

# Carbon Capture from cement production through mineralisation

Responsible for 8% of global greenhouse gas emissions and set to grow substantially, the cement sector is a key target for emissions reduction technologies. Stephen B. Harrison, sbh4 consulting, reviews some of the companies developing commercial carbon capture solutions.

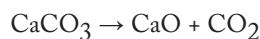
Concrete is a composite material and the most frequently used building material worldwide. As a composite, it consists of three main components: cement, sand, and aggregate. The exact mixing ratio depends on the application and required strength, with a 'normal mix' being 1 part cement, 2 parts sand, and 4 parts aggregate (1:2:4). The annual global cement production in 2019 was 4.2 Giga Tonnes, of which 55% was produced in China.

Typically, concrete is produced locally and distributed within a 400 km radius. The fine and coarse aggregates are mined in local quarries and the sand must be of certain size and grain quality. Desert sands, for example those in the Sahara are not suitable. This has led to shortages in sand supply in some regions.

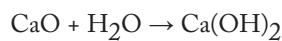
Up to 1 Tonne of CO<sub>2</sub> is released into the atmosphere during the production of 1 Tonne of cement production. The raw material, mainly limestone, accounts for 65% of the emissions, and the fuel consumption of the production for the remaining 35%. Due to the large demand for concrete, the CO<sub>2</sub> released from cement making accounts for 8% of global emissions – four times more than the global aviation industry.

## Non-Hydraulic Cement

The most popular non-hydraulic cement in the past millennia was lime mortar, a mixture of lime, sand, and water. Limestone is burnt and decomposed into quicklime (carbon carbonate) and carbon dioxide above 900°C.

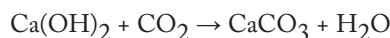


The quicklime is then mixed with water, and optionally sand, to form calcium hydroxide.



The lime mortar is then ready to use. After

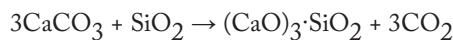
the excess water has evaporated, carbonation starts.



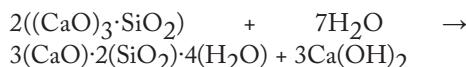
This mineralisation takes carbon dioxide from the atmosphere but is very slow due to low partial pressure of CO<sub>2</sub>. In theory all CO<sub>2</sub> which was released during limestone burning should eventually captured again at the end of the carbonation process.

## Hydraulic Cement

Portland cement is the most common type of hydraulic cement. It has a higher strength than quicklime and is water resistant after curing is completed. Within the Portland cement production process limestone and clay, with a high silicon dioxide content, are mixed and preheated to 900°C where CO<sub>2</sub> from the calcium carbonate is released as a gas. In the cement making rotary kiln, the components are sintered at temperatures of up to 1450°C into complex compounds such as tricalcium silicate.



The concrete curing starts with the mixing of cement and water. Hydration occurs during curing with the forming of calcium-silicate hydrates.



Under typical conditions it can take up to 28 days until 90% of the strength is reached. Over several decades atmospheric carbon dioxide diffuses into the concrete and converts the calcium hydroxide into calcium carbonate to further strengthen the concrete. However, the maximum theoretical carbon sequestration capacity is only 50% of the raw material CO<sub>2</sub> emissions.

## Carbon Cure – Carbon Dioxide Concrete Injection

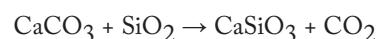
The Canadian-based company Carbon Cure takes advantage of the sequestration capability of concrete by injecting an additional 1.5 kg of CO<sub>2</sub> per Tonne of cement (or 0.482 kg CO<sub>2</sub> per m<sup>3</sup> of concrete) during concrete preparation. This increases the strength of the concrete.

Since the strength increases, up to 16.9 kg of cement can be removed from each cubic metre of concrete and replaced with sand. Due to the high CO<sub>2</sub> emissions of cement about 17 kg CO<sub>2</sub> are saved per cubic metre of concrete. The cement avoidance accounts for 97.7% of total emissions reduction from this process, rather than the additional binding of CO<sub>2</sub> to the cement.

The technology is readily available to reduce the CO<sub>2</sub> emissions of concrete by 5% and can be scaled up immediately, as few changes are necessary in the concrete production process. Several reference projects exist in the US, with the Amazon HQ2 the largest project to date, achieving a net saving of 1,144 Tonnes of CO<sub>2</sub>.

## Solidia – Alteration of the Cement Production

The US based company Solidia Technologies goes one step further and alters the cement production process itself. Instead of a 3:1 ratio of calcium carbonate to silica within Portland cement, the ratio was altered to a 1:1 and the burning temperature reduced to 1250°C instead of 1450°C. This creates synthetic calcium silicate (Wollastonite) instead of tricalcium silicate.



Hence, the CO<sub>2</sub> emissions in cement manufacturing reduces by approximately 30% in-

cluding both the emissions from limestone and the energy demand. The Solidia concrete is cured at 60°C and ambient pressure mainly by CO<sub>2</sub> with just a minimal amount of water, instead of up to 50% water at Portland cement-based concrete. This makes Solidia concrete favourable for precast concrete producers.

Considering the CO<sub>2</sub> sequestration during curing plus the CO<sub>2</sub> emission avoidance in cement production, the CO<sub>2</sub> footprint can be lowered to 550 kg of CO<sub>2</sub> per tonne of cement, which is equal to a reduction of about 50%. The technology is currently offered by LafargeHolcim in the US to precast concrete producers.



## Blue Planet – Carbon Dioxide Sequestered Aggregates

The two technologies presented so far have a certain GHG reduction potential. Nevertheless, there are still dedicated CO<sub>2</sub> emissions associated with them. To sequester anthropogenic CO<sub>2</sub> emissions Blue Planet suggested a new mineralisation process. It uses recycled concrete as base material. The crushed concrete contains the aggregate and cement fraction. During the process, the aggregate is upcycled and can be reused as aggregate in new concrete. Whereas the old cement fractions are mineralised with CO<sub>2</sub> to form a new layer of calcium carbonate around the old cement parts, which basically acts as an incubation seed.

The CO<sub>2</sub>-sequestered aggregate is used in addition to the upcycled aggregate in newly mixed concrete. In a first reference project the aggregates were used at the Interim Boarding Area B at San Francisco International Airport in 2016.

To store the CO<sub>2</sub> as calcium carbonate, a raw material with a high calcium hydroxide or calcium oxide content is necessary. One example for this is Portland cement where the included calcium hydroxide is used for CO<sub>2</sub> storage, like the Carbon Cure approach. Whereas other raw materials are fly ash (CaO 10–40%, MgO 0–10%) and steel slag (CaO 40–50%, MgO 5–10%). These materials contain also other metal oxides in high concentration, for example MgO. These can be also utilised to sequester carbon dioxide by the formation of carbonates (for example MgO + CO<sub>2</sub> ⇌ MgCO<sub>3</sub>).

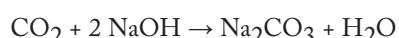
The Blue Planet process reduces CO<sub>2</sub> emissions by 100 kg per Tonne of concrete. This

*The cement industry is responsible for 8% global GHG emissions*

equates to about 220 kg CO<sub>2</sub> per m<sup>3</sup> concrete. Considering a cement content of 320 kg per m<sup>3</sup> of concrete, this results in a reduction of about 0.65 Tonnes of CO<sub>2</sub> per Tonne of Portland cement, and would therefore compensate for the raw material CO<sub>2</sub> emissions of the cement production.

## SkyMine – Turning Flue Gas into Baking Soda

Some processes above require modifications to the concrete and cement production process. The company CarbonFree has developed a new process, where the CO<sub>2</sub> capture and sequestration can be directly connected to standard cement kilns. The flue gas is directed into an absorber column where CO<sub>2</sub> is stripped using an aqueous sodium hydroxide solution.



In a second step the sodium hydroxide is reacted with additional flue gas to produce sodium hydrogen carbonate, commonly known as baking soda.



The sodium hydroxide is produced on a chloralkali electrolyser. This electrolysis is responsible for 87% of the total energy demand, which reads as 8.3 GJ per Tonne of captured CO<sub>2</sub>. This is very similar to state-of-the art Direct Air Capture processes such as CarbonEngineering or Climeworks. If the avoided energy requirement to produce the electroly-

sis by-products (HCl, NaClO, NaOH) is accounted for in the overall carbon footprint analysis, then the energy demand for the CO<sub>2</sub> sequestration drops to 2.8 GJ per Tonne of captured CO<sub>2</sub>.

In a first demonstration of the SkyMine process, 90% of the CO<sub>2</sub> from a slipstream at the San Antonio cement factory is being captured. It has operated since 2016 and captures 75,000 Tonnes of CO<sub>2</sub> annually. Food-grade baking soda from the process is supplied into the consumer market. Ultimately, the captured CO<sub>2</sub> is released into the atmosphere in ovens during the baking process.

## Global imperative to maintain the pace of innovation

The cement industry is responsible for 8% global GHG emissions. The worldwide market is expected to grow by up to 25% until 2050. Due to the sheer size of the cement industry and the lack of affordable alternatives to cement, it remains a global imperative to reduce the impact of CO<sub>2</sub> emissions from this sector. Several technologies may have the potential to alleviate the problem, but the field is still open to see which carbon capture technology will dominate within this sector.

**More information**

[sbh4.de](http://sbh4.de)

