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Stationary source emissions — Determination of greenhouse gas emissions in energy-intensive industries —

Part 6: Ferroalloys and silicon industry

*Émissions de sources fixes — Détermination des émissions des gaz à
effet de serre dans les industries à forte intensité énergétique —*

Partie 6: Industrie des ferro-alliages et du silicium



Reference number
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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see www.iso.org/iso/foreword.html.

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A list of all parts in the ISO 19694 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Introduction

0.1 Overview of the ferro-alloy manufacturing process

Ferroalloy production involves a metallurgical reduction process that results in significant carbon dioxide emissions. These emissions are the results of a carbothermic reaction which is intrinsic to the process. In ferroalloy production, ore, carbon materials and slag forming materials are mixed and heated to high temperatures for smelting.

Smelting in an electric arc furnace is accomplished by conversion of electrical energy to heat. An alternating current applied to the electrodes creates current to flow through the charge between the electrode tips. The heat is produced by the electric arcs and by the resistance in the charge materials. Emissions from the smelting process are therefore not to combustion emissions. The furnaces can be open, semi-closed or closed. Submerged electric arc furnaces with graphite electrodes or self-baking Søderberg electrodes are used (see [Figure 1](#)).

The reduction process is the main source of direct CO₂ emissions. Other CO₂ sources include direct emissions from calcination of calcium, magnesium and other carbonates (e.g. limestone) in some processes and from non-smelting fuels (e.g. dryers for ladles and refractory linings), room heating and indirect emissions from, for example, external power production.

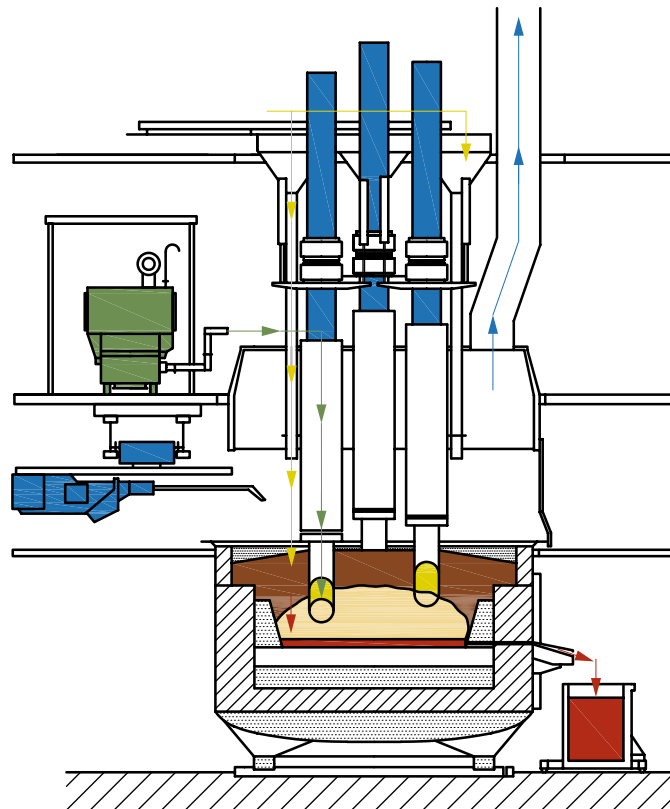


Figure 1 — Submerged electric arc furnace

0.2 CO₂ from the smelting of raw materials

In the smelting process, CO₂ is released due to the carbothermic reduction of the metallic oxides occurring with the consumption of both carbonaceous reductants and carbon-based electrodes. The carbon in the reductants reacts with oxygen from the metal oxides to form CO and then CO₂ (in different ways depending on the process), and the ores are reduced to molten base metals. For the calculation, the assumption is that all CO is assumed to be converted in the furnace to CO₂.

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The reductant carbon is used in the form of coke, coal, pet coke, anthracite, charcoal and wood chips. The first four are fossil-based and the charcoal and wood chips are bio-carbon.

In the carbothermic process, only the fixed carbon content is used as a reducing agent, which means that volatile matter, ashes and moisture mostly leave the furnace with the off-gas and slag.

The nature of reducing agents, price and electrodes depends on the localization of the plant, the raw material availability and it is presented in [Table 1](#). It is variable from one site to another and from one year to another and also from one ferro-alloy to another.

Table 1 — Type of reducing agents and electrodes used in the electrometallurgy sector

Reducing agents	Electrodes
Crude petroleum coke	Graphite electrode
Calcinated petroleum coke	Prebaked electrodes
Coal coke	Söderberg paste
Coke from coal	Composite electrode
Wood	—
Calcinated wood	—
Charcoal	—
Graphite powder	—
Anthracite	—

CO₂ emissions are estimated with and calculated from the consumption of the reducing agents and electrodes, their carbon content, and the carbon content of the final products.

NOTE The basic calculation methods used in this document are compatible with the 2006 IPCC Guidelines for National Greenhouse Gas Inventories issued by the Intergovernmental Panel on Climate Change (IPCC)^[1].

Ores and reducing agent react to form ferro-alloys or metal, CO₂ and dust and other by-product (i.e. slags); amount of carbon can be found in the products

Default emission factors suggested in these documents are used, except where more recent, industry-specific data has become available.