

## **A transient method for characterizing flow regimes in a Circulating Fluid Bed**

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### **Abstract**

In recent years, although an increase number of literature have been devoted to circulating fluidized bed, the prediction of velocities over which different fluidization regimes exist is still difficult. In this study, a transient method was applied which readily allows one to identify operational features and critical transitions. The method is based on stopping the solids flow rate into the riser when riser is operating in fully dense transport regime. The analysis of transient pressure drop data across the riser during a solids flow cut-off experiment against its time derivative demonstrate the three distinct operating regimes that exist as the gas deplete the solid out of the riser. The transient was compared to data taken under steady state operations using statistically designed experiments. Results indicated that although there were significant differences when comparing operations in dilute conditions, there were no significant differences between the two methods in the fast fluidized and dense transport regimes. The transient method was capable of reproducing the solids circulation dependence on riser solids holdup and on the axial pressure profile. This transient method offers an accurate, easy, rapid, and reproducible means of characterizing CFB operations over a wide range of flow conditions. The lack of accuracy in the dilute regime is conjectured to be due to the wide particle size distribution that resulted in segregation during the transient testing.

### **1. Introduction**

Circulating fluidized beds (CFB) and pneumatic conveying of solids have been widely used in chemical and petroleum industries, including pressurized circulating fluidized bed combustion, catalytic cracking, and aluminum oxide calcination. Understanding of the flow regimes in CFB risers is the key to successful design and scale-up of CFB systems. Numerous studies on CFB riser's regimes are available in the literature [1-6]. Due to restricted range of operating conditions, generally these studies are carried out for the specific regimes (i.e. dilute, fast fluidized, and dense). For instance, studies on the dilute regime do not provide any information on the neighboring regimes, such as fast fluidized regime. Therefore, it is difficult to recognize the operating conditions for fast fluidized regime. There is a lot of

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# A Transient Method For Characterizing Flow Regimes In A

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## **Table of Contents A Transient Method For Characterizing Flow Regimes In A**

1. Understanding the eBook A Transient Method For Characterizing Flow Regimes In A
  - The Rise of Digital Reading A Transient Method For Characterizing Flow Regimes In A
  - Advantages of eBooks Over Traditional Books
2. Identifying A Transient Method For Characterizing Flow Regimes In A
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an A Transient Method For Characterizing Flow Regimes In A
  - User-Friendly Interface
4. Exploring eBook Recommendations from A Transient Method For Characterizing Flow Regimes In A
  - Personalized Recommendations
  - A Transient Method For Characterizing Flow Regimes In A User Reviews and Ratings
  - A Transient Method For Characterizing Flow Regimes In A and Bestseller Lists
5. Accessing A Transient Method For Characterizing Flow Regimes In A Free and Paid eBooks
  - A Transient Method For Characterizing Flow Regimes In A Public Domain eBooks
  - A Transient Method For Characterizing Flow Regimes In A eBook Subscription Services
  - A Transient Method For Characterizing Flow Regimes In A Budget-Friendly Options
6. Navigating A Transient Method For Characterizing Flow Regimes In A eBook Formats
  - ePub, PDF, MOBI, and More
  - A Transient Method For Characterizing Flow Regimes In A Compatibility with Devices
  - A Transient Method For Characterizing Flow Regimes In A Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of A Transient Method For Characterizing Flow Regimes In A
  - Highlighting and Note-Taking A Transient Method For Characterizing Flow Regimes In A
  - Interactive Elements A Transient Method For Characterizing Flow Regimes In A

8. Staying Engaged with A Transient Method For Characterizing Flow Regimes In A
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers A Transient Method For Characterizing Flow Regimes In A
9. Balancing eBooks and Physical Books A Transient Method For Characterizing Flow Regimes In A
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection A Transient Method For Characterizing Flow Regimes In A
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine A Transient Method For Characterizing Flow Regimes In A
  - Setting Reading Goals A Transient Method For Characterizing Flow Regimes In A
  - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of A Transient Method For Characterizing Flow Regimes In A
  - Fact-Checking eBook Content of A Transient Method For Characterizing Flow Regimes In A
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
  - Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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