which can be accomplished by designing a fuel reactor where the fuel and oxygen carrier are in counter-current, [117],[118].

Manufactured iron materials generally show poor reactivity towards methane, whereas the reactivity towards syngas is reasonable. Reported operation with manufactured iron oxides is shown in Table 5.

Table 5: Operation with manufactured iron-based oxides.

Location	Unit	Active oxide/support, prod. method	Time, h	Fuel	Ref.
Chalmers	10 kW	Fe <sub>2</sub> O <sub>3</sub> /MgAl <sub>2</sub> O <sub>3</sub> 60/40, FG	17	NG	[37]
Chalmers	0.3 kW	Fe <sub>2</sub> O <sub>3</sub> /ZrO <sub>2</sub> -Mg 40/60, FG	40	NG/SG	[119]
CSIC	0.5 kW	Fe <sub>2</sub> O <sub>3</sub> /γ-Al <sub>2</sub> O <sub>3</sub> 15/85, WI	40	PSA-OG, CH <sub>4</sub>	[120]
CSIC	0.5 kW	Fe <sub>2</sub> O <sub>3</sub> /NiO/γ-Al <sub>2</sub> O <sub>3</sub> 15/2/83, WI Fe <sub>2</sub> O <sub>3</sub> /γ-Al <sub>2</sub> O <sub>3</sub> 15/85, WI plus NiO/γ-Al <sub>2</sub> O <sub>3</sub> 18/82, WI	32	PSA-OG, CH <sub>4</sub>	[121]
CSIC	0.5 kW	Fe <sub>2</sub> O <sub>3</sub> /γ-Al <sub>2</sub> O <sub>3</sub> 15/85, WI	54	CH <sub>4</sub> /H <sub>2</sub> S	[122]
CSIC	0.5 kW	Fe <sub>2</sub> O <sub>3</sub> /γ-Al <sub>2</sub> O <sub>3</sub> 15/85, WI	20	Sour gas	[98]
CSIC	0.5 kW	Fe <sub>2</sub> O <sub>3</sub> /γ-Al <sub>2</sub> O <sub>3</sub> 15/85, WI	18	Acid gas	[99]
CSIC	1 kW-LF	Fe <sub>2</sub> O <sub>3</sub> /γ-Al <sub>2</sub> O <sub>3</sub> 20/80, WI	27	ethanol	[54]
CSIC	0.5/1 kW-LF	Fe <sub>2</sub> O <sub>3</sub> /γ-Al <sub>2</sub> O <sub>3</sub> 20/80, WI	50	Diesel, oil	[123]
KAIST	1 kW	NiO/Fe <sub>2</sub> O <sub>3</sub> /bent. 15/45/40 Fe <sub>2</sub> O <sub>3</sub> /bentonite 60/40	2	CH <sub>4</sub>	[61]
Vienna UT	140 kW	Fe <sub>2</sub> O <sub>3</sub> /γ-Al <sub>2</sub> O <sub>3</sub> 15/85, WI	34	NG	[124] [103]
Nanjing	10 kW -SF	Fe <sub>2</sub> O <sub>3</sub> SIP	30	biomass	[125]
Ohio	25 kW	supported Fe <sub>2</sub> O <sub>3</sub>	>300 SCL	CH <sub>4</sub>	[126] [127] [128] [129]
Ohio	25 kW -SF	supported Fe <sub>2</sub> O <sub>3</sub>	680 CDLC	coal	[130] [131] [132]
Guangzhou	10 kW-G	Fe <sub>2</sub> O <sub>3</sub> /Al <sub>2</sub> O <sub>3</sub> 70/30	60	saw dust	[133] [134]
Guangzhou	10 kW-G	Fe <sub>2</sub> O <sub>3</sub> /Al <sub>2</sub> O <sub>3</sub> /NiO 7/3/0.53	2	saw dust	[135]
NCCC	250 kW	Fe <sub>2</sub> O <sub>3</sub> -based	360	SG+propane	[118]

### 2.1.6 Cobalt oxide CoO

The oxidized and reduced forms of this system are CoO and Co. For good reason little work has been done with cobalt-based materials. It is even more toxic and more costly than Ni materials and thermodynamic restraints prevent conversion of methane to CO<sub>2</sub> to 95-97%.

However, thermodynamics indicate that cobalt could be used for CLOU, using the system  $\text{Co}_3\text{O}_4/\text{CoO}$ , but to oxidize  $\text{CoO}$  to  $\text{Co}_3\text{O}_4$  would require temperatures below  $845^\circ\text{C}$  in 4% oxygen, [26].

Table 6. Operation with cobalt-based oxides.

Location	Unit	Active oxide/support, prod. method	Time, h	Fuel	Ref.
KIER	50 kW	$\text{Co}_x\text{O}_y/\text{CoAl}_2\text{O}_4$ 70/30, CP/I	28	NG	[136]
KIER	50 new kW	$\frac{1}{3}$ NiO/bentonite 60/40, MDCC + $\frac{2}{3}$ $\text{Co}_x\text{O}_y/\text{CoAl}_2\text{O}_4$ 70/30, CP/I	100-200	nat.gas, SG	[78]

### 2.1.7 Combined oxide materials

Combined metal oxides, i.e. where two or more oxides are combined not only physically, but chemically, constituting new oxides, for example calcium manganite,  $\text{CaMnO}_{3-\delta}$ . Combined Mn oxides may exhibit CLOU properties, i.e. the ability to release oxygen. Such materials include Mn combined with Ca, Fe, Si, Mg, Cu and Ni. The thermodynamic properties of these combined manganese oxides were investigated by Rydén et al., [27].

Operation with combined oxides is shown in Table 7. Much of the operation involves various calcium manganites, which have a perovskite structure. Although these materials have a lower direct reactivity towards methane than nickel materials, they seem to be able to perform equally, or even better in pilot operation. The reason is likely that the release of oxygen makes it possible to convert methane which is not in direct contact with the oxygen carrier. Thus, the by-pass of gas in fluidized beds should be less cumbersome with a CLOU material. If temperature and circulation are sufficient and fuel load not too high, operation with calcium manganite has shown full conversion and even an excess of oxygen in operation with natural gas, [137]. With high volatile solid fuel, i.e. biomass, a dramatic improvement in gas conversion compared to natural ores was observed,[138].

Table 7. Operation with manufactured combined oxides.

Location	Unit	Active oxide/support, prod. method	Time, h	Fuel	Ref.
Chalmers	10 kW	$\text{CaMn}_{0.9}\text{Mg}_{0.1}\text{O}_3$ , SD	55	NG	[137]
Chalmers	10 kW	$\text{CaMn}_{0.78}\text{Mg}_{0.1}\text{Ti}_{0.12}\text{O}_3$ , SD	99	NG	[139]
Chalmers	10 kW	$\text{CaMn}_{0.78}\text{Mg}_{0.1}\text{Ti}_{0.12}\text{O}_3$ , SD (E1S2, 901)	134	NG	[140]
Chalmers	0.3 kW	$\text{CaMn}_{0.87}\text{Ti}_{0.13}\text{O}_3$ , SP+FG	70	NG	[141]
Chalmers	0.3 kW	$(\text{Mn}_{0.5}\text{Fe}_{0.5})\text{TiO}_3$	12	NG	[142]
Chalmers	0.3 kW	$\text{FeMnSiO}_3$ , SD $\text{Fe}_{0.66}\text{Mn}_{1.33}\text{SiO}_3$ , SD	8+16	NG	[143]
Chalmers	0.3 kW	$\text{CaMn}_{0.8}\text{Mg}_{0.2}\text{O}_3$ , SD $\text{CaMn}_{0.9}\text{Mg}_{0.1}\text{O}_3$ , SD $\text{CaMn}_{0.78}\text{Mg}_{0.1}\text{Ti}_{0.12}\text{O}_3$ , SD	15+16+ 40 =71	NG	[144]
Chalmers	0.3 kW	Calcium manganite SD	35	NG	[145]
Chalmers	0.3 kW	$\frac{2}{3}(\text{Fe}_{0.33}\text{Mn}_{0.67})\text{O}_3/\frac{1}{3}\text{SiO}_2$ $\frac{7}{9}(\text{Fe}_{0.29}\text{Mn}_{0.71})\text{O}_3/\frac{2}{9}\text{SiO}_2$ $\frac{8}{9}(\text{Fe}_{0.25}\text{Mn}_{0.75})\text{O}_3/\frac{1}{9}\text{SiO}_2$	10+11+ 14 =35	NG	[146]
Chalmers	0.3 kW	$\text{Mn}_3\text{O}_4/\text{SiO}_2$ (75/25) $\text{Mn}_3\text{O}_4/\text{SiO}_2/\text{TiO}_2$ (67/22/11) SD	7 + 24 =31	NG, syn	[147]
Chalmers	0.3 kW	$\text{Mn}_3\text{O}_4/\text{Fe}_2\text{O}_3/\text{Al}_2\text{O}_3$ Mn:Fe:Al = 1:2:0.64	26	syn, CH <sub>4</sub> , kerosene	[148]
Chalmers	10 Kw SF	$\text{CaMn}_{0.9}\text{Mg}_{0.1}\text{O}_3$ , SD	74	wood char, petcoke	[149] [150]
Chalmers	10 kW SF	$\text{Mn}_3\text{O}_4/\text{SiO}_2/\text{TiO}_2$ (67/22/11) SD	32	w-char, coal, petcoke, lign	[151]
CSIC	0.5 kW	$\text{CaMn}_{0.9}\text{Mg}_{0.1}\text{O}_3$ , SD	71	CH <sub>4</sub> /H <sub>2</sub> S	[152]
CSIC	0.5 kW	$\text{Mn}_{0.77}\text{Fe}_{0.23}\text{O}_3$	10	CH <sub>4</sub> , syn	[153]

Vienna UT	140 kW	CaMn <sub>0.9</sub> Mg <sub>0.1</sub> O <sub>3</sub> , SD	30	NG	[124] [103]
Vienna UT	140 kW	CaMn <sub>0.78</sub> Mg <sub>0.1</sub> Ti <sub>0.12</sub> O <sub>3</sub> , SD	23	NG	[124] [103]
Vienna UT	140 kW	CaMn <sub>0.78</sub> Mg <sub>0.1</sub> Ti <sub>0.12</sub> O <sub>3</sub> , SD (ES)	11	NG (+ H <sub>2</sub> S)	[154]
Xi'an Jiaotong	10 kW- Pr	Fe <sub>2</sub> O <sub>3</sub> /CuO/MgAl <sub>2</sub> O <sub>4</sub> 45/15/40, Ext	15	coke oven gas\	[155]
Darmstadt	1 MW	CaMn <sub>0.78</sub> Mg <sub>0.1</sub> Ti <sub>0.12</sub> O <sub>3</sub> , SD	60	NG	[156] [157]
Darmstadt	1 MW	CaMn <sub>0.78</sub> Mg <sub>0.1</sub> Ti <sub>0.12</sub> O <sub>3</sub> , SD + ilmenite	20	NG	[157]
NETL	50 kW	CuO/Fe <sub>2</sub> O <sub>3</sub> /Al <sub>2</sub> O <sub>3</sub> 40/30/30	40	NG	[158, 159]
NETL	50 kW	CuO/Fe <sub>2</sub> O <sub>3</sub> /Al <sub>2</sub> O <sub>3</sub> WG	40	CH <sub>4</sub>	[160]
NETL	50 kW	CuO/Fe <sub>2</sub> O <sub>3</sub> /Al <sub>2</sub> O <sub>3</sub> WG	11	CH <sub>4</sub>	[161]
Chalmers	10 kW LF	CaMn <sub>0.9</sub> Mg <sub>0.1</sub> O <sub>3</sub> , SD	10	Heavy fuel oil	[162]
CSIC	0.5/1.5 kW-SF	CuO/Fe <sub>2</sub> O <sub>3</sub> /MgAl <sub>2</sub> O <sub>4</sub> 50/10/40, SD	35	lignite	[109]
CSIC	0.5/1.5 kW-SF	Cu <sub>34</sub> Mn <sub>66</sub> , SG	40	olive stone, sawdust, almond shell	[110]
CSIC	0.5/1.5 kW-SF	Mn <sub>0.77</sub> Fe <sub>0.23</sub> ) <sub>2</sub> O <sub>3</sub>	10	4 coals	[153]
IFP	10 kW	CaMn <sub>0.78</sub> Mg <sub>0.1</sub> Ti <sub>0.12</sub> O <sub>3</sub> , SD (ES)	75	CH <sub>4</sub>	[163]
Chalmers	100 kW-SF	CaMn <sub>0.78</sub> Mg <sub>0.1</sub> Ti <sub>0.12</sub> O <sub>3</sub> , SD (ES) + ilmenite	18	biomass	[164] [138]

### 2.1.8 Fe-based low-cost materials

Early studies of iron ores showed low reactivity towards methane, [165], but the low price of iron ores in combination with reasonable reactivity towards syngas, make iron ores an interesting option for chemical-looping combustion of solid fuels. Table 8 shows an overview of operation with iron ores and iron oxide waste materials.

Table 8. Operation with natural/waste iron oxides materials.

Location	Unit	Oxygen carrier	Time, h	Fuel	Ref.
Chalmers	0.3 kW	Fe <sub>2</sub> O <sub>3</sub> shells	37	SG	[166]
Chalmers	0.3 kW	Steel slag (Ca, Fe, Si, Mg, Mn)	20	SG, CH <sub>4</sub>	[167]
CSIC	0.5 kW	Fe <sub>2</sub> O <sub>3</sub> WM	111	CH <sub>4</sub> SG	[168]
CSIC	0.5 kW	iron ore (S)	50	CH <sub>4</sub> , SG, PSA off-gas	[169]
Nanjing	1 kW – SF	iron ore (Au)	10	coal	[170]
Nanjing	1 kW – SF	iron ore (Au)	?	sawdust/coal	[171]
Nanjing	1 kW – SF	iron ore (Au) + 3% of NiO/NiAl <sub>2</sub> O <sub>4</sub> /Al <sub>2</sub> O <sub>3</sub> 20/39/41, CP	10	coal	[172]
Nanjing	1 kW – SF	iron ore iron ore w 4.5% NiO, Imp iron ore w, 6.7% NiO, Imp iron ore + 4.5% NiO iron ore + 6.7% NiO	68	coals	[173]
Nanjing	1 kW – SF	iron ore	20	coal/anthracite	[174]
Nanjing	1 kW – SF	iron ore + K	5	coal	[175]
Nanjing	1 kW – SF	iron ore	22	coal with high K	[176]
Nanjing	1 kW – SF	iron ore	10	sewage sludge	[177]
Nanjing	1 kW – SF	iron ore + cement/CaO	15	coal	[178] [179]
Nanjing	1 kW – SF	iron ore	5	coal	[180]
CSIC	0.5/1.5 kW-SF	Fe WM	40	coal	[181]

CSIC	0.5/1.5 kW-SF	Fe ore (S)	78	biomass	[182]
CSIC	0.5/1.5 kW-SF	Fe ore (S)	30	coals	[183]
CSIC	0.5/1.5 kW-SF	Fe ore (S)	18	anthracite, lignite	[184]
CSIC	0.5/1.5 kW-SF	Fe ore (S)	40	saw dust, olive stone, almond shell	[185] [186]
Chalmers	100 kW-SF	Fe ore (S)	26	wood char, 2 coals	[187]
Huazhong	5 kW –G/SF	Fe ore	100	CH <sub>4</sub>	[188]
Huazhong	5 kW – G/SF	Fe ore	100	coal	[189]
Huazhong	50 kW –SF	Fe ore	6	coal	[190]
Nanjing	25 kW-SF	Fe Ore	>6	rice husk	[191]
Nanjing	50 kW-Pr SF	Fe Ore	19	coal	[192]
Nanjing	20 kW-SF	Fe Ore	70	coal	[193]
Huazhong	50 kW –SF	Fe ore	2	coal	[194]
Huazhong	50 kW –SF	Fe ore	6	coal	[190]
Zabrze	10 kW	Fe ore	3	CH <sub>4</sub>	[195]
NETL	50 kW	iron ore	2	NG	[196]
CSIC	50 kW-SF	iron ore	20	olive stone, saw dust	[197]
CSIC	50 kW-SF	iron ore	15	coal	[198]
Chalmers	10 kW–SF	Steel slag (Ca, Fe, Si, Mg, Mn)	28	wood char, wood pellets	[167]
Darmstadt	1 MW	iron ore	42	coal, torrif. biomass	[199]
Nanjing	5 kW-SF/s	iron ore	8	sewage sludge	[200]
Nanjing	5 kW-SF/s	iron ore	4	gasification of coal	[201]
Nanjing	5 kW-SF/s	iron ore	4	coal	[202]
Nanjing	5 kW-SF/i	iron ore	3	biomass	[203]
Nanjing	5 kW-SF/i	iron ore	3	CO	[203]
Nanjing	2 kW	iron ore	12	SG, NG	[204]
Nanjing	25 kW	iron ore	2	coal	[205]

### 2.1.9 Ilmenite

The combined oxide ilmenite, FeTiO<sub>3</sub>, is a naturally occurring mineral. FeTiO<sub>3</sub> is the reduced form and the oxidized form is Fe<sub>2</sub>TiO<sub>5</sub>+TiO<sub>2</sub>, [206]. In operation there is a phase separation with migration of Fe to the surface, giving an outer Fe<sub>2</sub>O<sub>3</sub> layer, which will also participate in the oxygen transfer. The important advantage of ilmenite is the low price in combination with a reasonable reactivity towards syngas. Table 9 shows operation with ilmenite materials.

Table 9. Operation with ilmenite ore.

Location	Unit	Oxygen carrier	Time, h	Fuel	Ref.
Chalmers	0.3 kW	ilmenite (N) w Ni	83	NG	[207]
Chalmers	0.3 kW	ilmenite (N)	85	SG	[166]
Chalmers	10 kW–SF	ilmenite (N)	22	coal	[208]
Chalmers	10 kW–SF	ilmenite (N)	11	petcoke	[209]
Chalmers	10 kW–SF	ilmenite (N)	18	petcoke	[210]
Chalmers	10 kW–SF	ilmenite (N)	26	petcoke	[211]
Chalmers	10 kW–SF	ilmenite (N)	4	petcoke	[212]
Chalmers	10 kW–SF	ilmenite (N) + lime	4	petcoke	[212]
Chalmers	10 kW–SF	ilmenite (N)	29	petcoke, coal	[213]
Vienna UT	140 kW	ilmenite (N)	appr. 160*	CH <sub>4</sub> , CO, H <sub>2</sub>	[214] [68] [69]
Stuttgart	10 kW	ilmenite (Au)	1	SG\	[215]
CSIC	0.5/1.5 kW-SF	ilmenite (N)	26	coal	[216]
CSIC	0.5/1.5 kW-SF	ilmenite (N)	35	coal	[217]
CSIC	0.5/1.5 kW-SF	ilmenite (N)	30	coal	[218]

CSIC	0.5/1.5 kW-SF	ilmenite (N)	44	coals	[219]
CSIC	0.5/1.5 kW-SF	ilmenite (N)	35	lignite	[220]
Chalmers	0.3 kW LF	ilmenite (N)	80	kerosene	[221]
Chalmers	100 kW-SF	ilmenite (N)	24	coal, PC	[222] [223] [224] [225]
Chalmers	100 kW-SF	ilmenite (N)	12	wood char	[226]
Chalmers	100 kW-SF	ilmenite (N)	34	wood char, PC	[227]
Chalmers	100 kW-SF	ilmenite (N) + Mn ore	18	wood char, 2 PC	[228]
Hamburg	25 kW –SF	ilmenite (Au)	>60	CH <sub>4</sub> , coal (21 h)	[229]
Hamburg	25 kW –SF	ilmenite (Au)	30	coal, lignite, biomass	[230]
Chalmers	10 kW LF	Ilmenite (N)	66	Diesel	[231]
Chalmers	10 kW LF	Ilmenite (N)	4	Heavy fuel oil	[162]
CSIC	50 kW-SF	Ilmenite (N)	4	coal	[232]
CSIC	50 kW-SF	Ilmenite (N)	30	coal	[233]
Darmstadt	1 MW	Ilmenite (N)	2	coal	[234]
Darmstadt	1 MW	Ilmenite (N)	3	coal	[235]
Darmstadt	1 MW	Ilmenite (N)	12	coal	[199]
Darmstadt	1 MW	Ilmenite + iron ore	56	coal	[199]
Tsinghua	0.2 kW	Ilmenite	140	CO	[236]
Chalmers	1.4/10 MW	Ilmenite	61	biomass	[237]
VTT	20 kW	Ilmenite (N)	16	biomass	[238]
SINTEF	150 kW	Ilmenite (N)	5	wood pellets	[239]
CSIRO	10 kW-SF	Ilmenite (A)	35	brown coal	[240]
Tsinghua	30 kW-SF	Ilmenite (V)	100	coal	[241]
JCOAL	100 kW-GSF	Ilmenite	64	NG	[242]
JCOAL	100 kW-GSF	Ilmenite	7	coal	[242]
Vienna UT	80 kW-SF	Ilmenite (N)	20	wood pellets	[243]

### 2.1.10 Mn-based low-cost materials

Manganese ores are not as cheap as iron ores, but they still have low cost. The oxidation state of manganese in the ores vary and often the manganese combines with other elements to form various minerals. Because Si and Fe are normally present in manganese ores, these could also potentially have CLOU properties. Laboratory testing indicates that most manganese ores have the ability to release at least minor amounts of oxygen, [244] [245]. Operation with manganese ores generally shows better conversion but more dust formation as compared to ilmenite. Operation with manganese ores is shown in Table 10.

Table 10. Operation with manganese ores.

Location	Unit	Oxygen carrier	Time, h	Fuel	Ref.
Chalmers	0.3 kW	Mn ore (EE)	2	NG	[116]
Chalmers	0.3 kW	5 Mn ores	111	NG, syn, vol	[246]
Chalmers	0.3 kW	Mn ore	21	syn, CH <sub>4</sub> , kerosene	[148]
Chalmers	10 kW–SF	Mn ore (Br)	10	petcoke	[213]
Chalmers	10 kW–SF	Mn ore (Br) + lime	15	petcoke	[247]
Chalmers	10 kW–SF	Mn ore (SI) Mn ore (VA) Mn ore (ME)	16+15 +11 =42	wood char, pet coke	[248]
Chalmers	10 kW–SF	Mn ore (SC)	22	wood char, wood pellets, coal	[249]
IFP-Lyon	10 kW-GSF	Mn ore	38	CH <sub>4</sub> , SG	[250]
IFP-Lyon	10 kW-GSF	Mn ore	52	coal	[250]
Tsinghua	1 kW	Mn ore, Mn ore + Cu	182	CO	[251]
Chalmers	100 kW-SF	Mn ore	52	w-char, coals, petcoke, lign.	[252]
Chalmers	100 kW-SF	Mn ore (SC)	33	wood char, wood pellets, coal	[249]
VTT	20 kW	Mn ore	23	biomass	[253]
Chalmers	1.4/10 MW	Mn ore	32	biomass	[254]
CSIC	0.5 kW-SF	Mn ore (Gb)	100	coal	[255]

### 2.1.11 Other low-cost materials

Limestone is a cheap and abundant material that can be sulphated to form  $\text{CaSO}_4$ .  $\text{CaSO}_4/\text{CaS}$  has been studied as a low cost oxygen carrier for solid fuels. It has a uniquely high oxygen transfer capacity, 47%, but it has a thermodynamic constraint and cannot convert CO and  $\text{H}_2$  more than 98-99%. There is also a risk of sulphur being lost, converting the oxygen carrier to CaO. Loss of sulphur is difficult to predict as it takes place in the shifts between oxidizing and reducing conditions and will be very dependent on the process conditions, including temperature, fuel sulphur content, extent of fuel conversion and frequency of shifts, [256-258]. Operation with the  $\text{CaSO}_4/\text{CaS}$  system is shown in Table 11.

Table 11. Operation with other low-cost materials.

Location	Unit	Active oxide/support, prod. method	Time, h	Fuel	Ref.
Alstom	3 MW-SF	$\text{CaSO}_4$ (FBC ash)	75	coal	[259]

## 2.2 Chemical-looping combustors

Since the first operation was reported in 2004, data from a rising number of chemical-looping combustors have been published, see Fig. 5. Further, the fraction of solid fuel combustors has increased from zero to 60%. Moreover, as indicated by the trend in Fig. 6, the chemical-looping combustors have generally become larger.

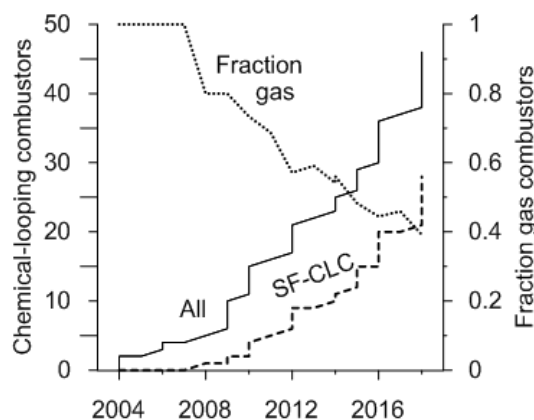


Figure 5. Number of chemical-looping combustors versus year

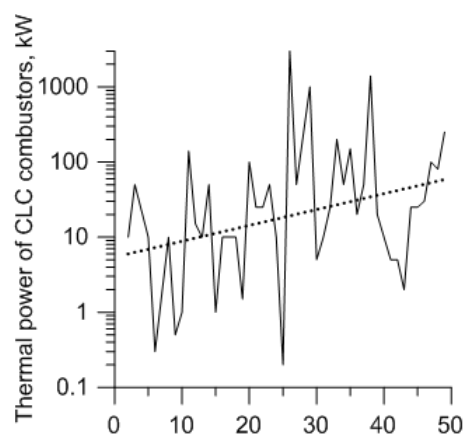


Figure 6. Size of chemical-looping combustors versus consecutive number.

Table 12 lists the 46 chemical-looping combustors used in operation and Table 13 explains the short names for the 25 locations. All these pilots, except those at Ohio State University and NCCC, use interconnected fluidized beds. In Ohio and at NCCC the fuel reactor is a moving bed.

A majority of the operation reported is from Europe, 70%, see Fig. 7, and is associated with a number of European projects that involved Chalmers, CSIC, Vienna, as well as Alstom, Darmstadt, IFP and SINTEF. In Asia an important part of the operation is with Nanjing and KIER, and in North America Ohio State University dominates.

Table 12. Operation with of 46 chemical-looping combustors/ gasifiers.

Location	Unit	Hours of operation	Typical fuels used, selected references	First reported
1 Chalmers	10 kW	1570	nat. gas [36] [37]	2004
2 KIER	50 kW	31	nat. gas [40]	2004
3 CSIC	10 kW	120	nat. gas [93]	2006
4 Chalmers	0.3 kW-GL	1359	nat. gas, syngas, kerosene [42]	2006
5 Chalmers	10 kW-SF	337	coal, petcoke, biomass pellets, wood char [260] [208]	2008
6 CSIC	0.5 kW-GL	1812	nat. gas, acid gas, sour gas, ethanol [47]	2009
7 KAIST	1 kW	8	CH <sub>4</sub> [61]	2009
8 Vienna UT	140 kW	660	nat. gas, CO, H <sub>2</sub> [67]	2009
9 Alstom, Fr	15 kW	100	nat. gas [74]	2009
10 Nanjing	10 kW-SF	260	coal, biomass. [261]	2009
11 KIER	50 kW	300	nat. gas, syngas [78]	2010
12 Nanjing	1 kW-SF	195	coal, biomass, sew. sludge [170] [171]	2010
13 IFP-Lyon	10 kW-GSF	453	CH <sub>4</sub> , coal, syngas [262] [250]	2010
14 Stuttgart	10 kW	1	syngas [215]	2010
15 Xi'an Jiaotong	10 kW-Pr	15	coke oven gas [155]	2010
16 CSIC	1.5 kW-SF	729	coal [217]	2011
17 Chalmers	100 kW-SF	217	coal, petcoke, wood pellets, wood char [223] [224]	2012
18 Hamburg	25 kW-SF	95	coal, CH <sub>4</sub> [263]	2012
19 Ohio	25 kW-SF	980	coal [127] [264]	2012
20 Nanjing	50 kW-Pr	19	coal [192]	2012
21 WKentU	10 kW	24	nat. gas, syngas [111]	2012
22 Tsinghua	0.2 kW	322	CO [236]	2013
23 Alstom, US	3 MW-SF	75	coal [259]	2014
24 CSIC	50 kW-SF	69	coal, lignite, anthracite [232]	2014
25 Chalmers	10 kW-LF	80	diesel, heavy fuel oil [162]	2014
26 Darmstadt	1 MW-GSF	195	coal [234] [235]	2015
27 Huazhong	5 kW-GSF	200	CH <sub>4</sub> coal [189]	2015
28 Guangzhou	10 kW-G	62	saw dust [133]	2015
29 Nanjing	25 kW-G	13	rice husk [83]	2015
30 KIER	200 kW	100	nat. gas [84]	2016
31 Huazhong	50 kW-SF	8	coal [194]	2016
32 SINTEF	150 kW	9	CH <sub>4</sub> , biomass [113]	2016
33 VTT	20 kW-SF	130	biomass [238]	2016
34 NETL	50 kW	2	CH <sub>4</sub> [265]	2016
35 Chalmers	1.4/10 MW	93	biomass [237]	2016
36 Nanjing	20 kW-SF	70	coal [193]	2016
37 Zabrze	10 kW	3	CH <sub>4</sub> [195]	2017
38 Nanjing	5 kW-SF/s	16	coal, sewage sludge [200]	2017
39 Nanjing	5 kW-SF/i	6	biomass, CO, [203]	2018
40 Nanjing	2 kW-SF	12	syngas, nat. gas [204]	2018
41 Nanjing	25 kW-G	2	coal [205]	2018
42 CSIRO	25 kW-SF	35	brown coal [240]	2018
43 Tsinghua	30 kW-SF	100	coal [241]	2018
44 JCOAL	100 kW-GSF	73	NG, coal [242]	2018
45 Vienna UT	80 kW-SF	20	wood pellets [243]	2018
46 NCCC	250 kW Pr WS	360	syngas+propane [118]	2018

SF-solid fuel, GSF-gaseous & solid fuel, Pr-pressurized, LF-liquid fuel, GL=gaseous/liquid fuel, G-Gasification, WS=water splitting, /s=staged, /i=with internals

Table 13. Locations. Abbreviations used.

Alstom, Fr	Alstom Power Boilers, France
Alstom, US	Alstom Power Inc., Windsor, US (now GE)
Chalmers	Chalmers University of Technology, Gothenburg, Sweden
CSIC	Consejo Superior de Investigaciones Cientificas, Instituto de Carboquímica, Zaragoza, Spain
CSIRO	Commonwealth Scientific and Industrial Research Organisation, Clayton South, Australia
Darmstadt	Darmstadt University of Technology, Germany
Guangzhou	Guangzhou Institute of Energy Conversion, China
Hamburg	Technical University Hamburg-Harburg, Germany
Huazhong	Huazhong University of Science and Technology, China
IFP-Lyon	Institut Francais du Petrole, Lyon, France
KAIST	Korea Advanced Institute of Science and Technology, Daejeon, Korea
JCOAL	Japan Coal Energy Center, Tokyo, Japan
KIER	Korea Institute of Energy Research, Daejeon, Korea
Nanjing	South East University, Nanjing, China
NCCC	National Carbon Capture Centre, Wilsonville, Alabama
NETL	National Energy Technology Laboratory, US
Ohio	Ohio State University, US
SINTEF	SINTEF Energy Research, Trondheim, Norway
Stuttgart	University of Stuttgart, Germany
Tsinghua	Tsinghua University, Beijing, China
Vienna UT	Vienna University of Technology, Austria
VTT	VTT Technical Research Centre of Finland
WKentuU	Western Kentucky University, Bowling Green, US
Xi'an Jiaotong	Xi'an Jiaotong University, Xi'an, China
Zabrze	Institute for Chemical Processing of Coal, Zabrze, Poland

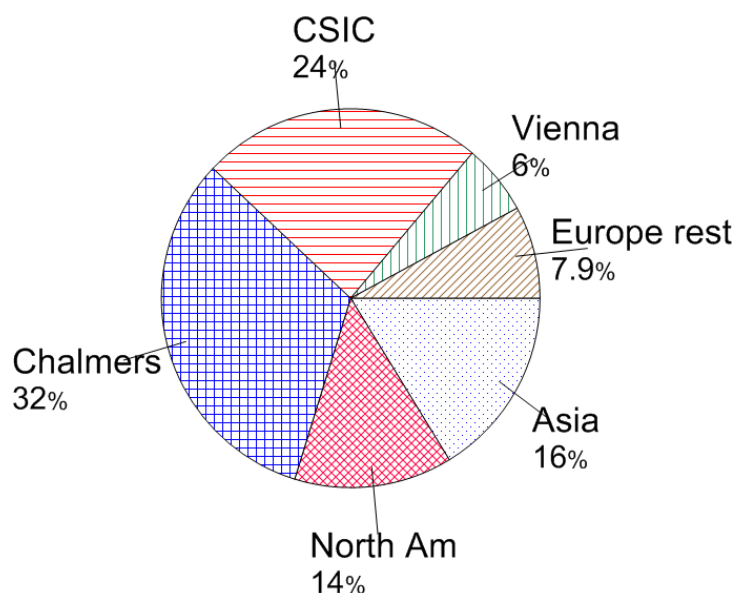


Figure 7. Operation versus location.

### 3 Where are we and where are we going?

#### 3.1 Where are we?

When looking at the rapid accumulation of experience from operation of Chemical-Looping Combustion it should be acknowledged that there is a significant gap to close in comparison to established and well-known technologies. In fact, Chemical-Looping Combustion represents a novel principle of fuel oxidation. In contrast to normal combustion using direct contact between oxidizing gas (air) and fuel, chemical-looping is an indirect method using a medium for oxygen transfer, in similarity to respiration, used by the biosphere since 2 billion years, and fuel cells demonstrated first in 1839, Table 14.

Table 14. Principles of hydrocarbon fuel oxidation.

Principle	first demonstration by human beings or living organisms
respiration	~2 000 000 000 B.C
combustion	~500 000 B.C
fuel cells	1839
chemical-looping combustion	2003

Figures 4-5 and Table 1 clearly demonstrate an increasing activity in the chemical-looping research. It should be also remembered that the earlier phase of development was, for good reason, more focused on the low-hanging fruits. As the operational experiences accumulate, the demands for novel information, that may be more difficult to come by, increases. From Fig. 5 and 6, showing the increased use of solid fuels and the increase in unit size, it is clear that the more recent operational experiences have a greater focus on more difficult tasks.

Firstly the operation of solid and liquid fuels is more costly and requires more manpower. Chemical-looping combustion of solid fuels require much more preparatory work and supplementary work, e.g. in order to establish the fate of fuel particles and constituents and its interaction with the oxygen carrier. Even though SF-CLC comes with expectations of dramatic reductions in CO<sub>2</sub> capture costs and energy penalties, it is undeniable that, at least from the point of view of research, it comes with greater complexity and costs.

Secondly, the operation of larger units also comes with similarly increased costs and increased requirements for manpower. Thirdly, there is also a much greater focus on more complex materials, both the combined manufactured materials and the natural ores and waste materials. The natural materials are normally quite complex containing a number of oxides that may make up a number of various combined oxides. As an example the average composition and standard deviation from a comparison of eight natural manganese ores are given in Table 15, showing firstly high concentrations of several oxides that are likely to interact with manganese as well as high standard deviations suggesting that the materials could have different properties.

Clearly, the research activities are comprehensive, and the scope is expanding leading to rapid accumulation of important knowledge and experience. Important is the increasing operational experiences with an increased number of oxygen-carrier materials. This means there is an increasing portfolio of materials that can be suitable for different applications of chemical-looping technologies, or under different conditions. Economic optimizations, commercial experiences of the technology, technology developments, or other changes in conditions may shift the emphasis on what is actually the best particle properties in relation to expected lifetime, reactivity, price, toxicity and suitable temperature range. A portfolio of different materials is also an important risk reducer for large-scale investments in the technology.

*Table 15. Average analysis of 8 manganese ores. Data from [245]*

	Average, %	Standard deviation
SiO <sub>2</sub>	11.0	3.5
Al <sub>2</sub> O <sub>3</sub>	4.6	4.2
CaO	5.3	6.5
Fe <sub>2</sub> O <sub>3</sub>	27.7	21.6
K <sub>2</sub> O	0.6	0.4
MgO	2.1	2.6
Mn <sub>3</sub> O <sub>4</sub>	49.5	21.4
Na <sub>2</sub> O	0.22	0.18
P <sub>2</sub> O <sub>5</sub>	0.19	0.07
TiO <sub>2</sub>	0.29	0.38

### 3.1.1 Oxygen Carrier Aided Combustion (OCAC)

A spin-off from the quest for oxygen carriers for chemical-looping combustion, is the idea to use oxygen carrier materials to improve fluidized-bed combustion, called Oxygen Carrier Aided Combustion (OCAC). OCAC has been investigated in a 12 MW<sub>th</sub> CFB boiler, using ilmenite, [266], and manganese ore, [267], as oxygen carrier. Moreover, ilmenite has been used as bed material in a 75 MW<sub>th</sub> CFB for more than 12,000 h of operation, [268]. The advantages using oxygen-carrier materials are significant and may outweigh an added cost of such bed materials. For chemical-looping combustion the use of oxygen carriers in OCAC has firstly demonstrated that oxygen carriers can be used in large-scale fluidized beds with fuels such as biomass and municipal waste, and has secondly provided the experience with acquisition and handling of oxygen carrier in the scale of a thousand tonnes.

## 3.2 Where are we going?

A number of developments of chemical-looping combustion are going on in parallel. At the same time the rules of the game in which CLC will play are changing and can be expected to change fundamentally. Meeting the Paris climate agreement will require very fundamental changes to the global energy system, which will not be possible without introduction of effective means of governance. We can only guess what this will mean in practice, but a combination of rapidly decreasing fossil CO<sub>2</sub> emissions and atmospheric carbon removal, i.e. negative CO<sub>2</sub> emissions, will be needed. Consequently, several schemes with incentives, regulations and subsidies could come out of this.

A few points with likely bearing on the future development of SF-CLC will be discussed next.

### 3.2.1 What will happen to performances as the process is up-scaled?

A comparison of the performance of the four largest solid-fuel pilots, 50 kW to 3 MW, is given in [20]. The largest SF-CLC units so far have a size of 1 and 3 MW. The latter used CaSO<sub>4</sub>/CaS and no comparison to smaller pilots is available for this system. In case of the 1 MW pilot a significantly lower performance has been noted. However, it is most likely that

this can be explained by factors like low fuel reactor solids inventory, high level of fuel inlet, and low fuel reactor temperature, [20]. Conditions in fluidized-beds change fundamentally when scale is increased. Higher velocities and bed heights can, on the one hand, be expected create bigger bubbles, i.e. poorer mass transfer, and on the other hand change the fluidization regime in a way that improves the mass transfer. The hard truth is that it is difficult to safely predict the performance in larger units.

### *3.2.2 Key technology challenges*

In general, CLC technology can adapt circulating fluidized bed (CFB) technology, but there are also differences, [20], involving some important challenges, e.g. control of circulation, optimizing gas conversion by design of fuel reactor and selection of oxygen carrier, control of char loss to stack and air reactor by fuel particle size and fuel reactor design, and finally adequate downstream treatment of fuel reactor effluent.

### *3.2.3 Routes for scaling up at reduced costs*

An important barrier against the scaling up of the technology, is obviously the cost and, perhaps even more important, the reluctance to risk money on technology not previously demonstrated in full scale. Lyngfelt et al., [20], discusses strategies to significantly reduce the financial risks involved, e.g. using an existing CFB, or construction of a dual purpose CLC/CFB. The dual purpose approach can also be combined with starting a demonstration unit without the costly process steps needed to attain storable CO<sub>2</sub>, i.e. without oxygen production for oxygen polishing and downstream treatment involving purification and compression of the CO<sub>2</sub>. These can be added after successful demonstration of the core process and be optimized for the composition of the effluent stream obtained. Alternately, the unit can be used as a CFB. A further development of this idea is the concept of a multipurpose dual fluidized-bed (MDFB), with several different potential applications, [269].

### *3.2.4 Costs of solid-fuel CLC*

Proposed designs of solid-fuel chemical-looping boilers presented in the literature involve a 100 MW<sub>th</sub> and a 1000 MW<sub>th</sub> unit, [270], [271]. The latter also involves a cost estimation indicating an added cost of CLC as compared to a circulating fluidized bed (CFB) boiler of 16-26 €/tonne of CO<sub>2</sub> captured. The major costs are downstream of the process, i.e. compression and oxygen production for oxy-polishing. Therefore, the two step approach suggested in the previous section could make sense. Other costs presented for SF-CLC of coal are 10 €/tonne, [272], 26 €/tonne, [273], and 32 €/tonne, [274]. The latter found a lower cost for biomass, 24 €/tonne.

Another aspect of the costs is that chemical-looping may come with other advantages, in the case of coal potentially very low emissions of SO<sub>2</sub> and NO<sub>x</sub>. A techno-economic analysis indicates the cost of both SO<sub>2</sub> and NO<sub>x</sub> removal should go down by a factor of three,[275]. Thus, CLC could be a solution when strengthened emission policies go beyond what is reached with CFB technology. As will be discussed in section 3.2.6 chemical-looping combustion could also come with advantages with respect to difficulties associated with alkali compounds in the fuel ash.

In conclusion, SF-CLC shows a unique potential for attaining very significant cost reduction for CO<sub>2</sub> capture. This is not an unexpected result, as the technology avoids very costly gas separation processes.

### *3.2.5 Funding of CLC*

At present, incentives for reducing CO<sub>2</sub> emissions or for negative CO<sub>2</sub> emissions, are generally poor or non-existent. But, as discussed above, this can be expected to change, and there are many possible means of introducing incentives, [276]. As an interesting example, the California Low Carbon Fuel Standard (LCFS), has created a cap-and-trade market for CO<sub>2</sub> credits which will start to include negative emissions from the fall of 2018, [277]. These credits are typically sold at 120 \$/tonne of CO<sub>2</sub>, [278]. To be added to this price is also the possibility of a tax deduction of 50 \$/tonne for negative emissions. In total this could mean 170 \$/tonne of CO<sub>2</sub> for negative emissions. This is ten times more than the lowest estimations of costs for CLC.

## **4 Negative CO<sub>2</sub> emissions using biomass**

### **4.1 Negative CO<sub>2</sub> emissions**

The concept of CO<sub>2</sub> budgets is used to show the total amount of emissions that would still be allowed for meeting climate stabilization targets. The estimated remaining budget for a maximum temperature rise of 2°C is around 700-800 Gt CO<sub>2</sub>, [279]. With present emissions of 35-40 Gt/year, this would be exhausted in approximately 20 years from now. It is evident that such a rapid reduction in CO<sub>2</sub> emissions is not in correspondence with national plans for CO<sub>2</sub> reductions. This is because the modelling scenarios include a back-door, namely negative CO<sub>2</sub> emissions, also called atmospheric carbon removal. Thus, the model scenarios typically assume fossil emissions will be twice the budget, around 1600 Gt CO<sub>2</sub>, see Fig. 8, while we leave our descendants with the expensive task of removing around 800 Gt of CO<sub>2</sub>, i.e. around 100 tonne/capita.

These model scenarios were conceived before the Paris agreement and form a basis for the ideas on what is needed to meet the climate goal. However, these modelling scenarios, are based on optimization of costs and tend to favour taking necessary costs in a distant future instead of now. Consequently, the costs for addressing the climate issue are sent to our descendants. There is a growing concern about the immoral aspect of emitting CO<sub>2</sub> that our descendants will need to remove from the atmosphere. The obvious way to make better is to reduce fossil emissions more rapidly in combination with a more rapid introduction of negative emissions at large scale.

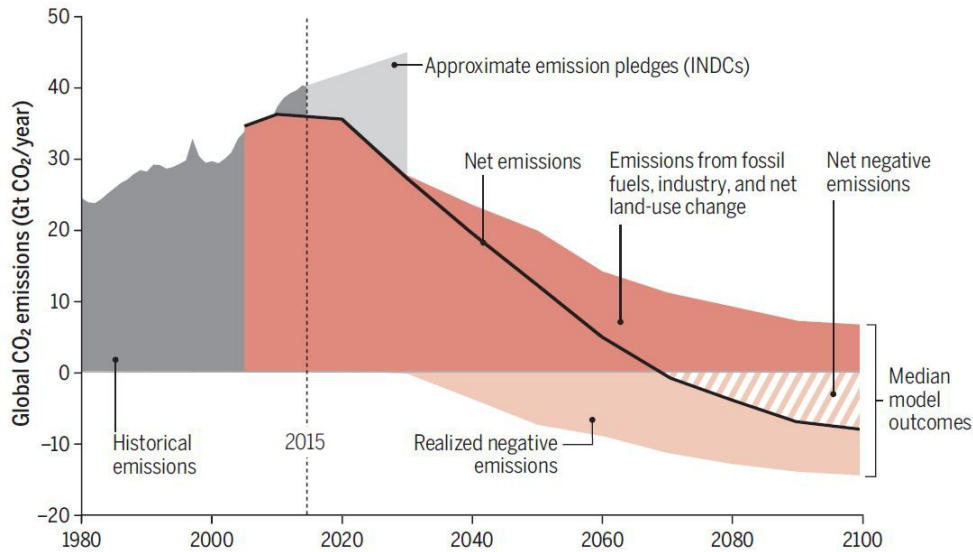


Figure 9. A median IPCC emission scenario for meeting the 2°C target. From [279]

With an assumed deficit in the carbon budget of e.g. 800 Gt CO<sub>2</sub>, and an assumed cost of negative emissions of 100 €/t the debt we leave to children and grandchildren corresponds to 10,000 € for every now living human being. Will future political leaders be able to agree on how to share these costs between countries and have their tax-payers pay their share of this debt, even if the money for practical reasons would need to be used in another country? Options for financing negative emissions are discussed in,[280].

A very attractive solution would be a producer liability for emissions of CO<sub>2</sub>, i.e. that the emitter of CO<sub>2</sub> pays for the subsequent removal from the atmosphere. This would both create the necessary incentives for rapid CO<sub>2</sub> reductions as well as the necessary funding for removing the CO<sub>2</sub> emitted.

In this context, chemical-looping of biomass could become important much earlier than expected. The necessity of negative emissions may also contribute to a more positive public perception of BECCS, i.e. Bio-Energy CCS, as compared to CCS, which has experienced difficulties in some European countries.

## 4.2 Biomass in chemical-looping combustion

In the case of biomass, CLC may also come with important advantages. Low or eliminated  $\text{NO}_x$  emissions, is one, *cf. section 3.2.4.* Another is associated with the important difficulties imposed by the aggressive alkali ash components in biomass fuels. If the alkali could be avoided in the air reactor, this could give significant reductions of maintenance costs as well as higher efficiency, see Fig. 9. It could even open up for the use of biomass fuels of high potassium content, e.g. grasses, normally avoided in boilers. However, the fate of alkali in CLC is largely unknown and further research is needed.

Zevenhoven et al. studied defluidization in a lab reactor with salts to simulate biomass ash,[281]. They concluded that  $\text{KCl}$  will vaporize in the fuel reactor. Consequently, alkali chloride should not appear in air reactor. They also found that  $\text{K}_2\text{CO}_3$  will react with ilmenite and form potassium titanate. Hence, some alkali can be carried to the air reactor from potassium containing fuels if ilmenite is used as bed material. Feeding potassium dihydrogen phosphate to their test reactor Zevenhoven et al. observed bed agglomeration. This result indicates that phosphorous-containing fuels, such as agricultural residues could give difficulties.

Alkali and especially alkali chlorides is one reason that the steam parameters in solid fuel fired biomass boilers typically are lower than those used in coal fired ones. Although stem wood typically contains low amounts of chlorine, in most cases this is a too expensive fuel. Less valuable, but more demanding fractions are usually more attractive. In Bubbling Fluidized-Bed Combustion (BFBC), a technology often applied in biomass combustion, the maximum steam temperature used is typically  $550\text{ }^\circ\text{C}$ . Most of the heat in biomass CLC is produced in the air reactor. The potential for increasing the steam parameters compared to BFBC, and thus the efficiency of the Rankine cycle, seems promising. Until now, investigations on corrosion risk in CLC are scarce.

Eriksson et al. have assessed the corrosion risk in biomass-CLC using laboratory experiments,[282]. The steels chosen for testing air reactor like conditions were TP347, TP310, Sanicro28, and the high alloyed steels HRN11 and Inconel617. In these tests, material temperatures up to  $700\text{ }^\circ\text{C}$  were investigated. The steels were either exposed directly to dry air or were covered with a layer of ilmenite or ilmenite with potassium titanate. The results revealed that from a “fire-side” corrosion point of view, these material all potentially could be used in heat transfer surfaces with a much higher material temperature than in e.g. BFBC. Despite the promising results in laboratory corrosion testing at high temperature investigating super heater materials at conditions anticipated in the air reactor, it is important to bear in mind that also the strength of the material at these conditions must be taken into account.

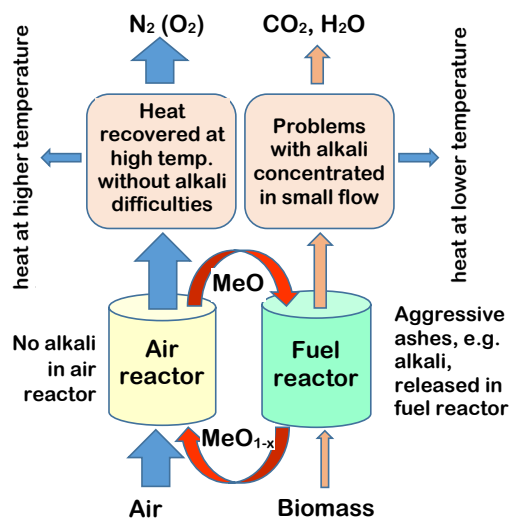


Figure 9. Advantages with respect to alkali.

In the case of the fuel reactor, there are no cooling surfaces and the first cooling surfaces would be downstream of the oxy-polishing step. Here the conditions would be significantly different and further research is needed. However, the heat duty of this stream is significantly smaller and cooling surfaces could be adapted to higher alkali gas content both considering materials used and cooling temperatures.

A first study on the alkali streams in chemical-looping combustion using mostly ilmenite as bed material, found that essentially all alkali was contained in the bed material. This was verified both by a mass balance showing the accumulation of alkali in the solids as well as measurements of alkali in exiting gas streams suggesting these contained only 1-2% of incoming alkali,[138].

There are a large number of existing fluidized bed boilers operating on biomass. As such, bio-CLC may be a very relevant candidate for early up-scaling of the technology, following the already mentioned up-scaling route based on using an existing CFB.

## **5 Discussion and conclusions**

The paper shows that the basis of knowledge for this novel technology is rapidly expanding. The two main barriers for the implementation of solid fuel CLC are firstly the lacking incentives for CO<sub>2</sub> capture and secondly investment risks associated with building full-scale plants with novel technology. However, there should be good hope that both these barriers can be overcome as the need for both rapidly reduced emissions, as well as negative emissions, eventually will be translated into legal and fiscal actions. The bottom-line is the much lower cost of the technology, which may be further augmented by some important advantages associated with the very clean exhaust gas that can be produced by the air reactor.

The following conclusions can be made:

- ❶ With more than 10 000 h of operational experience involving different oxygen carrier materials, fuels and reactor design, it is clear that the concept works and is possible to scale up to full scale.
- ❷ Operational experiences have advanced greatly in the last years, especially with more complex operation involving solid fuels and oxygen carriers of more complex composition.
- ❸ The large experience with a number of different oxygen carriers creates a portfolio of materials with a variation in properties and costs that forms a solid basis for the commercialization and optimization of the process. The possibility to have a choice of materials will facilitate upscaling and investment decisions.
- ❹ At least with solid fuels, and compared to conventional CFB combustion, it is clear that the added costs of chemical-looping are small, and much smaller than for competing technologies.
- ❺ The process has a number of potential advantages, in addition to inherent CO<sub>2</sub> capture, which could reduce costs further. It can also be speculated whether in some specific cases, these advantages could be great enough to motivate the CLC process even without CO<sub>2</sub> capture.

- ❑ While most CLC research has focused on fossil fuels, an important future use could be with biomass, in order to accomplish negative CO<sub>2</sub> emissions, i.e. remove atmospheric carbon.
- ❑ Although performance in full scale cannot be safely predicted, it is highly unlikely that large-scale performance would be so poor that it jeopardized the unique and principal advantage of a CO<sub>2</sub> capture technology where gas separation is inherent in the process.
- ❑ The up-scaling presents a very large barrier for the commercialization of CLC, but there could be ways to reduce the actual and perceived financial risks with building a large-scale boiler using a completely novel combustion principle.
- ❑ At present there is no market for CLC, because of lacking or insufficient incentives, but this could change rapidly. There is a clear understanding that the only way to meet the Paris agreement is to introduce strong measures directed against CO<sub>2</sub> emissions.

Thus, it can only be concluded that the future prospects for CLC should be excellent.

## 6 Acknowledgement

This work was carried out with funding from Swedish Research Council, project “Biomass combustion chemistry with oxygen carriers” 2016-06023, and the Nordic Flagship Project No. 77732 "Negative CO<sub>2</sub> emissions in the Nordic energy system" (2015-2019), funded by the Nordic Energy Research.

## 7 References

- [1] Adánez J, Abad A, Garcia-Labiano F, Gayan P, and de Diego L. *Progress in Chemical-Looping Combustion and Reforming technologies*. Progress in Energy and Combustion Science 38 (2012) p. 215–282.
- [2] Fennell P and Anthony EJ, eds. *Calcium and chemical looping technology for power generation and carbon dioxide (CO<sub>2</sub>) capture*. 2015, Woodhead Publishing Ltd.
- [3] Lyngfelt A. *Chemical looping combustion*. In: F. Scala, editor. Fluidized-bed technologies for near-zero emission combustion and gasification, Woodhead Publishing Limited; 2013, p. 895-930.
- [4] Boot-Handford ME, Abanades JC, Anthony EJ, Blunt MJ, S. Brandani, Dowell NM, J. R. Fernández, Ferrari M-C, Gross R, J. P. Hallett, Haszeldine S, Heptonstall P, Lyngfelt A, Makuch Z, Mangano E, R. T. J. Porter, M. Pourkashanian, G. T. Rochelle, I N. Shah, Yaoa JG, and Fennell P. *Carbon capture and storage update*. Energy Environ. Sci. 7 (2014) p. 130-189.
- [5] Fang H, Haibin, L, Zengli, Z, . *Advancements in development of chemical-looping combustion (CLC) – a review*. Int J Chem Engng Article ID 710515, doi:10.1155/2009/710515 (2009) p.
- [6] Abanades JC, Arias B, Lyngfelt A, Mattisson T, Wiley DE, Li H, Ho MT, Mangano E, and Brandani S. *Emerging CO<sub>2</sub> capture systems*. International Journal of Greenhouse Gas Control 40 ( 2015) p. 126-166.
- [7] Nandy A, Loha C, Gu S, Sarkar P, Karmakar MK, and Chatterjee PK. *Present status and overview of Chemical Looping Combustion technology*. Renewable and Sustainable Energy Reviews 59 (2016) p. 597–619.

- [8] Hossain M and de Lasa H. *Chemical-looping combustion (CLC) for inherent CO<sub>2</sub> separations – a review*. Chem Eng Science 63 (2008) p. 4433-4451.
- [9] Lyngfelt A and Mattisson T. *Chapter 11. Oxygen Carriers for Chemical-Looping Combustion*. In: P. Fennell and E.J. Anthony, editors. Calcium and Chemical Looping Technology for Power Generation and Carbon Dioxide (CO<sub>2</sub>) Capture, Woodhead Publishing; 2014.
- [10] Lyngfelt A, Johansson M, and Mattisson T. Chemical-looping combustion - status of development. In: *9th Int Conf Circ Fluidized Beds*. Hamburg; 2008
- [11] Lyngfelt A and Mattisson T. *Materials for chemical-looping combustion*. In: D. Stolten and V. Scherer, editors. Efficient Carbon Capture for Coal Power Plants, WILEY-VCH Verlag GmbH & Co.. KGaA: Weinheim; 2011, p. 475-504.
- [12] Johansson M, *Screening of oxygen-carrier particles based on iron-, manganese- copper- and nickel oxides for use in chemical-looping technologies, PhD Thesis*. Göteborg: Chalmers University of Technology; 2007.
- [13] Jerndal E, *Investigation of Nickel- and Iron-Based Oxygen Carriers for Chemical-Looping Combustion, PhD Thesis*, . Göteborg: Chalmers University of Technology; 2010.
- [14] Dueso C, *Chemical looping combustion of gaseous fuels with NiO-based oxygen carriers*. Zaragoza, Spain: Instituto de carboquímica; 2010.
- [15] Arjmand M, *Copper and Manganese-based Oxygen Carriers in Chemical-Looping Combustion (CLC) and Chemical-Looping with Oxygen Uncoupling (CLOU)*. Göteborg, Sweden: Chalmers University of Technology; 2014.
- [16] Adánez J, Abad A, Mendiara T, Gayán P, Diego LFd, and García-Labiano F. *Chemical looping combustion of solid fuels*. Progress in Energy and Combustion Science 65 (2018) p. 6-66.
- [17] Lyngfelt A. *Chemical-looping combustion of solid fuels – status of development*. Applied Energy 113 (2014) p. 1869-1873.
- [18] Lyngfelt A and Linderholm C. *Chemical-Looping Combustion of Solid Fuels – status and recent progress*. Energy Procedia 114 (2017) p. 371-386.
- [19] Linderholm C and Lyngfelt A. Use of Manganese Ores as Oxygen Carriers in Chemical-Looping Combustors for Solid Fuels. In: *4<sup>th</sup> International Conference on Chemical Looping*. Nanjing, China; 2016
- [20] Lyngfelt A, Mattisson T, Linderholm C, and Ryden M. Chemical-Looping Combustion of Solid Fuels – What is Needed to Reach Full-Scale ? In: *4<sup>th</sup> International Conference on Chemical Looping*. Nanjing, China; 2016
- [21] Wang P, Means N, Shekhawat D, Berry D, and Massoudi M. *Chemical-Looping Combustion and Gasification of Coals and Oxygen Carrier Development: A Brief Review*. Energies 8 (2015) p. 10605-10635.
- [22] Lyngfelt A. *Oxygen carriers for chemical-looping combustion - 4000 h of operational experience*. Oil & Gas Science and Technology - Revue d'IFP Energies nouvelles 66 (2011) p. 161-172.
- [23] Song T and Shen L. *Review of reactor for chemical looping combustion of solid fuels*. International Journal of Greenhouse Gas Control 76 (2018) p. 92-110.
- [24] Moghtaderi B. *Review of the Recent Chemical Looping Process Developments for Novel Energy and Fuel Applications*. Energy Fuels 26 ( 2012) p. 15–40.
- [25] Fan L-S, *Chemical Looping Systems for Fossil Energy Conversions*: John Wiley & Sons; 2010.
- [26] Jerndal E, Mattisson T, and Lyngfelt A. *Thermal analysis of chemical-looping combustion*. Chemical Engineering Research and Design 84 (2006) p. 795-806.
- [27] Rydén M, Leion H, Mattisson T, and Lyngfelt A. *Combined oxides as oxygen carrier material for chemical-looping with oxygen uncoupling*. Applied Energy 113 (2014) p. 1924-1932.

- [28] Mattisson T, Lyngfelt A, and Leion H. *Chemical-looping oxygen uncoupling for combustion of solid fuels* International Journal of Greenhouse Gas Control 3 (2009) p. 11-19.
- [29] Mattisson T. *Materials for chemical-looping with oxygen uncoupling (CLOU)*. ISRN Chemical Engineering 2013, Article ID 526375 <http://dx.doi.org/10.1155/2013/526375> (2013) p.
- [30] Imtiaz Q, Hosseini D, and Müller C. *Review of Oxygen Carriers for Chemical Looping with Oxygen Uncoupling (CLOU): Thermodynamics, Material Development, and Synthesis*. Energy Technology 1 (2013) p.
- [31] Rydén M, Moldenhauer P, Lindqvist S, Mattisson T, and Lyngfelt A. *Measuring attrition resistance of oxygen carrier particles for chemical looping combustion with a customized jet cup*. Powder Technology 256 (2014) p. 75-86.
- [32] Cabello A, Gayán P, Garcá-Labiano F, Diego LFd, Abad A, and Adánez J. *On the attrition evaluation of oxygen carriers in chemical looping combustion*. Fuel Processing Technology 148 (2016) p. 188-197.
- [33] Rydén M, Linderholm C, Markström P, and Lyngfelt A. *Release of gas phase O<sub>2</sub> from ilmenite during chemical-looping combustion experiments*. Chemical Engineering & Technology 35 (2012) p. 1968-1972.
- [34] Rydén M and Lyngfelt A. *Using steam reforming to produce hydrogen with carbon dioxide capture by chemical-looping combustion*. International Journal of Hydrogen Energy 31 (2006) p. 1271-1283.
- [35] Jerndal E, Mattisson T, and Lyngfelt A. *Investigation of different NiO/NiAl<sub>2</sub>O<sub>4</sub> particles as oxygen carriers for chemical-looping combustion*. Energy and Fuels 23 (2009) p. 665-676.
- [36] Lyngfelt A, Kronberger B, Adánez J, Morin J-X, and Hurst P. *The GRACE project. Development of oxygen carrier particles for chemical-looping combustion. Design and operation of a 10 kW chemical-looping combustor*. in 7th International Conference on Greenhouse Gas Control Technologies. Vancouver.(2004).
- [37] Lyngfelt A and Thunman H. *Construction and 100 h of operational experience of a 10-kW chemical-looping combustor*. Carbon Dioxide Capture for Storage in Deep Geologic Formations--Results from the CO<sub>2</sub> Capture Project 1 (2005) p. 625-645.
- [38] Linderholm C, Mattisson T, and Lyngfelt A. *Long-term integrity testing of spray-dried particles in a 10-kW chemical-looping combustor using natural gas as fuel* Fuel 88 (2009) p. 2083-2096.
- [39] Linderholm C, Abad A, Mattisson T, and Lyngfelt A. *160 h of chemical-looping combustion in a 10 kW reactor system with a NiO-based oxygen carrier*. International Journal of Greenhouse Gas Control 2 (2008) p. 520-530.
- [40] Ryu H-J, Jin G-T, and Yi C-K. *Demonstration of inherent CO<sub>2</sub> separation and no NO<sub>x</sub> emission in a 50 kW chemical-looping combustor: continuous reduction and oxidation experiment*. in Proceedings of the 7th International Conference on Greenhouse Gas Control Technologies. Vancouver.(2004).
- [41] Johansson E, Mattisson T, Lyngfelt A, and Thunman H. *A 300 W laboratory reactor system for chemical-looping combustion with particle circulation*. Fuel 85 (2006) p. 1428-1438.
- [42] Johansson E, Mattisson T, Lyngfelt A, and Thunman H. *Combustion of syngas and natural gas in a 300 W chemical-looping combustor*. Chemical Engineering Research and Design 84 (2006) p. 819-827.
- [43] Rydén M, Lyngfelt A, and Mattisson T. *Synthesis gas generation by chemical-looping reforming in a continuously operating laboratory reactor*. Fuel 85 (2006) p. 1631-1641.
- [44] Rydén M, Lyngfelt A, and Mattisson T. *Chemical-looping combustion and chemical-looping reforming in a circulating fluidized-bed reactor using Ni-based oxygen carriers*. Energy and Fuels 22 (2008) p. 2585-2597.

- [45] Rydén M, Johansson M, Lyngfelt A, and Mattisson T. *NiO supported on Mg-ZrO<sub>2</sub> as oxygen carrier for chemical-looping combustion and chemical-looping reforming*. Energy and Environmental Science 2 (2009) p. 970-981.
- [46] Linderholm C, Jerndal E, Mattisson T, and Lyngfelt A. *Investigation of NiO-based mixed oxides in a 300-W chemical-looping combustor*. Chemical Engineering Research and Design 88 (2010) p. 661-672.
- [47] Adánez J, Dueso C, Diego LFD, García-Labiano F, Gayán P, and Abad A. *Methane combustion in a 500 Wth chemical-looping combustion system using an impregnated ni-based oxygen carrier*. Energy and Fuels 23 (2009) p. 130-142.
- [48] Adánez J, García-Labiano F, Gayán P, de Diego LF, Abad A, Dueso C, and Forero CR. *Effect of gas impurities on the behavior of Ni-based oxygen carriers on chemical-looping combustion*. (2009) p. 11-18.
- [49] Adánez J, Dueso C, De Diego LF, García-Labiano F, Gayán P, and Abad A. *Effect of fuel gas composition in chemical-looping combustion with Ni-based oxygen carriers. 2. Fate of light hydrocarbons*. Industrial and Engineering Chemistry Research 48 (2009) p. 2509-2518.
- [50] de Diego LF, Ortiz M, García-Labiano F, Adánez J, Abad A, and Gayán P. *Hydrogen production by chemical-looping reforming in a circulating fluidized bed reactor using Ni-based oxygen carriers*. Journal of Power Sources 192 (2009) p. 27-34.
- [51] de Diego LF, Ortiz M, García-Labiano F, Adánez J, Abad A, and Gayán P. *Synthesis gas generation by chemical-looping reforming using a Ni-based oxygen carrier*. Energy Procedia 1 (2009) p. 3-10.
- [52] Dueso C, García-Labiano F, Adánez J, de Diego LF, Gayán P, and Abad A. *Syngas combustion in a chemical-looping combustion system using an impregnated Ni-based oxygen carrier*. Fuel 88 (2009) p. 2357-2364.
- [53] García-Labiano F, De Diego LF, Gayán P, Adánez J, Abad A, and Dueso C. *Effect of fuel gas composition in chemical-looping combustion with ni-based oxygen carriers. 1. fate of sulfur*. Industrial and Engineering Chemistry Research 48 (2009) p. 2499-2508.
- [54] L.F. de Diego, A. Serrano, F. García-Labiano, E. García-Díez, A. Abad, P. Gayán, and Adánez J. *Bioethanol combustion with CO<sub>2</sub> capture in a 1 kWth Chemical Looping Combustion prototype: Suitability of the oxygen carrier*. Chemical Engineering Journal 283 (2016) p. 1405–1413.
- [55] Gayán P, Cabello A, García-Labiano F, Abad A, de Diego LF, and Adánez J. *Performance of a low Ni content oxygen carrier for fuel gas combustion in a continuous CLC unit using a CaO/Al<sub>2</sub>O<sub>3</sub> system as support* International Journal of Greenhouse Gas Control 14 (2013) p. 209-219.
- [56] García-Labiano F, Diego LFD, García-Díez E, Serrano A, Abad A, Gayán P, and Adánez J. *Combustion and Reforming of Ethanol in a Chemical Looping Continuous Unit*. Energy Procedia 63 (2014) p. 53–62.
- [57] García-Labiano F, García-Díez E, Diego LFD, Serrano A, Abad A, P. Gayán, Adánez J, and Ruíz JAC. *Syngas/H<sub>2</sub> production from bioethanol in a continuous chemical-looping reforming prototype*. Fuel Processing Technology 137 (2015) p. 24–30.
- [58] García-Labiano F, L.F. de Diego, E. García-Díez, A. Serrano, A. Abad, P. Gayán, and Adánez J. *Combustion and Reforming of Liquid Fossil Fuels through Chemical Looping Processes: Integration of Chemical Looping Processes in a Refinery*. Energy Procedia 114 (2017) p. 325-333.
- [59] García-Díez E, García-Labiano F, Diego LFD, Abad A, Gayán P, Adánez J, and Ruíz JAC. *Steam, dry, and steam-dry chemical looping reforming of diesel fuel in a 1 kW<sub>th</sub> unit*. Chemical Engineering Journal 325 (2017) p. 369-377.

- [60] García-Labiano F, García-Díez E, Diego LFD, Adánez J, and Ruíz JAC. Autothermal Chemical Looping Reforming of Bioethanol for Hydrogen Production. In: *International Conference on Negative CO<sub>2</sub> Emissions*. Göteborg, Sweden; 2018
- [61] Son SR and Kim SD. *Chemical-Looping Combustion with NiO and Fe<sub>2</sub>O<sub>3</sub> in a Thermobalance and Circulating Fluidized Bed Reactor with Double Loops*. *Industrial & Engineering Chemistry Research* 45 (2006) p. 2689-2696.
- [62] Pröll T, Kolbitsch P, Bolhàr-Nordenkamp J, and Hofbauer H. *A Dual Circulating Fluidized Bed (DCFB) system for chemical looping processes*. in AICHE Annual Meeting, Conference Proceedings. Philadelphia, PA.(2008).
- [63] Bolhàr-Nordenkamp J, Pröll T, Kolbitsch P, and Hofbauer H. *Performance of a NiO-based oxygen carrier for chemical looping combustion and reforming in a 120 kW unit*. *Energy Procedia* 1 (2009) p. 19-25.
- [64] Bolhàr-Nordenkamp J, Pröll T, Kolbitsch P, and Hofbauer H. *Chemical looping autothermal reforming at a 120 kW pilot rig*. in Proceedings of the 20<sup>th</sup> International conference on Fluidized Bed Combustion.(2009) p. 603-607.
- [65] Kolbitsch P, Pröll T, Bolhar-Nordenkamp J, and Hofbauer H. *Design of a chemical looping combustor using a dual circulating fluidized bed reactor system*. *Chemical Engineering and Technology* 32 (2009) p. 398-403.
- [66] Kolbitsch P, Pröll T, Bolhar-Nordenkamp J, and Hofbauer H. *Characterization of chemical looping pilot plant performance via experimental determination of solids conversion*. *Energy and Fuels* 23 (2009) p. 1450-1455.
- [67] Kolbitsch P, Bolhàr-Nordenkamp J, Pröll T, and Hofbauer H. *Comparison of two Ni-based oxygen carriers for chemical looping combustion of natural gas in 140 kw continuous looping operation*. *Industrial and Engineering Chemistry Research* 48 (2009) p. 5542-5547.
- [68] Kolbitsch P, Pröll T, Bolhar-Nordenkamp J, and Hofbauer H. *Operating experience with chemical looping combustion in a 120 kW dual circulating fluidized bed (DCFB) unit*. *Energy Procedia* 1 (2009) p. 1465-1472.
- [69] Kolbitsch P, Bolhàr-Nordenkamp J, Pröll T, and Hofbauer H. *Operating experience with chemical looping combustion in a 120 kW dual circulating fluidized bed (DCFB) unit*. *International Journal of Greenhouse Gas Control* 4 (2010) p. 180-185.
- [70] Pröll T, Kolbitsch P, Bolhàr-Nordenkamp J, and Hofbauer H. *A novel dual circulating fluidized bed system for chemical looping processes*. *AIChE Journal* 55 (2009) p. 3255-3266.
- [71] Pröll T, Bolhàr-Nordenkamp J, Kolbitsch P, and Hofbauer H. *Syngas and a separate nitrogen/argon stream via chemical looping reforming - A 140 kW pilot plant study*. *Fuel* 89 (2010) p. 1249-1256.
- [72] Pröll T, Kolbitsch P, Bolhàr-Nordenkamp J, and Hofbauer H. *Chemical looping pilot plant results using a nickel-based oxygen carrier*. *Oil & Gas Science and Technology - Revue d'IFP Energies nouvelles* 66 (2011) p. 173-180.
- [73] Díaz - Castro I, Mayer K, Pröll T, and Hofbauer H. Effect of sulfur on chemical-looping combustion of natural gas using a nickel-based oxygen carrier. In: *21st International Conference on Fluidized Bed Combustion*. Naples; 2012
- [74] Mattisson T, Adánez J, Proell T, Kuusik R, Beal C, Assink J, Snijkers F, and Lyngfelt A. *Chemical-looping Combustion CO<sub>2</sub> Ready Gas Power*. *Energy Procedia* 1 (2009) p. 1557-1564.
- [75] Shen L, Wu J, and Xiao J. *Experiments on chemical looping combustion of coal with a NiO based oxygen carrier*. *Combustion and Flame* 156 (2009) p. 721-728.
- [76] Shen L, Wu J, Gao Z, and Xiao J. *Reactivity deterioration of NiO/Al<sub>2</sub>O<sub>3</sub> oxygen carrier for chemical looping combustion of coal in a 10 kWth reactor*. *Combustion and Flame* 156 (2009) p. 1377-1385.

- [77] Wu J, Shen L, Xiao J, Wang L, and Hao J. *Chemical looping combustion of sawdust in a 10 kWth interconnected fluidized bed*. Huagong Xuebao/CIESC Journal 60 (2009) p. 2080-2088.
- [78] Ryu H-J, Jo S-H, Park YC, Bae D-H, and Kim S. Long-term operation experience in a 50 kWth chemical looping combustor using natural gas and syngas as fuels. In: *1st International Conference on Chemical Looping*. Lyon; 2010
- [79] Shen L, Gao Z, Wu J, and Xiao J. *Sulfur behavior in chemical looping combustion with NiO/Al<sub>2</sub>O<sub>3</sub> oxygen carrier*. Combustion and Flame 157 (2010) p. 853-863.
- [80] Song T, Shen L, Xiao J, Chen D, Gu H, and Zhang S. *Nitrogen transfer of fuel-N in chemical looping combustion*. Combustion and Flame 159 (2012) p. 1286-1295.
- [81] Riffart S, Hoteit A, Yazdanpanah MM, Pelletant W, and Surla K. *Construction and operation of a 10kW CLC unit with circulation configuration enabling independent solid flow control*.(2011) p. 333-340.
- [82] Moldenhauer P, Rydén M, Mattisson T, and Lyngfelt A. *Chemical-Looping Combustion and Chemical-Looping Reforming of Kerosene in a Circulating Fluidized-Bed 300W Laboratory Reactor*. Int. Journal of Greenhouse Gas Control 9 (2012) p. 1-9.
- [83] Ge H, Shen L, Feng F, and Jiang S. *Experiments on biomass gasification using chemical looping with nickel-based oxygen carrier in a 25 kWth reactor*. Applied Thermal Engineering 85 (2015) p. 52–60.
- [84] Baek J-I, Kim U, Jo H, Eom TH, Lee JB, and Ryu H-J. Chemical Looping Combustion Development in Korea. In: *4<sup>th</sup> International Conference on Chemical Looping*. Nanjing, China; 2016
- [85] Mattisson T, Lyngfelt A, and Leion H. *Chemical-looping with oxygen uncoupling for combustion of solid fuels*. International Journal of Greenhouse Gas Control 3 (2009) p. 11-19.
- [86] Adánez-Rubio I, Gayán P, Abad A, de Diego LF, García-Labiano F, and Adánez J. *Evaluation of a spray-dried CuO/MgAl<sub>2</sub>O<sub>4</sub> oxygen carrier for the chemical looping with oxygen uncoupling process*. Energy and Fuels 26 (2012) p. 3069-3081.
- [87] Rydén M, Jing D, Källén M, Leion H, Lyngfelt A, and Mattisson T. *CuO-based oxygen-carrier particles for chemical-looping with oxygen uncoupling (CLOU) – experiments in batch reactor and in continuous operation*. Industrial & Engineering Chemistry Research 53 (2014) p. 6255–6267.
- [88] Moldenhauer P, Rydén M, Mattisson T, and Lyngfelt A. *Chemical-Looping Combustion and Chemical-Looping Combustion with Oxygen Uncoupling of Kerosene with Mn- and Cu-based Oxygen Carriers in a Circulating Fluidized-Bed 300W Laboratory Reactor*. Fuel Processing Technology 104 (2012) p. 378–389.
- [89] Cabello A, Gayán P, Abada A, Diego LFd, García-Labiano F, Izquierdo MT, Scullard A, Williams G, and Adánez J. *Long-lasting Cu-based oxygen carrier material for industrial scale in Chemical Looping Combustion*. International Journal of Greenhouse Gas Control 52 (2016) p. 120–129.
- [90] Forero CR, Gayán P, García-Labiano F, de Diego LF, Abad A, and Adánez J. *High temperature behaviour of a CuO/ $\gamma$ -Al<sub>2</sub>O<sub>3</sub> oxygen carrier for chemical-looping combustion*. International Journal of Greenhouse Gas Control 5 (2011) p. 659-667.
- [91] Arjmand M, Azad A-M, Leion H, Mattisson T, and Lyngfelt A. *Evaluation of CuAl<sub>2</sub>O<sub>4</sub> as Oxygen Carrier in Chemical-looping Combustion (CLC)*. Industrial & Engineering Chemistry Research 51 (2012) p. 13924–13934.
- [92] Lambert A, Tilland A, Pelletant W, Bertholin S, Moreau F, Clemençon I, and Yazdanpanah M. *Performance and degradation mechanisms of CLC particles produced by industrial methods*. Fuel 216 (2018) p. 71-82.
- [93] Adanez J, Gayan P, Celaya J, de Diego LF, Garcia-Labiano F, and Abad A. *Chemical Looping Combustion in a 10 kWth Prototype Using a CuO/Al<sub>2</sub>O<sub>3</sub> Oxygen Carrier: Effect of*

- Operating Conditions on Methane Combustion*. Industrial & Engineering Chemistry Research 45 (2006) p. 6075-6080.
- [94] de Diego LF, García-Labiano F, Gayán P, Celaya J, Palacios JM, and Adánez J. *Operation of a 10 kWth chemical-looping combustor during 200 h with a CuO-Al<sub>2</sub>O<sub>3</sub> oxygen carrier*. Fuel 86 (2007) p. 1036-1045.
- [95] Forero CR, Gayán P, de Diego LF, Abad A, García-Labiano F, and Adánez J. *Syngas combustion in a 500 Wth Chemical-Looping Combustion system using an impregnated Cu-based oxygen carrier*. Fuel Processing Technology 90 (2009) p. 1471-1479.
- [96] Gayán P, Forero CR, de Diego LF, Abad A, García-Labiano F, and Adánez J. *Effect of gas composition in Chemical-Looping Combustion with copper-based oxygen carriers: Fate of light hydrocarbons*. International Journal of Greenhouse Gas Control 4 (2010) p. 13-22.
- [97] Gayán P, Forero CR, Abad A, de Diego LF, García-Labiano F, and Adánez J. *Effect of support on the behavior of Cu-based oxygen carriers during long-term CLC operation at temperatures above 1073 K* Energy and Fuels 25 (2011) p. 1316-1326.
- [98] de Diego LF, García-Labiano F, Gayán P, Abad A, Cabello A, Adánez J, and Sprachmann G. *Performance of Cu- and Fe-based oxygen carriers in a 500 Wth CLC unit for sour gas combustion with high H<sub>2</sub>S content*. International Journal of Greenhouse Gas Control 28 (2014) p. 168–179.
- [99] García-Labiano F, Diego LFD, Gayán P, Abad A, Cabello A, Adánez J, and Sprachmann G. *Energy exploitation of acid gas with high H<sub>2</sub>S content by means of a chemical looping combustion system*. Applied Energy 136 (2014) p. 242–249.
- [100] Cabello A, Diego LFD, García-Labiano F, Abad A, Gayán P, Izquierdo MT, and Adánez J. *Study of the Physical and Chemical Stability of a Cu-based Impregnated Oxygen Carrier at Low Conversion Ratios and Different Temperatures*. In: *5<sup>th</sup> International Conference on Chemical Looping*. Park City, Utah, USA; 2018
- [101] Penthor S, Mayer K, Kern S, Kitzler H, Wöss D, Pröll T, and Hofbauer H. *Chemical-looping combustion of raw syngas from biomass steam gasification - Coupled operation of two dual fluidized bed pilot plants*. Fuel 127 (2014) p. 178-185.
- [102] Penthor S, Zerobin F, Mayer K, Pröll T, and Hofbauer H. *Investigation of the performance of a copper based oxygen carrier for chemical looping combustion in a 120 kW pilot plant for gaseous fuels*. Applied Energy 145 (2015) p. 52–59.
- [103] Mayer K, Penthor S, Pröll T, and Hofbauer H. *The different demands of oxygen carriers on the reactor system of a CLC plant – Results of oxygen carrier testing in a 120 kW<sub>th</sub> pilot plant*. Applied Energy 157 (2015) p. 323–329.
- [104] Pachler RF, Kollerits M, Mayer K, Penthor S, and Hofbauer H. *Fate of sulfur in chemical looping combustion of gaseous fuels using a copper based oxygen carrier*. In: *4<sup>th</sup> International Conference on Chemical Looping*. Nanjing, China; 2016
- [105] Abad A, Adánez-Rubio I, Gayán P, García-Labiano F, de Diego LF, and Adánez J. *Demonstration of chemical-looping with oxygen uncoupling (CLOU) process in a 1.5kW th continuously operating unit using a Cu-based oxygen-carrier*. International Journal of Greenhouse Gas Control 6 (2012) p. 189-200.
- [106] Adánez-Rubio I, Abad A, Gayán P, de Diego L, García-Labiano F, and Adánez J. *Performance of CLOU process in the combustion of different types of coal with CO<sub>2</sub> capture*. International Journal of Greenhouse Gas Control 12 (2013) p. 430–440.
- [107] Adánez-Rubio I, Abad A, Gayán P, García-Labiano F, de Diego LF, and Adánez J. *The fate of sulphur in the Cu-based Chemical Looping with Oxygen Uncoupling (CLOU) Process*. Applied Energy 113 (2014) p. 1855-1862.
- [108] Adánez-Rubio I, Abad A, Gayán P, de Diego LF, García-Labiano F, and Adánez J. *Biomass combustion with CO<sub>2</sub> capture by chemical looping with oxygen uncoupling (CLOU)*. Fuel Processing Technology 124 (2014) p. 104-114.

- [109] Pérez-Vega R, Adánez-Rubio I, Gayán P, Izquierdo MT, Abad A, García-Labiano F, Diego LF, and Adánez J. *Sulphur, nitrogen and mercury emissions from coal combustion with CO<sub>2</sub> capture in chemical looping with oxygen uncoupling (CLOU)*. International Journal of Greenhouse Gas Control 46 (2016) p. 28–38.
- [110] Adánez-Rubio I, Pérez-Astray A, Abad A, Gayán P, de Diego L, and Adánez J. Biomass combustion by Chemical Looping with Oxygen Uncoupling process: experiments with Cu-based and Cu-Mn mixed oxide as oxygen carriers. In: *International Conference on Negative CO<sub>2</sub> Emissions*. Göteborg, Sweden; 2018
- [111] Cao Y, Sit SP, and Pan W-P. The development of 10-KW Chemical Looping Combustion Technology in ICSET, WKU. In: *2nd International Conference on Chemical Looping*. Darmstadt, Germany; 2012
- [112] Tilland A, Lambert A, Pelletant W, Chiche D, Bounie C, and Bertholin S, *Comparison of two oxygen carriers performances for Chemical Looping Combustion application, presentation at, in 9<sup>th</sup> Trondheim Conference on CO<sub>2</sub> Capture, Transport and Storage*. 2017: Trondheim, Norway.
- [113] Langørgen Ø, Saanum I, and Haugen NEL. Performance of a 150 kW chemical looping combustion reactor system for gaseous fuels using a copper-based oxygen carrier. In: *4<sup>th</sup> International Conference on Chemical Looping*,. Nanjing, China; 2016
- [114] Haus J, Feng Y, Hartge E-U, Heinrich S, and Werther J. High volatiles conversion in a dual stage fuel reactor system for Chemical Looping Combustion of wood biomass. In: *International Conference on Negative CO<sub>2</sub> Emissions*. Göteborg, Sweden; 2018
- [115] Abad A, Mattisson T, Lyngfelt A, and Rydén M. *Chemical-looping combustion in a 300 W continuously operating reactor system using a manganese-based oxygen carrier*. Fuel 85 (2006) p. 1174-1185.
- [116] Rydén M, Lyngfelt A, and Mattisson T. *Combined manganese/iron oxides as oxygen carrier for chemical looping combustion with oxygen uncoupling (CLOU) in a circulating fluidized bed reactor system*. Energy Procedia 4 (2011) p. 341-348.
- [117] Mizia F, Rossini S, Cozzolino M, Cornaro U, Tlatlik S, Kaus I, Bakken E, and Larring Y. *Chapter 15: One Step Decarbonization*. In: L.I. Eide, editor. Carbon Dioxide Capture for Storage in Deep Geologic Formations - Results from the CO<sub>2</sub> Capture Project, CPL Press: Newbury; 2009.
- [118] Hsieh T-L, Xu D, Zhang Y, Nadgouda S, Wang D, Chung C, Pottimurphy Y, Guo M, Chen Y-Y, Xu M, He P, Fan L-S, and Tong A. *250 kWth high pressure pilot demonstration of the syngas chemical looping system for high purity H<sub>2</sub> production with CO<sub>2</sub> capture*. Applied Energy 230 (2018) p. 1660-1672.
- [119] Abad A, Mattisson T, Lyngfelt A, and Johansson M. *The use of iron oxide as oxygen carrier in a chemical-looping reactor*. Fuel 86 (2007) p. 1021-1035.
- [120] Gayán P, Pans MA, Ortiz M, Abad A, de Diego LF, García-Labiano F, and Adánez J. *Testing of a highly reactive impregnated Fe<sub>2</sub>O<sub>3</sub>/Al<sub>2</sub>O<sub>3</sub> oxygen carrier for a SR-CLC system in a continuous CLC unit* Fuel Processing Technology 96 (2012) p. 37-47.
- [121] Pans MA, Gayán P, Abad A, García-Labiano F, de Diego LF, and Adánez J. *Use of chemically and physically mixed iron and nickel oxides as oxygen carriers for gas combustion in a CLC process*. Fuel Processing Technology 115 (2013) p. 152-163.
- [122] Cabello A, Dueso C, García-Labiano F, Gayán P, Abad A, de Diego LF, and Adánez J. *Performance of a highly reactive impregnated Fe<sub>2</sub>O<sub>3</sub>/Al<sub>2</sub>O<sub>3</sub> oxygen carrier with CH<sub>4</sub> and H<sub>2</sub>S in a 500 Wth CLC unit*. Fuel 121 (2014) p. 117-125.
- [123] A. Serrano, F. García-Labiano, L.F. de Diego, P. Gayán, A. Abad, and Adánez J. *Chemical Looping Combustion of liquid fossil fuels in a 1 kWth unit using a Fe-based oxygen carrier*. Fuel Processing Technology 160 (2017) p. 47-54.

- [124] Mattisson T, Adánez J, Mayer K, Snijkers F, Williams G, Wesker E, Bertsch O, and Lyngfelt A. *Innovative Oxygen Carriers Uplifting Chemical-looping Combustion*. Energy Procedia 63 (2014) p. 113-130.
- [125] Shen L, Wu J, Xiao J, Song Q, and Xiao R. *Chemical-looping combustion of biomass in a 10 kW<sub>th</sub> reactor with iron oxide as an oxygen carrier*. Energy and Fuels 23 (2009) p. 2498-2505.
- [126] Tong A, Zeng L, Kathe MV, Sridhar D, and Fan L-S. *Application of the moving-bed chemical looping process for high methane conversion*. Energy and Fuels 27 (2013) p. 4119-4128.
- [127] Kim H, Wang D, Zeng L, Bayham S, Tong A, chung E, Kathe M, Luo S, McGiveron O, Wang A, Zhenchao S, Chen D, and Fan L-S. *Coal direct chemical looping combustion process: Design and operation of a 25-kW<sub>th</sub> sub-pilot unit* Fuel 108 (2013) p. 370-384.
- [128] Bayham SC, Kim H, Wang D, Tong A, Zeng L, McGiveron O, Kathe MV, Chung E, Wang W, Wang A, Majumder A, and Fan L-S. *Iron-based coal direct chemical looping combustion process: 200-h continuous operation of a 25-kW<sub>th</sub> subpilot unit*. Energy and Fuels 27 (2013) p. 1347-1356.
- [129] Tong A, Sridhar D, Sun Z, Kim H, Zeng L, Wang F, Wang D, Kathe M, Luo S, Sun Y, and Fan L-S. *Continuous high purity hydrogen generation from a syngas chemical looping 25 kW<sub>th</sub> sub-pilot unit with 100% carbon capture*. Fuel 103 (2013) p. 495-505.
- [130] Sridhar D, Tong A, Kim H, Zeng L, Li F, and Fan L-S. *Syngas chemical looping process: Design and construction of a 25 kW<sub>th</sub> subpilot unit* Energy and Fuels 26 (2012) p. 2292-2302.
- [131] Tong A, Bayham S, Kathe MV, Zeng L, Luo S, and Fan L-S. *Iron-based syngas chemical looping process and coal-direct chemical looping process development at Ohio State University* Applied Energy 113 (2014) p. 1836-1845.
- [132] Bayham S, McGiveron O, Tong A, Chung E, Kathe M, Wang D, Zeng L, and Fan L-S. *Parametric and dynamic studies of an iron-based 25-kW<sub>th</sub> coal direct chemical looping unit using sub-bituminous coal*. Applied Energy 145 (2015) p. 354–363.
- [133] Huseyin S, Wei G, Li H, He F, and Huang Z. *Chemical-looping gasification of biomass in a 10 kW<sub>th</sub> interconnected fluidized bed reactor using Fe<sub>2</sub>O<sub>3</sub>/Al<sub>2</sub>O<sub>3</sub> oxygen carrier* Journal of Fuel Chemistry and Technology 42 (2014) p. 922–931.
- [134] Wei G, He F, Huang Z, Zheng A, Zhao K, and Li H. *Continuous Operation of a 10 kW<sub>th</sub> Chemical Looping Integrated Fluidized Bed Reactor for Gasifying Biomass Using an Iron-Based Oxygen Carrier*. Energy Fuels 29 (2015) p. 233–241.
- [135] Wei G, He F, Zhao Z, Huang Z, Zheng A, Zhao K, and Li H. *Performance of Fe–Ni bimetallic oxygen carriers for chemical looping gasification of biomass in a 10 kW<sub>th</sub> interconnected circulating fluidized bed reactor*. International Journal of Hydrogen Energy 40 (2015) p. 16021-16032.
- [136] Ryu H-J, Jin G-T, Bae D-H, and Yi C-K. *Continuous operation of a 50 kW chemical looping combustor: long-term operation with Ni- and Co-based oxygen carrier particles*. In: *5<sup>th</sup> China-Korea Joint Workshop on Clean Energy Technology*. Qingdao University, China; 2004
- [137] Källén M, Rydén M, Dueso C, Mattisson T, and Lyngfelt A. *CaMn<sub>0.9</sub>Mg<sub>0.103-δ</sub> as Oxygen Carrier in a Gas-Fired 10 kW<sub>th</sub> Chemical-Looping Combustion Unit*. Industrial & Engineering Chemistry Research 52 (2013) p. 6923-6932.
- [138] Gogolev I, Linderholm C, Gall D, Schmitz M, Mattisson T, Pettersson JBC, and Lyngfelt A. *Chemical-Looping Combustion in a 100 kW Unit Using a Mixture of Synthetic and Natural Oxygen Carriers - Operational Results and Fate of Biomass Fuel Alkali*. submitted for publication (2019) p.
- [139] Hallberg P, Hanning M, Rydén M, Mattisson T, and Lyngfelt A. *Investigation of a calcium manganite as oxygen carrier during 99 h of operation of Chemical-Looping*

- Combustion in a 10 kWth unit.*, International Journal of Greenhouse Gas Control 53 (2016) p. 222-229.
- [140] Moldenhauer P, Hallberg P, Biermann M, Snijkers F, Albertsen K, Mattisson T, and Lyngfelt A. Oxygen carrier development of calcium manganite-based materials with perovskite structure for chemical looping combustion of methane. In: *42<sup>nd</sup> International Technical Conference on Clean Energy*. Clearwater, FL, USA; 2017
- [141] Rydén M, Lyngfelt A, and Mattisson T. *CaMn<sub>0.875</sub>Ti<sub>0.125</sub>O<sub>3</sub> as oxygen carrier for chemical-looping combustion with oxygen uncoupling (CLOU) – experiments in continuously operating fluidized bed reactor system*. Int. Journal of Greenhouse Gas Control 5 (2011) p. 356-366.
- [142] Rydén M, Källén M, Jing D, Hedayati A, Mattisson T, and Lyngfelt A. *(Fe<sub>1-x</sub>Mn<sub>x</sub>)Ti<sub>y</sub>O<sub>3</sub> based oxygen carriers for chemical-looping combustion and chemical-looping with oxygen uncoupling* Energy Procedia 51 (2014) p. 85-98.
- [143] Källén M, Hallberg P, Rydén M, Mattisson T, and Lyngfelt A. *Combined Oxides of Iron, Manganese and Silica as Oxygen Carriers for Chemical-Looping with Oxygen Uncoupling*. Fuel Processing Technology 124 (2014) p. 87–96.
- [144] Hallberg P, Källén M, Jing D, Snijkers F, van Noyen J, Rydén M, and Lyngfelt A. *Experimental investigation of CaMnO<sub>3-δ</sub> based oxygen carriers used in continuous Chemical-Looping Combustion*. International Journal of Chemical Engineering, Article ID 412517 (2014) p.
- [145] Hallberg P, Rydén M, Mattisson T, and Lyngfelt A. *CaMnO<sub>3-δ</sub> made from low cost material examined as oxygen carrier in Chemical-Looping Combustion*. Energy Procedia 63 (2014) p. 80-86.
- [146] Källén M, Rydén M, Lyngfelt A, and Mattisson T. *Chemical-looping combustion using combined iron/manganese/silicon oxygen carriers*. Applied Energy 157 (2015) p. 330-337.
- [147] Hanning M, Frick, V., Mattisson, T., Rydén, M., Lyngfelt, A., . *The Performance of Combined Manganese-Silicon Oxygen Carriers and the Possible Effects of Adding Titania*. Energy & Fuels 30 (2016) p. 1171–1182.
- [148] Moldenhauer P, Serrano A, García-Labiano F, Diego LFD, Biermann M, Mattisson T, and Lyngfelt A. *Chemical Looping Combustion of Kerosene and Gaseous Fuels with a Natural and a Synthetic Mn-Fe-based Oxygen Carrier*. accepted for publication Energy & Fuels (2018) p.
- [149] Schmitz M, Linderholm C, and Lyngfelt A. *Chemical Looping Combustion of Sulfurous Solid Fuels using Calcium Manganite as Oxygen Carrier*. Energy Procedia 63 (2014) p. 140-152.
- [150] Schmitz M and Linderholm C. *Performance of calcium manganite as oxygen carrier in chemical looping combustion of biomass in a 10 kW pilot*. Applied Energy 169 (2016) p. 729–737.
- [151] Schmitz M, Linderholm C, and Lyngfelt A. *Chemical-Looping Combustion of Four Different Solid Fuels using a Manganese -Silicon-Titanium Oxygen Carrier*. Journal of Greenhouse Gas Control 70 (2018) p. 88–96.
- [152] Cabello A, Abad A, Gayán P, de Diego LF, García-Labiano F, and Adánez J. *Effect of operating conditions and H<sub>2</sub>S presence on the performance of CaMg<sub>0.1</sub>Mn<sub>0.9</sub>O<sub>3-δ</sub> perovskite material in chemical looping combustion (CLC)*. Energy and Fuels 28 (2014) p. 1262-1274.
- [153] Pérez-Vega R, Abad A, García-Labiano F, Gayán P, Diego LFD, Izquierdo MT, and Adánez J. *Chemical Looping Combustion of gaseous and solid fuels with manganese-iron mixed oxide as oxygen carrier*. Energy Conversion and Management (2018) p. 221–231.
- [154] Pachler RF, Penthor S, Mayer K, and Hofbauer H. *Fate of sulfur in chemical looping combustion of gaseous fuels using a Perovskite oxygen carrier*. Fuel 241 (2019) p. 432-441.

- [155] Wang S, Wang G, Jiang F, Luo M, and Li H. *Chemical looping combustion of coke oven gas by using Fe<sub>2</sub>O<sub>3</sub>/CuO with MgAl<sub>2</sub>O<sub>4</sub> as oxygen carrier*. Energy and Environmental Science 3 (2010) p. 1353-1360.
- [156] Ohlemüller P, Reitz M, Ströhle J, and Epple B, *Operation of a 1 MW<sub>th</sub> chemical looping pilot plant with natural gas, presentation at*, in *High Temperature Solid Looping Cycles Network*. 2017: Luleå.
- [157] Ohlemüller P, Reitz M, Ströhle J, and Epple B, *Operation of a 1 MW<sub>th</sub> chemical looping pilot plant with natural gas, presented at*, in *9th Trondheim Conference on CO<sub>2</sub> Capture, Transport and Storage*. 2017: Trondheim, Norway.
- [158] Siriwardane R, Tian H, Riley J, Benincosa W, Straub D, Weber J, and Richards G. Commercial Scale Preparations of CuO-Fe<sub>2</sub>O<sub>3</sub>-Alumina Oxygen Carrier with various techniques: Bench Scale Fluidized Bed Tests with Coal/Air and Methane/air and Pilot Scale (51 Kwth) Chemical Looping Combustion Tests with Methane/Air. In: *4<sup>th</sup> International Conference on Chemical Looping*. Nanjing, China; 2016
- [159] Bayham S, Straub D, and Weber J, “*Operation of the NETL Chemical Looping Reactor with Natural Gas and a Novel Copper-Iron Material*,” in *NETL-PUB-20912; NETL Technical Report Series*; . 2017: U.S. Department of Energy, National Energy Technology Laboratory: Morgantown, WV, 2017.
- [160] Siriwardane R, Riley J, Bayham S, Straub D, Weber HTJ, and Richards G. *50-kW<sub>th</sub> methane/air chemical looping combustion tests with commercially prepared CuO-Fe<sub>2</sub>O<sub>3</sub>-alumina oxygen carrier with two different techniques*. Applied Energy 213 (2018) p. 92–99.
- [161] Bayham S, Straub D, and Weber J. Operation of a 50-kW chemical looping combustion test facility under autothermal conditions. In: *5th International Conference on Chemical Looping*. Park City, Utah, USA; 2018
- [162] Moldenhauer P, Rydén M, Mattisson T, Jamal A, and Lyngfelt A. *Chemical-Looping Combustion with Heavy Liquid Fuels in a 10 kW Pilot Plant*. Fuel Processing Technology 156 (2017) p. 124-137.
- [163] Lambert A, Tilland A, Pelletant W, and Bertholin S. Ageing and characterization of CaMn<sub>0,775</sub>Ti<sub>0,1</sub>Mg<sub>0,103-δ</sub> particles in a 10 kW<sub>th</sub> CLC pilot plant. In: *5<sup>th</sup> International Conference on Chemical Looping*. Park City, Utah, USA; 2018
- [164] Gogolev I, Linderholm C, Gall D, Schmitz M, Mattisson T, Pettersson JBC, and Lyngfelt A. Chemical-Looping Combustion in a 100 kW Unit Using a Mixture of Synthetic and Natural Oxygen Carriers - Operational Results and Fate of Biomass Fuel Alkali. In: *5<sup>th</sup> International Conference on Chemical Looping*. Park City, Utah, USA; 2018
- [165] Mattisson T, Lyngfelt A, and Cho P. *The use of iron oxide as an oxygen carrier in chemical-looping combustion of methane with inherent separation of CO<sub>2</sub>*. Fuel 80 (2001) p. 1953-1962.
- [166] Moldenhauer P, Rydén M, and Lyngfelt A. *Testing of minerals and industrial by-products as oxygen carriers for chemical-looping combustion in a circulating 300W laboratory reactor*. Fuel 93 (2012) p. 351–363.
- [167] Moldenhauer P, Linderholm C, Rydén M, and Lyngfelt A. Experimental investigation of chemical-looping combustion and chemical-looping gasification of biomass-based fuels using steel converter slag as oxygen carrier. In: *International Conference on Negative CO<sub>2</sub> Emissions*. Gothenburg, Sweden; 2018
- [168] Ortiz M, Gayán P, de Diego LF, García-Labiano F, Abad A, Pans MA, and Adánez J. *Hydrogen production with CO<sub>2</sub> capture by coupling steam reforming of methane and chemical-looping combustion: Use of an iron-based waste product as oxygen carrier burning a PSA tail gas*. Journal of Power Sources 196 (2011) p. 4370-4381.
- [169] Pans MA, Gayán P, de Diego LF, García-Labiano F, Abad A, and Adánez J. *Performance of a low-cost iron ore as an oxygen carrier for Chemical Looping Combustion of gaseous fuels* Chemical Engineering Research and Design 93 (2015) p. 736-746.

- [170] Wu J, Shen L, Hao J, and Gu H. Chemical looping combustion of coal in a 1 kWth reactor. In: *1st International Conference on Chemical Looping*. Lyon; 2010
- [171] Gu H, Shen L, Xiao J, Zhang S, and Song T. *Chemical looping combustion of biomass/coal with natural iron ore as oxygen carrier in a continuous reactor*. Energy and Fuels 25 (2011) p. 446-455.
- [172] Song T, Wu J, Zhang J, and Shen L. *Characterization of an Australia hematite oxygen carrier in chemical looping combustion with coal*. International Journal of Greenhouse Gas Control 11 (2012) p. 336-326.
- [173] Chen D, Shen L, Xiao J, Song T, Gu H, and Zhang S. *Experimental investigation of hematite oxygen carrier decorated with NiO for chemical-looping combustion of coal* Journal of Fuel Chemistry and Technology 40 (2012) p. 267–272.
- [174] Song T, Shen T, Shen L, Xiao J, Gu H, and Zhang S. *Evaluation of hematite oxygen carrier in chemical-looping combustion of coal*. Fuel 104 (2013) p. 244-252.
- [175] Gu H, Shen L, Zhong Z, Niu X, Ge H, Zhou Y, and Xiao S. *Potassium-Modified Iron Ore as Oxygen Carrier for Coal Chemical Looping Combustion: Continuous Test in 1 kW Reactor*. Ind. Eng. Chem. Res. 53 (2014) p. 13006–13015.
- [176] Ge H, Shen L, Gu H, Song T, and Jiang S. *Combustion performance and sodium transformation of high-sodium Zhundong coal during chemical looping combustion with hematite as oxygen carrier*. Fuel 159 (2015) p. 107–117.
- [177] Niu X, Shen L, Gu H, Jiang S, and Xiao J. *Characteristics of hematite and fly ash during chemical looping combustion of sewage sludge*. Chemical Engineering Journal 268 (2015) p. 236–244.
- [178] Gu HM, Shen LH, Zhong Z, Niu X, Liu W, Ge H, Jiang S, and Wang L. *Cement/CaO-modified iron ore as oxygen carrier for chemical looping combustion of coal*. Applied Energy 157 (2015) p. 314–22.
- [179] Gu H, Shen L, Zhong Z, Niu X, Ge H, Zhou Y, Xiao S, and Jiang S. *NO release during chemical looping combustion with iron ore as an oxygen carrier*. Chemical Engineering Journal 264 (2015) p. 211–220.
- [180] Jiang S, Shen L, Niu X, Ge H, and Gu H. *Chemical Looping Co-combustion of Sewage Sludge and Zhundong Coal with Natural Hematite as the Oxygen Carrier*. Energy Fuels 30 (2016) p. 1720–1729.
- [181] Mendiara T, de Diego LF, García-Labiano F, Gayán P, Abad A, and Adánez J. *Behaviour of a bauxite waste material as oxygen carrier in a 500Wth CLC unit with coal*. International Journal of Greenhouse Gas Control 17 (2013) p. 170-182.
- [182] Mendiara T, Abad A, de Diego LF, García-Labiano F, Gayán P, and Adánez J. *Biomass combustion in a CLC system using an iron ore as an oxygen carrier*. International Journal of Greenhouse Gas Control 19 (2013) p. 322-330.
- [183] Mendiara T, de Diego LF, García-Labiano F, Gayán P, Abad A, and Adánez J. *On the use of a highly reactive iron ore in Chemical Looping Combustion of different coals*. Fuel 126 (2014) p. 239-249.
- [184] Mendiara T, Izquierdo MT, Abad A, Gayán P, García-Labiano F, Diego LFd, and Adánez J. *Mercury Release and Speciation in Chemical Looping Combustion of Coal*. Energy Fuels 28 (2014) p. 2786–2794.
- [185] Mendiara T, P. Gayán, F. García-Labiano, L.F. de Diego, A. Pérez-Astray, M.T. Izquierdo, A. Abad, and Adánez J. *Chemical Looping Combustion of Biomass: An Approach to BECCS*. Energy Procedia 114 (2017) p. 6021-6029.
- [186] Mendiara T, Pérez-Astray A, Izquierdo MT, Abad A, Diego LFd, García-Labiano F, Gayán P, and Adánez J. *Chemical Looping Combustion of different types of biomass in a 0.5 kWth unit*. Fuel 211 (2018) p. 868-875.

- [187] Linderholm C and Schmitz M. *Chemical-Looping Combustion of Solid Fuels in a 100 kW Dual Circulating Fluidized Bed System using Iron Ore as Oxygen Carrier*. Journal of Environmental Chemical Engineering 4 (2016) p. 1029–1039.
- [188] Ma J, Zhao H, Tian X, Wei Y, Zhang Y, and Zheng C. *Continuous Operation of Interconnected Fluidized Bed Reactor for Chemical Looping Combustion of CH<sub>4</sub> Using Hematite as Oxygen Carrier*. Energy Fuels (2015) p. 3257–3267.
- [189] Ma J, Zhao H, Tian X, Wei Y, Rajendran S, Zhang Y, Bhattacharya S, and Zheng C. *Chemical looping combustion of coal in a 5 kW<sub>th</sub> interconnected fluidized bed reactor using hematite as oxygen carrier*. Applied Energy 157 (2015) p. 304–313.
- [190] Ma J, Tian X, Wang C, Chen X, and Zhao H. *Performance of a 50 kW<sub>th</sub> coal-fuelled chemical looping combustor*. International Journal of Greenhouse Gas Control 75 (2018) p. 98–106.
- [191] Ge H, Guo W, Shen L, Song T, and Xiao J. *Biomass gasification using chemical looping in a 25kW<sub>th</sub> reactor with natural hematite as oxygen carrier*. Chemical Engineering Journal 286 (2016) p. 174–183.
- [192] Xiao R, Chen L, Saha C, Zhang S, and Bhattacharya S. *Pressurized chemical-looping combustion of coal using an iron ore as oxygen carrier in a pilot-scale unit*. International Journal of Greenhouse Gas Control 10 (2012) p. 363–373.
- [193] Wang X, Jin B, Zhu X, and Liu H. *Experimental Evaluation of a Novel 20 kW<sub>th</sub> in Situ Gasification Chemical Looping Combustion Unit with an Iron Ore as the Oxygen Carrier*. Ind. Eng. Chem. Res. 55 (2016) p. 11775–11784.
- [194] Ma J, Zhao H, Pengjie Niu, Xin Chen, Xin Tian, and Zheng C. *Design and Operation of a 50 kW<sub>th</sub> Chemical Looping Combustion (CLC) Reactor Using Coal as Fuel*. In: *4th International Conference on Chemical Looping*. Nanjing, China; 2016
- [195] Ksepko E, Babinski P, and Ściażko M. *Examination of methane chemical looping combustion with selected natural Fe - based oxygen carrier in 10kW fluidized bed*. In: *12th International Conference on Fluidized Bed Technology*. Krakow, Poland; 2017
- [196] Bayham S, Weber J, Straub D, and Breault R. *Performance of a raw hematite and a manufactured copper - iron oxygen carrier in a 50 - kW natural gas chemical looping system*. In: *12th International Conference on Fluidized Bed Technology*. Krakow, Poland; 2017
- [197] Abad A, Pérez-Vega R, Pérez-Astray A, Mendiara T, de Diego L, Garcá-Labiano F, Gayan P, Izquierdo MT, and Adánez J. *Biomass Combustion with CO<sub>2</sub> Capture by Chemical Looping: Experimental results in a 50 kW<sub>th</sub> Pilot plant*. In: *International Conference on Negative CO<sub>2</sub> Emissions*. Göteborg, Sweden; 2018
- [198] Abad A, Pérez-Vega R, Mendiara T, Gayán P, and Adánez J. *Improving the performance of the chemical looping combustion process with coal in a 50 kW<sub>th</sub> unit*. In: *5th International Conference on Chemical Looping*. Park City, Utah, USA; 2018
- [199] Ohlemüller P, Ströhle J, and Epple B. *Chemical looping combustion of hard coal and torrefied biomass in a 1 MW<sub>th</sub> pilot plant*. International Journal of Greenhouse Gas Control 65 (2017) p. 149–159.
- [200] Yan J, Shen L, Jiang S, Wu J, Shen T, and Song T. *Combustion Performance of Sewage Sludge in a Novel CLC System with a Two-Stage Fuel Reactor*. Energy & Fuels 31 (2017) p. 12570-12581.
- [201] Shen T, Wu J, Shen L, Yan J, and Jiang S. *Chemical Looping Gasification of Coal in a 5 kW<sub>th</sub> Interconnected Fluidized Bed with a Two-Stage Fuel Reactor*. Energy & Fuels 32 (2018) p. 4291-4299.
- [202] Jiang S, Shen L, Yan J, Ge H, and Gu H. *Performance in Chemical Looping Staged Combustion of Coal by Using Hematite as Oxygen Carrier*. Industrial & Engineering Chemistry Research 57 (2018) p. 16486-16494.

- [203] Jiang S, Shen L, Yan J, Ge H, and Song T. *Performance in Coupled Fluidized Beds for Chemical Looping Combustion of CO and Biomass Using Hematite as an Oxygen Carrier*. Energy & Fuels 32 (2018) p. 12721-12729.
- [204] Gu H, Shen L, Zhang S, Niu M, Sun R, and Jiang S. *Enhanced fuel conversion by staging oxidization in a continuous chemical looping reactor based on iron ore oxygen carrier*. Chemical Engineering Journal 334 (2018) p. 829-836.
- [205] Wang X, Wang X, Zhang S, Kong Z, Jin Z, Shao Y, and Jin B. *Test Operation of a Separated-Gasification Chemical Looping Combustion System for Coal*. Energy & Fuels 32 (2018) p. 11411-11420.
- [206] Leion H, Lyngfelt A, Johansson M, Jerndal E, and Mattisson T. *The use of ilmenite as an oxygen carrier in chemical-looping combustion*. Chemical Engineering Research and Design 86 (2008) p. 1017-1026.
- [207] Rydén M, Johansson M, Cleverstam E, Lyngfelt A, and Mattisson T. *Ilmenite with addition of NiO as oxygen carrier for chemical-looping combustion*. Fuel 89 (2010) p. 3523-3533.
- [208] Berguerand N and Lyngfelt A. *Design and operation of a 10 kWth chemical-looping combustor for solid fuels - Testing with South African coal*. Fuel 87 (2008) p. 2713-2726.
- [209] Berguerand N and Lyngfelt A. *The use of petroleum coke as fuel in a 10 kWth chemical-looping combustor*. International Journal of Greenhouse Gas Control 2 (2008) p. 169-179.
- [210] Berguerand N and Lyngfelt A. *Chemical-looping combustion of petroleum coke using ilmenite in a 10 kWth unit - high-temperature operation*. Energy and Fuels 23 (2009) p. 5257-5268.
- [211] Berguerand N and Lyngfelt A. *Operation in a 10 kWth chemical-looping combustor for solid fuel-Testing with a Mexican petroleum coke*. Energy Procedia 1 (2009) p. 407-414.
- [212] Cuadrat A, Linderholm C, Abad A, Lyngfelt A, and Adánez J. *Influence of limestone addition in a 10 kWth Chemical-Looping Combustion unit operated with pet coke*. Energy and Fuels 25 (2011) p. 4818-4828.
- [213] Linderholm C, Lyngfelt A, Cuadrat A, and Jerndal E. *Chemical-looping combustion of solid fuels – operation in 10 kW unit with two fuels, above-bed and in-bed fuel feed and two oxygen carriers, manganese ore and ilmenite*. Fuel 102 (2012) p. 808-822.
- [214] Pröll T, Mayer K, Bolhàr-Nordenkamp J, Kolbitsch P, Mattisson T, Lyngfelt A, and Hofbauer H. *Natural minerals as oxygen carriers for chemical looping combustion in a dual circulating fluidized bed system*. Energy Procedia 1 (2009) p. 27-34.
- [215] Bidwe AR, Mayer F, Hawthorne C, Charitos A, Schuster A, and Scheffknecht G. *Use of ilmenite as an oxygen carrier in chemical looping combustion-batch and continuous dual fluidized bed investigation*. Energy Procedia 4 (2011) p. 433-440.
- [216] Cuadrat A, Abad A, García-Labiano F, Gayán P, de Diego LF, and Adánez J. *Ilmenite as oxygen carrier in a Chemical Looping Combustion system with coal* Energy Procedia 4 (2011) p. 362-369.
- [217] Cuadrat A, Abad A, García-Labiano F, Gayán P, de Diego LF, and Adánez J. *The use of ilmenite as oxygen-carrier in a 500Wth Chemical-Looping Coal Combustion unit*. International Journal of Greenhouse Gas Control 5 (2011) p. 1630-1642
- [218] Cuadrat A, Abad A, García-Labiano F, Gayán P, de Diego LF, and Adánez J. *Effect of operating conditions in Chemical-Looping Combustion of coal in a 500W th unit* International Journal of Greenhouse Gas Control 6 (2012) p. 153-163.
- [219] Cuadrat A, Abad A, García-Labiano F, Gayán P, de Diego LF, and Adánez J. *Relevance of the coal rank on the performance of the in situ gasification chemical-looping combustion*. Chemical Engineering Journal (2012) p. 91-102.

- [220] Mendiara T, Izquierdo MT, Abad A, de Diego LF, García-Labiano F, Gayán P, and Adánez J. *Release of pollutant components in CLC of lignite*. International Journal of Greenhouse Gas Control 22 (2014) p. 15-24.
- [221] Moldenhauer P, Rydén M, Mattisson T, Younes M, and Lyngfelt A. *The use of ilmenite as oxygen carrier with kerosene in a 300 W CLC laboratory reactor with continuous circulation*. Applied Energy Volume 113 (2014) p. 1846–1854.
- [222] Markström P, Lyngfelt A, and Linderholm C. *Chemical-Looping Combustion in a 100 kW unit for Solid Fuels*. Paper presented at 21st International Conference on Fluidized Bed Combustion, Naples, June 3-6, 2012 (2012) p.
- [223] Markström P, Linderholm C, and Lyngfelt A. Operation of a 100 kW chemical-looping combustor with Mexican petroleum coke and Cerrejón coal. In: *2nd International Conference on Chemical Looping*. Darmstadt; 2012
- [224] Markström P, Linderholm C, and Lyngfelt A. *Chemical-looping combustion of solid fuels - Design and operation of a 100 kW unit with bituminous coal*. International Journal of Greenhouse Gas Control 15 (2013) p. 150-162.
- [225] Markström P, Linderholm C, and Lyngfelt A. *Analytical model of gas conversion in a 100 kW chemical-looping combustor for solid fuels - comparison with operational results*. Chem Eng Sci 96 (2013) p. 131-141.
- [226] Linderholm C, Knutsson P, Schmitz M, Markström P, and Lyngfelt A. *Material balances of carbon, sulfur, nitrogen and ilmenite in a 100 kW CLC reactor system*. International Journal of Greenhouse Gas Control 27 (2014) p. 188-202.
- [227] Linderholm C, Schmitz M, Knutsson P, Källén M, and Lyngfelt A. *Use of low-volatile fuels in a 100 kW chemical-looping combustor*. Energy & Fuels 28 (2014) p. 5942-5952.
- [228] Linderholm C, Schmitz M, Knutsson P, and Lyngfelt A. *Chemical-Looping Combustion in a 100-kW Unit using a Mixture of Ilmenite and Manganese Ore as Oxygen Carrier*, . Fuel 166 (2016) p. 533–542.
- [229] Thon A, Kramp M, Hartge E, Heinrich S, and Werther J. *Operational experience with a system of coupled fluidized beds for chemical looping combustion of solid fuels using ilmenite as oxygen carrier*. Applied Energy Volume 118 (2014) p. 309–317.
- [230] Haus J, Hartge E-U, Werther J, and Heinrich S. Effects of a Two-Stage Fuel Reactor on Chemical Looping Combustion with Methane, Bituminous Coal, Lignite and Wood Biomass. In: *5th International Conference on Chemical Looping*. Park City, Utah, USA; 2018
- [231] Moldenhauer P, Rydén M, Mattisson T, Hoteit A, Jamal A, and Lyngfelt A. *Chemical-Looping Combustion with Fuel Oil in a 10 kW Pilot Plant*. Energy & Fuels 28 (2014) p. 5978-5987.
- [232] Abad A, Pérez-Vega R, De Diego L, García-Labiano F, Gayán P, and Adánez J. *Design and operation of a 50 kWth Chemical Looping Combustion (CLC) unit for solid fuels*. Applied Energy 157 (2015) p. 295–303.
- [233] Pérez-Vega R, Abad A, García-Labiano F, Gayán P, Diego LFd, and Adánez J. *Coal combustion in a 50 kWth Chemical Looping Combustion unit: Seeking operating conditions to maximize CO<sub>2</sub> capture and combustion efficiency*. International Journal of Greenhouse Gas Control 50 (2016) p. 80–92.
- [234] Ströhle J, Orth M, and Epple B. *Chemical Looping Combustion of Hard Coal in a 1 MW<sub>th</sub> Pilot Plant Using Ilmenite as Oxygen Carrier*. Applied Energy 157 (2015) p. 288–294.
- [235] Ohlemüller P, Busch J-P, Reitz M, Ströhle J, and Epple B. *Chemical-Looping Combustion of Hard Coal: Autothermal Operation of a 1 MW<sub>th</sub> Pilot Plant*. J. Energy Resour. Technol. 138 (2016) p. 042203-1-042203-7.
- [236] Bao J, Li Z, Sun H, and Cai N. *Continuous Test of Ilmenite-Based Oxygen Carriers for Chemical Looping Combustion in a Dual Fluidized Bed Reactor System*. Ind. Eng. Chem. Res. 52 (2013) p. 14817–14827.

- [237] Vilches TB, Lind F, Rydén M, and Thunman H. Experience of more than 1000h of operation with oxygen carriers and solid biomass at large scale. In: *4<sup>th</sup> International Conference on Chemical Looping*. Nanjing, China; 2016
- [238] Pikkarainen T, Hiltunen I, and Teir S. Piloting of bio-CLC for BECCS. In: *4<sup>th</sup> International Conference on Chemical Looping*. Nanjing, China; 2016
- [239] Langørgen Ø and Saanum I. Chemical Looping Combustion of wood pellets in a 150 kWth CLC reactor. In: *International Conference on Negative CO<sub>2</sub> Emissions*. Göteborg, Sweden; 2018
- [240] Lim S, Yamaguchi D, Tang L, Orellana J, Hadley T, and Bhattacharya S. Evaluation of Chemical Looping Combustion Behavior using Victorian Brown Coal with Ilmenite. In: *5<sup>th</sup> International Conference on Chemical Looping*. Park City, Utah, USA; 2018
- [241] Cheng M, Chen H, Liu L, Li Y, Li Z, Li W, and Cai N. Coal-fired chemical-looping combustion coupled with a high efficient annular carbon stripper. In: *5<sup>th</sup> International Conference on Chemical Looping*. Park City, Utah, USA; 2018
- [242] Lin S-Y, Saito T, Sharma A, Matsumura A, and Hatanaka T. Chemical Looping Combustion by using 100kW Three-Tower CFB Facility. In: *14th International Conference on Greenhouse Gas Control Technologies, GHGT-14*. Melbourne, Australia; 2018
- [243] Penthor S, Fuchs J, Benedikt F, Schmid JC, Mauerhofer AM, Mayer K, and Hofbauer H. First results from an 80 kW dual fluidized bed pilot unit for solid fuels at TU Wien. In: *5<sup>th</sup> International Conference on Chemical Looping*. Park City, Utah, USA; 2018
- [244] Sundqvist S, Mattisson T, Leion H, and Lyngfelt A. *Oxygen release from manganese ores relevant for chemical looping with oxygen uncoupling conditions*. accepted for publication in *Fuel* (2018) p.
- [245] Sundqvist S, Khalilian N, Leion H, Mattisson T, and Lyngfelt A. *Manganese ores as oxygen carriers for chemical-looping combustion (CLC) and chemical-looping with oxygen uncoupling (CLOU)*. *Journal of Environmental Chemical Engineering* 5 (2017) p. 2552–2563.
- [246] Moldenhauer P, Sundqvist S, Mattisson T, and Linderholm C. *Chemical-Looping Combustion of Synthetic Biomass Volatiles with Manganese-Ore Oxygen Carriers*. *International Journal of Greenhouse Gas Control* 71 (2018) p. 239–252.
- [247] Linderholm C, Lyngfelt A, and Dueso C. *Chemical-looping combustion of solid fuels in a 10 kW reactor system using natural minerals as oxygen carrier*. *Energy Procedia* 37 (2013) p. 598-607.
- [248] Schmitz M, Linderholm C, Hallberg P, Sundqvist S, and Lyngfelt A. *Chemical-Looping Combustion of Solid Fuels using Manganese Ores as Oxygen Carriers*. *Energy Fuels* 30 (2016) p. 1204–1216.
- [249] Schmitz M and Linderholm C. *Chemical looping combustion of biomass in 10 and 100 kW pilots - Analysis of conversion and lifetime using a sintered manganese ore*. Submitted for publication (2018) p.
- [250] Sozinho T, Pelletant W, Gauthier T, and Stainton H. Main results of the 10 kW coal pilot plant operation. . In: *2nd Int. Conf. on Chemical Looping*. Darmstadt; 2012
- [251] Xu L, Sun H, Li Z, and Cai N. *Experimental study of copper modified manganese ores as oxygen carriers in a dual fluidized bed reactor*. *Applied Energy* 162 (2016) p. 940–947.
- [252] Linderholm C, Schmitz M, Biermann M, Hanning M, and Lyngfelt A. *Chemical-looping combustion of solid fuel in a 100 kW unit using sintered manganese ore as oxygen carrier*. *International Journal of Greenhouse Gas Control* 65 (2017) p. 170-181.
- [253] Pikkarainen T and Hiltunen I. Chemical looping combustion of solid biomass - performance of ilmenite and braunite as oxygen carrier materials. In: *25<sup>th</sup> European Biomass Conference and Exhibition*. Stockholm, Sweden; 2017
- [254] Vilches TB, Lind F, Rydén M, and Thunman H. *Experience of more than 1000 h of operation with oxygen carriers and solid biomass at large scale*. *Applied Energy* 190 (2017) p. 1174–1183.

- [255] Abad A, Gayán P, Mendiara T, Bueno JA, García-Labiano F, de Diego LF, and Adánez J. *Assessment of the improvement of chemical looping combustion of coal by using a manganese ore as oxygen carrier*. Fuel Processing Technology 176 (2018) p. 107-118.
- [256] Hansen PFB, Dam-Johansen K, and Østergaard K. *High-temperature reaction between sulphur dioxide and limestone — V. The effect of periodically changing oxidizing and reducing conditions*. Chemico, Engineering Science 48 (1993) p. 1325-1341.
- [257] Lyngfelt A and Leckner B. *SO<sub>2</sub> capture in fluidized bed boilers: re-emission of SO<sub>2</sub> due to reduction of CaSO<sub>4</sub>*. Chemical Engineering Science 44 (1989) p. 207-213.
- [258] Fernández MJ, Lyngfelt A, and Steenari B-M. *Reaction between limestone and SO<sub>2</sub> under Conditions Alternating between Oxidizing and Reducing. The Effect of Short Cycle Times*. Energy & Fuels 14 p. 654-662.
- [259] Abdulally I, Beal C, Andrus H, Epple B, Lyngfelt A, and White B. Alstom's Chemical Looping Technology, Program Update. In: *11th Annual Conference on Carbon Capture Utilization & Sequestration* Pittsburgh, Pennsylvania; 2014
- [260] Lyngfelt A. *Chemical-looping combustion of solid fuels*. Greenhouse Gas Issues (2007) p. 9-10.
- [261] Shen L, Wu J, Xiao J, Song Q, and Xiao R. *Chemical-looping combustion of biomass in a 10 kW reactor with iron oxide as an oxygen carrier*. Energy and Fuels 23 (2009) p. 2498-2505.
- [262] Riffart S, Hoteit A, Yazdanpanah M, Pelletant W, and Surla K. *Construction and operation of a 10kW CLC unit with circulation configuration enabling independent solid flow control*. Energy Procedia (GHGT-10) in press (2010) p.
- [263] Thon A, Kramp M, Hartge EU, Heinrich S, and Werther J. *Operational experience with a system of coupled fluidized beds for chemical looping combustion of solid fuels using ilmenite as oxygen carrier* Applied Energy Volume 118 (2014) p. 309–317.
- [264] Bayham S, Kim H, Wang D, Tong A, Zeng L, McGiveron O, Kathe M, Chung E, Wang W, Majumder A, and Fan L-S. *Iron-based coal direct chemical looping combustion process: 200-h continuous operation of a 25-kW<sub>th</sub> subpilot unit* Energy and Fuels 27 (2013) p. 1347-1356.
- [265] Siriwardane R, Tian H, Riley J, Benincosa W, Straub D, Weber J, and Richards G. *Commercial Scale Preparations of CuO-Fe<sub>2</sub>O<sub>3</sub>-Alumina Oxygen Carrier with various techniques: Bench Scale Fluidized Bed Tests with Coal/Air and Methane/air and Pilot Scale (51 Kw<sub>th</sub>) Chemical Looping Combustion Tests with Methane/Air*. In: *4<sup>th</sup> International Conference on Chemical-Looping*. Nanjing, China; 2016
- [266] Thunman H, Lind F, Breitholtz C, Berguerand N, and Seemann M. *Using an oxygen-carrier as bed material for combustion of biomass in a 12-MW<sub>th</sub> circulating fluidized-bed boiler*. Fuel 113 (2013) p. 300-309.
- [267] Rydén M, Hanning M, Corcoran A, and Lind F. *Oxygen carrier aided combustion (OCAC) of wood chips in a semi-commercial circulating fluidized bed boiler using manganese ore as bed material*. Applied Science 6 (2016) p. 1-19.
- [268] Lind F, Corcoran A, Andersson B-Å, and Thunman H. *12,000 hours of operation with oxygen-carriers in industrially relevant scale*. VGB PowerTech Journal 7 (2017) p.
- [269] Lyngfelt A, Mattisson T, Rydén M, and Linderholm C. *The Multipurpose Dual Fluidized-Bed (MDFB) for biomass – providing ultimate flexibility to achieve the desired mix of heat/power, fuels, negative emissions, power grid stabilization, low NO<sub>x</sub> and benefits with respect to fouling/corrosion*. In: *International Conference on Negative CO<sub>2</sub> Emissions*. Göteborg, Sweden; 2018
- [270] Abad A, Adánez J, Gayán P, Diego LFD, García-Labiano F, and Sprachmann G. *Conceptual design of a 100 MW<sub>th</sub> CLC unit for solid fuel combustion*. Applied Energy 157 (2015) p. 462-474.

- [271] Lyngfelt A and Leckner B. *A 1000 MW<sub>th</sub> Boiler for Chemical-Looping Combustion of Solid Fuels – Discussion of Design and Costs*. Applied Energy 157 (2015) p. 475-487.
- [272] Ekström C, Schwendig F, Biede O, Franco F, Haupt G, de Koeijer G, Papapavlou C, and Røkke PE. *Techno-Economic Evaluations and Benchmarking of Pre-combustion CO<sub>2</sub> Capture and Oxy-fuel Processes Developed in the European ENCAP Project*. Energy Procedia 1 (2009) p. 4233-4240.
- [273] Anon., *The Costs of CO<sub>2</sub> capture – Post-demonstration CCS in the EU – Zero Emission Platform*. 2011, The European Technology Platform for Zero Emission Fossil Fuel Power Plants
- [274] Haaf M, Ohlemüller P, Ströhle J, and Epple B. Assessment of the Potential for Negative CO<sub>2</sub> Emissions by the Utilization of Alternative Fuels in 2<sup>nd</sup> Generation CCS Processes. In: *International Conference on Negative CO<sub>2</sub> Emissions*. Göteborg, Sweden; 2018
- [275] Ajdari S, Gardarsdóttir SO, Normann F, and Andersson K. *Techno-economic evaluation of integrated NO<sub>x</sub> and SO<sub>x</sub> removal in pressurized flue gas systems for carbon capture applications*. Submitted for publication (2019) p.
- [276] Lyngfelt A. Financing of Future Negative Emissions - Bringing it All Back Home or Tangled up in Blue. In: *International Conference on Negative CO<sub>2</sub> Emissions*. Göteborg, Sweden; 2018
- [277] Aines RD and Mccoy ST. Making Negative Emissions Economically Feasible: The View from California. In: *International Conference on Negative CO<sub>2</sub> Emissions*. Göteborg, Sweden; 2018
- [278] Aines RD and Mccoy ST. Making Negative Emissions Economically Feasible: The View from California, <https://www.youtube.com/watch?v=aeKOPIXAe3s> (YouTube video of presentation) In: *YouTube channel for International Conference on Negative CO<sub>2</sub> Emissions*. Göteborg, Sweden; 2018
- [279] Anderson K and Peters G. *The trouble with negative emissions. Reliance on negative-emission concepts locks in humankind's carbon addiction*. Science 354 (2016) p. 182-183.
- [280] Lyngfelt A. *Financing of Future Negative CO<sub>2</sub> Emissions - Bringing it All Back Home or Tangled up in Blue*. Submitted for publication (2018) p.
- [281] Zevenhoven M, Sevonius C, Salminen P, Lindberg D, Brink A, Yrjas P, and Hupa L. *Defluidization of the oxygen carrier ilmenite – Laboratory experiments with potassium salts*. Energy 148 (2018) p. 930-940.
- [282] Eriksson J-E, Zevenhoven M, Yrjas P, Hupa L, and Brink A. *Assessment of corrosion in bio-CLC, Negative CO<sub>2</sub> Emissions with Chemical Looping Combustion of Biomass, internal project report, Åbo Akademi*. (2018) p.