

State of California
Air Resources Board

Method 16A

**Determination of Total Reduced Sulfur Emissions
from Stationary Sources (Impinger Technique)**

Adopted: January 22, 1987

Amended: _____

Note: this document consists of the text of the proposed amendment to Method 16A. Proposed deletions are noted by **graphic screen** and proposed additions are noted by underline.

Method 16A - Determination of Total Reduced Sulfur Emissions from Stationary Sources (Impinger Technique)

1. APPLICABILITY, PRINCIPLE, INTERFERENCES, PRECISION, AND BIAS

1.1 Applicability.

This method is applicable to the determination of total reduced sulfur (TRS) emissions from recovery boilers, lime kilns, and smelt dissolving tanks at kraft pulp mills, and from other sources when specified in an applicable subpart of the regulations. The TRS compounds include hydrogen sulfide, methyl mercaptan, dimethyl sulfide, and dimethyl disulfide.

The flue gas must contain at least 1 percent oxygen for complete oxidation of all TRS to sulfur dioxide (SO₂). The lower detectable limit is 0.1 ppm SO₂ when sampling at 2 liters/min for 3 hours or 0.3 ppm when sampling at 2 liters/min for a 1 hour. The upper concentration limit of the method exceeds TRS levels generally encountered at kraft pulp mills.

1.2 Principle. An integrated gas sample is extracted from the stack. SO₂ is removed selectively from the sample using a citrate buffer solution. TRS compounds are then thermally oxidized to SO₂, collected in hydrogen peroxide as sulfate, and analyzed by the Method 6 barium-thorin titration procedure.

Any modification of this method beyond those expressly permitted shall be considered a major modification subject to the approval of the Executive Officer. The term Executive Officer as used in this document shall mean the Executive Officer of the Air Resources Board (ARB), or his or her authorized representative.

1.3 Interferences.

TRS compounds other than those regulated by the emission standards, if present, may be measured by this method. Therefore, carbonyl sulfide, which is partially oxidized to SO₂ and may be present in a lime kiln exit stack, would be a positive interferant.

Particulate matter from the lime kiln stack gas (primarily calcium carbonate) can cause a negative bias if it is allowed to enter the citrate scrubber; the particulate matter will cause the pH to rise and H₂S to be absorbed prior to oxidation. Furthermore, if the calcium carbonate enters the hydrogen peroxide impingers, the calcium will precipitate sulfate ion. Proper use of the particulate filter described in Section 2.1.3 will eliminate this interference.

1.4 Precision and Bias.

Relative standard deviations of 2.0 and 2.6 percent were obtained when sampling at a recovery boiler for 1 and 3 hours, respectively.

In a separate study at a recovery boiler, Method 16A was found to be unbiased relative to Method 16. Comparison of Method 16A with Method 16 at a lime kiln indicated that there was no bias in Method 16A. However, instability of the source emissions adversely affected the comparison. The precision of Method 16A at the lime kiln was similar to that obtained at the recovery boiler.

Relative standard deviations of 2.7 and 7.7 percent have been obtained for system performance checks.

2. APPARATUS

2.1 Sampling. The sampling train is shown in Figure 16A-1 and component parts are discussed below. Modifications to this sampling train are acceptable provided the system performance check (Section 4.3) is met.

Note: Mention of trade names or specific products does not constitute endorsement by the Air Resources Board (ARB).

2.1.1 Probe. Teflon (mention of trade names or specific products does not constitute endorsement by the Air Resources Board (ARB)) tubing, 0.6-cm (1/4-in.) diameter, sequentially wrapped with heat-resistant fiber strips, a rubberized heat tape (plug at one end), and heat-resistant adhesive tape. A flexible thermocouple or other suitable temperature measuring device should be placed between the Teflon tubing and the fiber strips so that the temperature can be monitored to prevent softening of the probe. The probe should be sheathed in stainless steel to provide in-stack rigidity. A series of bored-out stainless steel fittings placed at the front of the sheath will prevent moisture and particulate from entering between the probe and sheath. A 0.6-cm (1/4-in.) Teflon elbow (bored out) should be attached to the inlet of the probe, and a 2.54-cm (1-in.) piece of Teflon tubing should be attached at the open end of the elbow to permit the opening of the probe to be turned away from the particulate stream; this will reduce the amount of particulate drawn into the sampling train. The sampling probe is depicted in Figure 16A-2.

2.1.2 Probe Brush. Nylon bristle brush with handle inserted into a 3.2-mm (1/8-in.) Teflon tubing. The Teflon tubing should be long enough to pass the brush through the length of the probe.

2.1.3 Particulate Filter. 50-mm Teflon filter holder and a 1 μm to 2 μm 1- to 2- μm porosity Teflon filter (available through Savillex Corporation, 5325 Highway 101, Minnetonka, Minnesota 55343). The filter holder must be maintained in a hot box at a temperature sufficient to prevent moisture condensation. A temperature of 121°C (250°F) was found to be sufficient when testing a lime kiln under sub-freezing ambient conditions.

2.1.4 SO₂ Scrubber. Three 300 ml 300-ml Teflon segmented impingers connected in series with flexible, thick-walled, Teflon tubing. (Impinger parts and tubing available through Savillex.) The first two impingers contain 100 mL ml of citrate buffer each and the third impinger is initially dry. The tip of the tube inserted into

the solution should be constricted to less than 3 mm (1/8 in.) ID and should be immersed to a depth of at least 5 cm (2 in.).

2.1.5 Combustion Tube. Quartz glass tubing with an expanded combustion chamber 2.54 cm (1 in.) in diameter and at least 30.5 cm (12 in.) long. The tube ends should have an outside diameter of 0.6 cm (1/4 in.) and be at least 15.3 cm (6 in.) long. This length is necessary to maintain the quartz-glass connector at ambient temperature and thereby avoid leaks. Alternatively, the outlet may be constructed with a 90-degree glass elbow and socket that would fit directly onto the inlet of the first peroxide impinger.

2.1.6 Furnace. A furnace of sufficient size to enclose the combustion chamber of the combustion tube with a temperature regulator capable of maintaining the temperature at 800 ± 100 °C. The furnace operating temperature should be checked with a thermocouple to ensure accuracy.

2.1.7 Peroxide Impingers, Stopcock Grease, Thermometer, Drying Tube, Valve, Pump, Barometer, and Vacuum Gauge. Same as in Method 6, Sections 2.1.2, 2.1.4, 2.1.6, 2.1.7, 2.1.8, 2.1.11, and 2.1.12, respectively.

2.1.8 Rate Meter. Rotameter, or equivalent, accurate to within 5 percent at the selected flow rate of 2 liters/min.

2.1.9 Volume Meter. Dry gas meter capable of measuring the sample volume under the sampling conditions of 2 liters/min with an accuracy of ± 2 percent.

2.1.10 Polyethylene Bottles. 250 ml 250-ml bottles for hydrogen peroxide solution recovery.

2.2 Sample Preparation and Analysis. Same as in Method 6, Section 2.3, except a 10-ml buret with 0.05-ml graduations is required and the spectrophotometer is not needed.

3. REAGENTS

Unless otherwise indicated, all reagents must conform to the specifications established by the Committee on Analytical Reagents of the American Chemical Society. When such specifications are not available, the best available grade shall be used.

3.1 Sampling. The following reagents are needed:

3.1.1 Water. Same as in Method 6, Section 3.1.1.

3.1.2 Citrate Buffer. Dissolve 300 g of potassium citrate (or 284 g of sodium citrate) and 41 g of anhydrous citric acid in 1 liter of water (200 ml is needed per test). Adjust the pH to between 5.4 and 5.6 with potassium citrate or citric acid, as required.

3.1.3 Hydrogen Peroxide, 3 percent. Same as in Method 6, Section 3.1.3 (40 ml is needed per sample).

3.1.4 Recovery Check Gas.

Hydrogen sulfide (100 ppm or less) in nitrogen, stored in aluminum cylinders. Verify the concentration by Method 11 or by gas chromatography where the instrument is calibrated with an H₂S permeation tube as described below. For Method 11, the standard deviation should not exceed 5 percent on at least three **20 minute** 20-minute runs.

Alternatively, hydrogen sulfide recovery gas generated from a permeation device gravimetrically calibrated and certified at some convenient operating temperature may be used. The permeation rate of the device must be such that at a dilution gas flow rate of 3 liters/min., an H₂S concentration in the range of the stack gas or within 20 percent of the standard can be generated.

3.1.5 Combustion Gas. Gas containing less than 50 ppb reduced sulfur compounds and less than 10 ppm total hydrocarbons. The gas may be generated from a clean-air system that purifies ambient air and consists of the following components: diaphragm pump, silica gel drying tube, activated charcoal tube, and flow rate measuring device. Flow from a compressed air cylinder is also acceptable.

3.2 Sample Recovery and Analysis. Same as in Method 6, Sections 3.2.1 and 3.3.

4. PROCEDURE

4.1 Sampling. Before any source sampling is done, conduct two 30-minute system performance checks in the field as detailed in Section 4.3 to validate the sampling train components and procedure (optional).

4.1.1 Preparation of Collection Train. For the SO₂ scrubber, measure 100 ml of citrate buffer into the first and second impingers; leave the third impinger empty. Immerse the impingers in an ice bath, and locate them as close as possible to the filter heat box. The connecting tubing should be free of loops. Maintain the probe and filter temperatures sufficiently high to prevent moisture condensation, and monitor with a suitable temperature indicator.

For the Method 6 part of the train, measure 20 ml of 3 percent hydrogen peroxide into the first and second midget impingers. Leave the third midget impinger empty, and place silica gel in the fourth midget impinger. Alternatively, a silica gel drying tube may be used in place of the fourth impinger. Maintain the oxidation furnace at 800 ± 100 °C. Place crushed ice and water around all impingers.

4.1.2 Citrate Scrubber Conditioning Procedure. Condition the citrate buffer scrubbing solution by pulling stack gas through the Teflon impingers and bypassing

all other sampling train components. A purge rate of 2 liters/min for 10 minutes has been found to be sufficient to obtain equilibrium. After the citrate scrubber has been conditioned, assemble the sampling train, and conduct (optional) a leak-check as described in Method 6, Section 4.1.2.

4.1.3 Sample Collection.

Same as in Method 6, Section 4.1.3, except the sampling rate is 2 liters/min (± 10 percent) for 1 or 3 hours. After the sample is collected, remove the probe from the stack, and conduct (mandatory) a post-test leak check as described in Method 6, Section 4.1.2. The 15-minute purge of the train following collection should not be performed. After each 3-hour test run (or after three 1-hour samples), conduct one system performance check (see Section 4.3) to determine the reduced sulfur recovery efficiency through the sampling train. After this system performance check and before the next test run, rinse and brush the probe with water, replace the filter, and change the citrate scrubber (recommended but optional).

In Method 16, a test run is composed of 16 individual analyses (injections) performed over a period of not less than 3 hours or more than 6 hours. For Method 16A to be consistent with Method 16, the following may be used to obtain a test run: (1) collect three 60-minute samples or (2) collect one 3-hour sample. (Three test runs constitute a test.)

4.2 Sample Recovery. Disconnect the impingers. Quantitatively transfer the contents of the midget impingers of the Method 6 part of the train into a leak-free polyethylene bottle for shipment. Rinse the three midget impingers and the connecting tubes with water, and add the washings to the same storage container. Mark the fluid level. Seal and identify the sample container.

4.3 System Performance Check. A system performance check is done (1) to validate the sampling train components and procedure (prior to testing; optional) and (2) to validate a test run (after a run). Perform a check in the field prior to testing consisting of at least two samples (optional), and perform an additional check after each 3-hour run or after three 1-hour samples (mandatory).

The checks involve sampling a known concentration of H_2S and comparing the analyzed concentration with the known concentration. Mix the H_2S recovery gas (Section 3.1.4) and combustion gas in a dilution system such as is shown in Figure 16A-3. Adjust the flow rates to generate an H_2S concentration in the range of the stack gas or within 20 percent of the applicable standard and an oxygen concentration greater than 1 percent at a total flow rate of at least 2.5 liters/min. Use Equation 16A-3 to calculate the concentration of recovery gas generated. Calibrate the flow rate from both sources with a soap bubble flow tube so that the diluted concentration of H_2S can be accurately calculated. Collect 30-minute samples, and analyze in the normal manner (as discussed in Section 4.1.3). Collect the sample through the probe of the sampling train using a manifold or some other suitable device that will ensure extraction of a representative sample.

The recovery check must be performed in the field prior to replacing the SO₂ scrubber and particulate filter and before the probe is cleaned. A sample recovery of 100 ± 20 percent must be obtained for the data to be valid and should be reported with the emission data, but should not be used to correct the data. However, if the performance check results do not affect the compliance or noncompliance status of the affected facility, the Executive Officer may decide to accept the results of the compliance test. Use Equation 16A-4 to calculate the recovery efficiency.

4.4 Sample Analysis. Same as in Method 6, Section 4.3, except for 1-hour sampling, take a 40-ml aliquot, add 160 ml of 100 percent isopropanol, and four drops of thiorin. Analyze an EPA SO₂ field audit sample with each set of samples. Such audit samples are available from the Source Branch, Quality Assurance Division, Environmental Monitoring Systems Laboratory, U.S. Environmental Agency, Research Triangle Park, North Carolina 27711.

4.5 Alternative Procedures. Any alternative procedure which, after review of the Executive Officer, is deemed suitable for this purpose, may be used. A successful petition for an alternative must at least include data to demonstrate that the method is equivalent, and substantiate this data through an adequate quality assurance program approved by the Executive Officer.

5. CALIBRATION

5.1 Metering System, Thermometers, Rotameters, Barometers, and Barium Perchlorate Solution. Calibration procedures are presented in Method 6, Sections 5.1 through 5.5.

6. CALCULATIONS

In the calculations, at least one extra decimal figure should be retained beyond that of the acquired data. Figures should be rounded off after final calculations.

6.1 Nomenclature.

C_{TRS} = Concentration of TRS as SO₂, dry basis corrected to standard conditions, ppm.

C_{RG} = Concentration of recovery gas generated, ppm.

$C_{\text{H}_2\text{S}}$ = Verified concentration of H₂S recovery gas.

N = Normality of barium perchlorate titrant, milliequivalents/mL.

P_{bar} = Barometric pressure at exit orifice of the dry gas meter, mm Hg (in. Hg).

P_{std} = Standard absolute pressure, 760 mm Hg (29.92 in. Hg).

- Q_{H_2S} = Calibrated flow rate of H₂S recovery gas, liters/min.
 Q_{CG} = Calibrated flow rate of combustion gas, liters/min.
 R = Recovery efficiency for the system performance check, percent.
 T_m = Average dry gas meter absolute temperature, K (R).
 T_{std} = Standard absolute temperature, 293 K, (528 R).
 V_a = Volume of sample aliquot titrated, mL.
 V_m = Dry gas volume as measured by the dry gas meter, liters (dcf).
 $V_{m(std)}$ = Dry gas volume measured by the dry gas meter, corrected to standard conditions, liters (dscf).
 V_{soln} = Total volume of solution in which the sulfur dioxide sample is contained, 100 ml.
 V_t = Volume of barium perchlorate titrant used for the sample, ml (average of replicate titrations).
 V_{tb} = Volume of barium perchlorate titrant used for the blank, ml.
 Y = Dry gas meter calibration factor.
 32.03 = Equivalent weight of sulfur dioxide, mg/meq.

6.2 Dry Sample Gas Volume, Corrected to Standard Conditions.

Old equation to be removed:

$$\begin{aligned}
 V_{m(std)} &= V_m Y \frac{T_{std}}{T_m} \frac{P_{bar}}{P_{std}} \\
 &= K_1 V_m \frac{P_{bar}}{T_m}
 \end{aligned}$$

Eq. 16A-1

New Equation to be inserted:

$$\begin{aligned}
 V_{m(std)} &= V_m Y \frac{T_{std}}{T_m} \frac{P_{bar}}{P_{std}} \\
 &= K_1 Y V_m \frac{P_{bar}}{T_m}
 \end{aligned}$$

Eq. 16A-1

Where: $K_1 = 0.3858$ K/mm Hg for metric units.

6.3 Concentration of TRS as ppm SO_2 .

Old equation to be deleted:

$$C_{\text{TRS(ppm)}} = K_2 \frac{(V_t - V_{tb}) \frac{V_{\text{soln}}}{V_a}}{V_{m(\text{std})}} \quad \text{Eq. 16A-2}$$

New equation to be inserted:

$$C_{\text{TRS(ppm)}} = K_2 \frac{(V_t - V_{tb}) N \frac{V_{\text{soln}}}{V_a}}{V_{m(\text{std})}} \quad \text{Eq. 16A-2}$$

Where:

Old equation to be deleted:

$$K_2 = 32.02 \frac{\text{mg}}{\text{meq}} \frac{24.05 \text{ liters}}{\text{mole}} \frac{1 \text{ mole}}{6.06 \text{ g}} \frac{1 \text{ g}}{1000 \text{ mg}} \frac{1000 \text{ ml}}{\text{liter}} \frac{1000 \mu\text{l}}{1 \text{ ml}} \\ = 12025 \frac{\mu\text{l}}{\text{meq}}$$

New equation to be inserted:

$$K_2 = 32.03 \frac{\text{mg}}{\text{meq}} \frac{24.05 \text{ liters}}{\text{mole}} \frac{1 \text{ mole}}{64.06 \text{ g}} \frac{1 \text{ g}}{1000 \text{ mg}} \frac{1000 \text{ ml}}{\text{liter}} \frac{1000 \mu\text{l}}{1 \text{ ml}} \\ = 12025 \frac{\mu\text{l}}{\text{meq}}$$

6.4 Concentration of Recovery Gas Generated in the System Performance Check.

$$C_{\text{RG}} = \frac{(Q_{\text{H}_2\text{S}})(C_{\text{H}_2\text{S}})}{Q_{\text{H}_2\text{S}} + Q_{\text{CG}}} \quad \text{Eq. 16A-3}$$

6.5 Recovery Efficiency for the System Performance Check.

$$R = \frac{C_{\text{TRS}}}{C_{\text{RG}}} \times 100 \quad \text{Eq. 16A-4}$$

7. ALTERNATIVE PROCEDURES

7.1 Determination of H₂S Content in Cylinder Gases. As an alternative to the procedures specified in section 3.1.4, the following procedure may be used to verify the concentration of the recovery check gas. The H₂S is collected from the calibration gas cylinder and is absorbed in zinc acetate solution to form zinc sulfide. The latter compound is then measured iodometrically. The method has been examined in the range of 5 to 1500 ppm. There are no known interferences to this method when used to analyze cylinder gases containing H₂S in nitrogen. Laboratory tests have shown a relative standard deviation of less than 3 percent. The method showed no bias when compared to a gas chromatographic method that used gravimetrically certified permeation tubes for calibration.

7.1.1 Sampling Apparatus. The sampling train is shown in Figure 16A-4 and consists of the following components:

7.1.1.1 Sampling Line. Teflon tubing (1/4-in.) to connect the cylinder regulator to the sampling valve.

7.1.1.2 Needle Valve. Stainless steel or Teflon needle valve to control the flow rate of gases to the impingers.

7.1.1.3 Impingers. Three impingers of approximately 100-ml capacity, constructed to permit the addition of reagents through the gas inlet stem. The impingers shall be connected in series with leak-free glass or Teflon connectors. The impinger bottoms have a standard 24/25 ground-glass fitting. The stems are from standard 1/4-in. (0.64-cm) ball joint midget impingers, custom lengthened by about 1 in. When fitted together, the stem end should be approximately 1/2 in. (1.27-cm) from the bottom. The third in-line impinger acts as a drop-out bottle.

7.1.1.4 Drying Tube, Flowmeter, and Barometer. Same as in Method 11, Sections 5.1.5, 5.18, and 5.1.10.

7.1.1.5 Cylinder Gas Regulator. Stainless steel, to reduce the pressure of the gas stream entering the Teflon sampling line to a safe level.

7.1.1.6 Soap Bubble Meter. Calibrated for 100 and 500 ml, or two separate bubble meters.

7.1.1.7 Critical Orifice. For volume and rate measurements. The critical orifice may be fabricated according to Section 7.1.4.3 and must be calibrated as specified in Section 7.1.8.4.

7.1.1.8 Graduated Cylinder. 50-ml size.

7.1.1.9 Volumetric Flask. 1-liter size.

7.1.1.10 Volumetric Pipette. 15-ml size.

7.1.1.11 Vacuum Gauge. Minimum 20-in. Hg capacity.

7.1.1.12 Stopwatch.

7.1.2 Sample Recovery and Analysis Apparatus.

7.1.2.1 Erlenmeyer Flasks. 125- and 250-ml sizes.

7.1.2.2 Pipettes. 2-, 10-, 20-, and 100-ml volumetric.

7.1.2.3 Burette. 50-ml size.

7.1.2.4 Volumetric Flask. 1-liter size.

7.1.2.5 Graduated Cylinder. 50-ml size.

7.1.2.6 Wash Bottle.

7.1.2.7 Stirring Plate and Bars.

7.1.3 Reagents. Unless otherwise indicated, all reagents shall conform to the specifications established by the Committee on Analytical Reagents of the American Chemical Society, where such specifications are available. Otherwise, use the best available grade.

7.1.3.1 Water. Same as in Method 11, Section 6.1.3.

7.1.3.2 Zinc Acetate Absorbing Solution. Dissolve 20 g zinc acetate in water and dilute to 1 liter.

7.1.3.3 Potassium Bi-iodate [KH(IO₃)₂] Solution, Standard 0.100 N. Dissolve 3.249 g anhydrous KH(IO₃)₂ in water, and dilute to 1 liter.

7.1.3.4 Sodium Thiosulfate (Na₂S₂O₃) Solution, Standard 0.1 N. Same as in Method 11, Section 6.3.1 Standardize according to Section 7.1.8.2.

7.1.3.5 Na₂S₂O₃ Solution, Standard 0.01 N. Pipette 100.0 ml of 0.1 N Na₂S₂O₃ solution into a 1-liter volumetric flask, and dilute to the mark with water.

7.1.3.6 Iodine Solution, 0.1 N. Same as in Method 11, Section 6.2.2.

7.1.3.7 Standard Iodine Solution, 0.01 N. Same as in Method 11, Section

6.2.3. Standardize according to Section 7.1.8.3 of Method 16A.

7.1.3.8 Hydrochloric Acid (HCl) Solution, 10 Percent by Weight. Add 230 ml concentrated HCl (specific gravity 1.19) to 770 ml water.

7.1.3.9 Starch Indicator Solution. To 5 g starch (potato, arrowroot, or soluble) add a little cold water, and grind in a mortar to a thin paste. Pour into 1 liter of boiling water, stir, and let settle overnight. Use the clear supernatant. Preserve with 1.25 g salicylic acid, 4 g zinc chloride, or a combination of 4 g sodium propionate and 2 g sodium azide per liter of starch solution. Some commercial starch substitutes are satisfactory.

7.1.4 Sampling Procedure.

7.1.4.1 Selection of Gas Sample Volumes. This procedure has been validated for estimating the volume of cylinder gas sample needed when the H₂S concentration is in the range of 5 to 1500 ppm. The sample volume ranges were selected in order to ensure a 35 to 60 percent consumption of the 20 ml of 0.01 N iodine (thus ensuring a 0.01 N Na₂S₂O₃ titer of approximately 7 to 12 ml). The sample volumes for various H₂S concentrations can be estimated by dividing the approximate ppm-liters desired for a given concentration range by the H₂S concentration stated by the manufacturer.

<u>Approximate cylinder gas H₂S concentration (ppm)</u>	<u>Approximate ppm-liters desired</u>
<u>5 to <30.....</u>	<u>650</u>
<u>30 to <500.....</u>	<u>800</u>
<u>500 to <1500.....</u>	<u>1000</u>

For example, for analyzing a cylinder gas containing approximately 10 ppm H₂S, the optimum sample volume is 65 liters (650 ppm-liters/10 ppm). For analyzing a cylinder gas containing approximately 1000 ppm H₂S, the optimum sample volume is 1 liter (1000 ppm-liters/1000 ppm).

7.1.4.2 Critical Orifice Flow Rate Selection. The following table shows the ranges of sample flow rates that are desirable in order to ensure capture of H₂S in the impinger solution. Slight deviations from these ranges will not have an impact on measured concentrations.

<u>Cylinder gas H₂S concentration (ppm)</u>	<u>Approximate ppm-liters desired</u>
<u>5 to <50 ppm.....</u>	<u>1500 ± 500</u>

50 to <250 ppm.....	500 ± 250
250 to <1000 ppm.....	250 ± 50
>1000 ppm.....	75 ± 25

7.1.4.3 Critical Orifice Fabrication. Critical orifice of desired flow rates may be fabricated by selecting an orifice tube of desired length and connecting 1/16-in. x 1/4-in. (0.16-cm x 0.64-cm) reducing fittings to both ends. The inside diameters and lengths of orifice tubes needed to obtain specific flow rates are shown below.

Tube (in. OD)	Tube (in. ID)	Length (in.)	Flow rate (ml/min)
1/16.....	0.007	1.2	85
1/16.....	0.01	3.2	215
1/16.....	0.01	1.2	350
1/16.....	0.02	1.2	1400

7.1.4.4 Determination of Critical Orifice Approximate Flow Rate. Connect the critical orifice to the sampling system as shown in Figure 16A-4 but without the H₂S cylinder. connect a rotameter in the line to the first impinger. Turn on the pump, and adjust the valve to give a reading of about half atmospheric pressure. Observe the rotameter reading. Slowly increase the vacuum until a stable flow rate is reached, and record this as the critical vacuum. The measured flow rate indicates the expected critical flow rate of the orifice. If this flow rate is in the range shown in Section 7.1.4.2, proceed with the critical orifice calibration according to Section 7.1.8.4.

7.1.4.5 Determination of Approximate Sampling Time. Determine the approximate sampling time for a cylinder of known concentration. Use the optimum sample volume obtained in Section 7.1.4.1.

$$\text{Approximate sampling time (min)} = \frac{\text{Optimum volume} \times 1000}{\text{Critical orifice flow rate (ml/min)}}$$

7.1.4.6 Sample Collection. Connect the Teflon tubing, Teflon tee, and rotameter to the flow control needle valve as shown in Figure 16A-4. Vent the rotameter to an exhaust hood. Plug the open end of the tee. Five to 10 minutes prior to sampling, open the cylinder valve while keeping the flow control needle valve closed. Adjust the delivery pressure to 20 psi. Open the

needle valve slowly until the rotameter shows a flow rate approximately 50 to 100 ml above the flow rate of the critical orifice being used in the system. Place 50 ml of zinc acetate solution in two of the impingers, connect them and the empty third impinger (dropout bottle) and the rest of the equipment as shown in Figure 16A-4. Make sure the ground-glass fittings are tight. The impingers can be easily stabilized by using a small cardboard box in which three holes have been cut, to act as a holder. Connect the Teflon sample line to the first impinger. Cover the impingers with a dark cloth or piece of plastic to protect the absorbing solution from light during sampling. Record the temperature and barometric pressure. Note the gas flow rate through the rotameter. Open the closed end of the tee. Connect the sampling tube to the tee, ensuring a tight connection. Start the sampling pump and stopwatch simultaneously. Note the decrease in flow rate through the excess flow rotameter. This decrease should equal the known flow rate of the critical orifice being used. Continue sampling for the period determined in Section 7.1.4.5. When sampling is complete, turn off the pump and stopwatch. Disconnect the sampling line from the tee and plug it. Close the needle valve followed by the cylinder valve. Record the sampling time.

7.1.5 Blank Analysis. While the sample is being collected, run a blank as follows: To a 250-ml Erlenmeyer flask, add 100 ml of zinc acetate solution, 20.0 ml 0.01 N iodine solution, and 2 ml HCl solution. Titrate, while stirring, with 0.01 N $\text{Na}_2\text{S}_2\text{O}_3$ until the solution is light yellow. Add starch, and continue titrating until the blue color disappears. Analyze a blank with each sample, as the blank titer has been observed to change over the course of a day.

Note: Iodine titration of zinc acetate solutions is difficult to perform because the solution turns slightly white in color near the end point, and the disappearance of the blue color is hard to recognize. In addition, a blue color may reappear in the solution about 30 to 45 seconds after the titration endpoint is reached. This should not be taken to mean the original endpoint was in error. It is recommended that persons conducting this test perform several titrations to be able to correctly identify the endpoint. The importance of this should be recognized because the results of this analytical procedure are extremely sensitive to errors in titration.

7.1.6 Sample Analysis. Sample treatment is similar to the blank treatment. Before detaching the stems from the bottoms of the impingers, add 20.0 ml of .01 N iodine through the stems of the impingers holding the zinc acetate solution, dividing it between the two (add about 15 ml to the first impinger and the rest to the second). Add 2 ml HCl solution through the stems, dividing it as with the iodine. Disconnect the sampling line, and store the impingers for 30 minutes. At the end of 30 minutes, rinse the impinger to a flask because this may result in a loss of iodine and cause a positive bias.

7.1.7 Post-test Orifice Calibration. Conduct a post-test critical orifice calibration run using the calibration procedures outlined in Section 7.1.8.4. If the Qstd obtained before and after the test differs by more than 5 percent, void the sample; if not, proceed to perform the calculations.

7.1.8 Calibrations and Standardizations.

7.1.8.1 Rotameter and Barometer. Same as in Method 11, Sections 8.2.3 and 8.2.4.

7.1.8.2 Na₂S₂O₃ Solution, 0.1 N. Standardize the 0.1 N Na₂S₂O₃ solution as follows: To 80 ml water, stirring constantly, add 1 ml concentrated H₂SO₄, 10.0 ml 0.100 N KH(IO₃)₂ and 1 g potassium iodide. Titrate immediately with 0.1 N Na₂S₂O₃ until the solution is light yellow. Add 3 ml starch solution, and titrate until the blue color just disappears. Repeat the titration until replicate analyses agree within 0.05 ml. Take the average volume of Na₂S₂O₃ consumed to calculate the normality to three decimal figures using Equation 16A-5.

7.1.8.3 Iodine Solution, 0.01 N. Standardize the 0.01 N iodine solution as follows: Pipet 20.0 ml of 0.01 N iodine solution into a 125-ml Erlenmeyer flask. Titrate with standard 0.01 N Na₂S₂O₃ solution until the solution is light yellow. Add 3 ml starch solution, and continue titrating until the blue color just disappears.

If the normality of the iodine tested is not 0.010, add a few ml of 0.1 N iodine solution if it is low, or a few ml of water if it is high, and standardize again. Repeat the titration until replicate values agree within 0.05 ml. Take the average volume to calculate the normality to three decimal figures using Equation 16A-6.

7.1.8.4 Critical Orifice. Calibrate the critical orifice using the sampling train shown in Figure 16A-4 but without the H₂S cylinder and vent rotameter. Connect the soap bubble meter to the Teflon line that is connected to the first impinger. Turn on the pump, and adjust the needle valve until the vacuum is higher than the critical vacuum determined in Section 7.1.4.4 Record the time required for gas flow to equal the soap bubble meter volume (use the 100-ml soap bubble meter for gas flow rates below 100 ml/min, otherwise use the 500-ml soap bubble meter). Make three runs, and record the data listed in Table 1. Use these data to calculate the volumetric flow rate of the orifice

7.1.9 Calculations.

7.1.9.1 Nomenclature.

B_{wa} \equiv Fraction of water vapor in ambient air during orifice calibration.

C_{H_2S} \equiv H₂S concentration in cylinder gas, ppm.

K \equiv Conversion factor

\equiv 12025 ml/eq

$$= \frac{17.03\text{g}}{\text{g-eq}} \frac{24.05\text{liters H}_2\text{S}}{\text{mole H}_2\text{S}} \frac{1\text{ mole H}_2\text{S}}{34.06\text{g H}_2\text{S}} \frac{10^3\text{ml}}{\text{Liter}}$$

M_a	≡	<u>Molecular weight of ambient air saturated at impinger temperature, g/g-mole.</u>
M_s	≡	<u>Molecular weight of sample gas (nitrogen) saturated at impinger temperature, g/g-mole. (For tests carried out in a laboratory where the impinger temperature is 25°C, $M_a=28.5$ g/g-mole and $M_s=27.7$ g/g-mole.)</u>
N_i	≡	<u>Normality of standard iodine solution (0.01 N), g-eq/liter.</u>
N_T	≡	<u>Normality of standard $Na_2S_2O_3$ solution (0.01 N), g-eq/liter.</u>
P_{bar}	≡	<u>Barometric pressure, mm Hg.</u>
P_{std}	≡	<u>Standard absolute pressure, 760 mm Hg.</u>
Q_{std}	≡	<u>Volumetric flow rate through critical orifice, liters/min.</u>
$Q_{std, average}$	≡	<u>Average standard flow rate through critical orifice, liters/min.</u>
$Q_{std, before}$	≡	<u>Average standard flow rate through critical orifice determined before H_2S sampling (Section 7.1.4.4), liters/min.</u>
$Q_{std, after}$	≡	<u>Average standard flow rate through critical orifice determined after H_2S sampling (Section 7.1.7), liters/min.</u>
T_{amb}	≡	<u>Absolute ambient temperature, K.</u>
T_{std}	≡	<u>Standard absolute temperature, 293 K.</u>
θ_s	≡	<u>Sampling time, min.</u>
θ_{sb}	≡	<u>Time for soap bubble meter flow rate measurement, min.</u>
$V_{m(std)}$	≡	<u>Sample gas volume measured by the critical orifice, corrected to standard conditions, liters.</u>
V_{sb}	≡	<u>Volume of gas as measured by the soap bubble meter, ml.</u>
$V_{sb(std)}$	≡	<u>Volume of gas as measured by the soap bubble meter, corrected to standard conditions, liters.</u>
V_i	≡	<u>Volume of standard iodine solution (0.01 N) used, ml.</u>
V_T	≡	<u>Volume of standard $Na_2S_2O_3$ solution (0.01 N) used, ml.</u>
V_{TB}	≡	<u>Volume of standard $Na_2S_2O_3$ solution (0.01 N) used for the blank, ml.</u>

Date _____

Critical Orifice ID _____

Soap bubble meter volume, V_{sb} _____ liters

Time, θ_{sb}

Run No. 1 _____ min _____ sec

Run No. 2 _____ min _____ sec

Run No. 3 _____ min _____ sec

Average _____ min _____ sec

Convert the seconds to fraction of minute:

Time

= _____ min + _____ Sec/60

= _____ min

Barometric pressure, P_{bar} = _____ mm Hg

Ambient temperature, T_{amb} = 273 + _____ °C

= _____ °K

Pump vacuum, = _____ mm Hg. (This should be approximately 0.4 times barometric pressure.)

$$V_{sb(std)} = \frac{(V_{sb})(T_{std})(P_{bar})(10^{-3})}{(T_{amb})(P_{std})}$$

= _____ liters

$$Q_{std} = \frac{V_{sb(std)}}{\theta_{sb}}$$

= _____ liters/min

Table 1 - Critical Orifice Calibration Data.

7.1.9.2 Normality of Standard Na₂S₂O₃ Solution (0.1. N).

$$N_T = \frac{1}{\text{ml Na}_2\text{S}_2\text{O}_3 \text{ Consumed}} \quad \text{Eq. 16A-5}$$

7.1.9.3 Normality of Standard Iodine Solution (0.01 N).

$$N_I = \frac{N_T V_T}{V_I} \quad \text{Eq. 16A-6}$$

7.1.9.4 Sample Gas Volume.

$$V_{m(\text{std})} = (\overline{Q}_{\text{std}})(\Theta_s)(1 - B_{wa}) \frac{M_a}{M_b} \quad \text{Eq. 16A-7}$$

7.1.9.5 Concentration of H₂S in the Gas Cylinder.

$$C_{\text{H}_2\text{S}} = \frac{K N_T (V_{\text{TB}} - V_T)}{V_{m(\text{std})}} \quad \text{Eq. 16A-8}$$

78. BIBLIOGRAPHY

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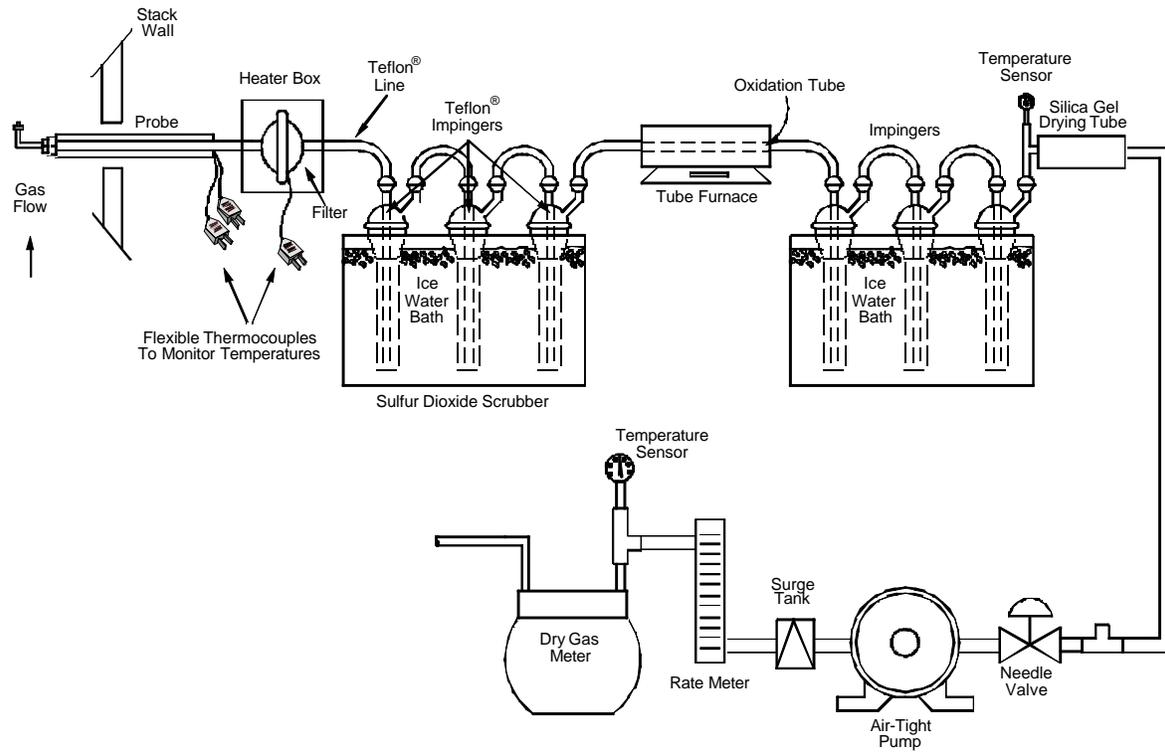


Figure 16A-1. Sampling Train.

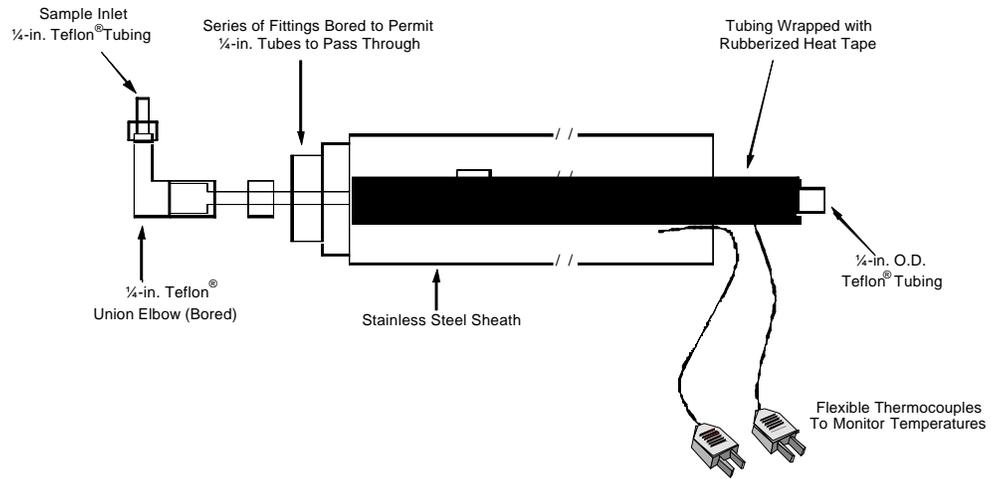


Figure 16A-2. Angled Sampling Probe.

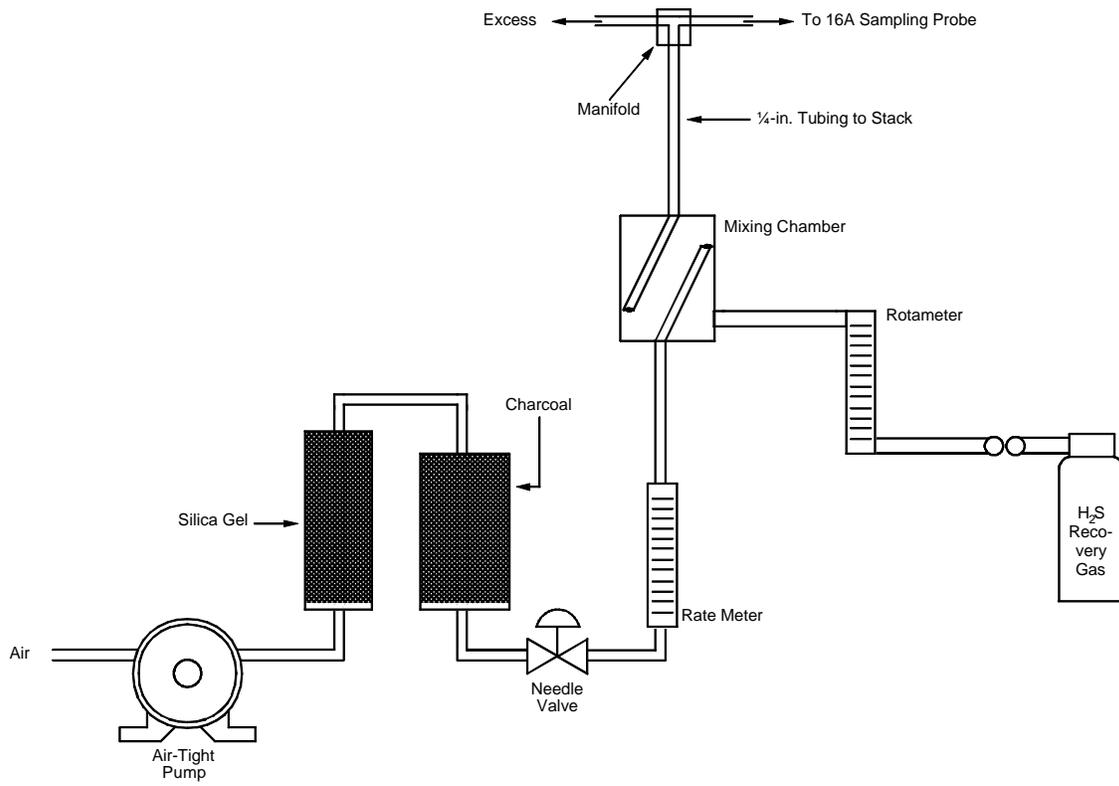


Figure 16A-3. Recovery Gas Dilution System.

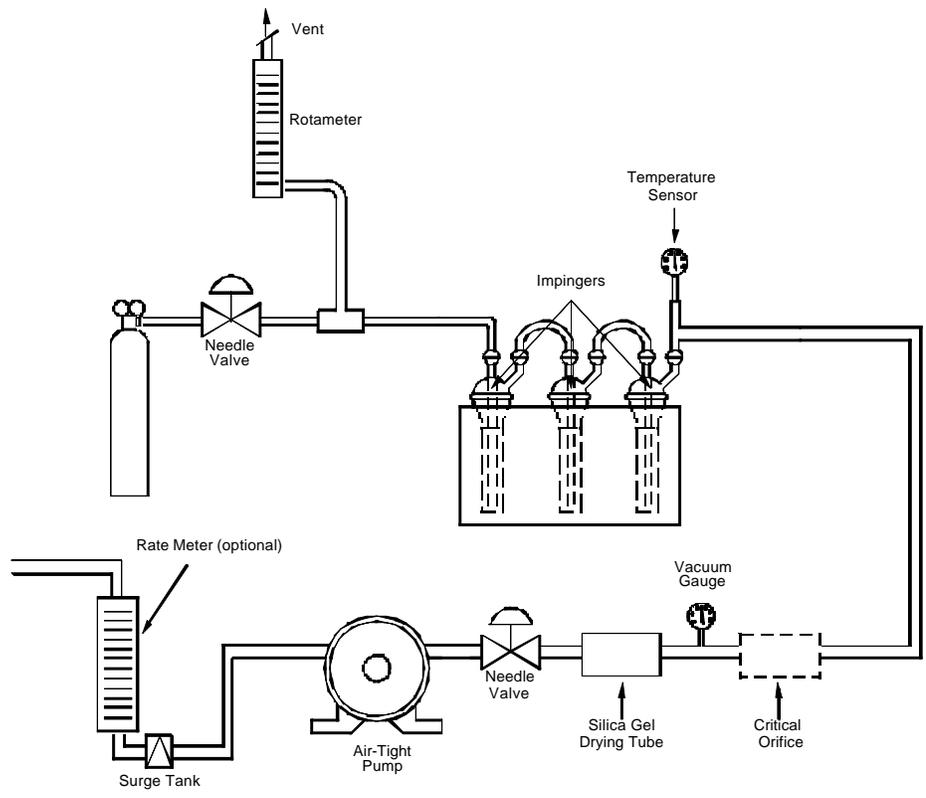


Figure 16A-4. Recovery Check Gas Sampling Train.

APPENDIX

Optional Procedure for Measuring Hydrogen Sulfide in Acid Gas-Tutwiler Procedure

Source: Gas Engineers Handbook, Fuel Gas Engineering Practices. The Industrial Press, 93 Worth Street, New York, New York, 1986, First Edition, Second Printing, page 6/25.

(a) When an instantaneous sample is desired and H₂S concentration is ten grains per 1000 cubic foot or more, a 100 mL Tutwiler burette is used. For concentrations less than ten grains, a 500 mL Tutwiler burette and more dilute solutions are used. In principle, this method consists of titrating hydrogen sulfide in a gas sample directly with a standard solution of iodine.

(b) Apparatus. (See Figure 1.) A 100 or 500 mL capacity Tutwiler burette, with two-way glass stopcock at bottom and three-way stopcock at top with connect either with inlet tubulature or glass-stoppered cylinder, 10 mL capacity, graduated in 0.1 mL subdivision; rubber tubing connecting burette with leveling bottle.

(c) Reagents

(1) Iodine Stock Solution, 0.1N. Weigh 12.7 g iodine, and 20 to 25 g c.p. potassium iodide for each liter of solution. Dissolve KI in as little water as necessary; dissolve iodine in concentrated KI solution, make up to proper volume, and store in glass-stoppered brown glass bottle.

(2) Standard Iodine Solution, 1 mL = 0.001711 g iodine. Transfer 33.7 mL of above 0.1N stock solution into a 250 mL volumetric flask; add water to mark and mix well. Then, for 100 mL sample of gas, 1 mL of standard iodine solution is equivalent to 100 grains H₂S per cubic ~~feet~~foot of gas.

(3) Starch Solution. Rub into a thin paste about one teaspoonful of wheat starch with a little water, pour into about a pint of boiling water, stir, let cool and decant off clear solution. Make fresh solution every few days.

(d) Procedure.

Fill leveling bulb with starch solution.

Raise (L), open cock (G), open (F) to (A), and close (F) when solution starts to run out of gas inlet. Close (G).

Purge gas sampling line and connect with (A). Lower (L) and open (F) and (G). When liquid level is several ml past the 100 ml mark, close (G), and (F), and disconnect sampling tube.

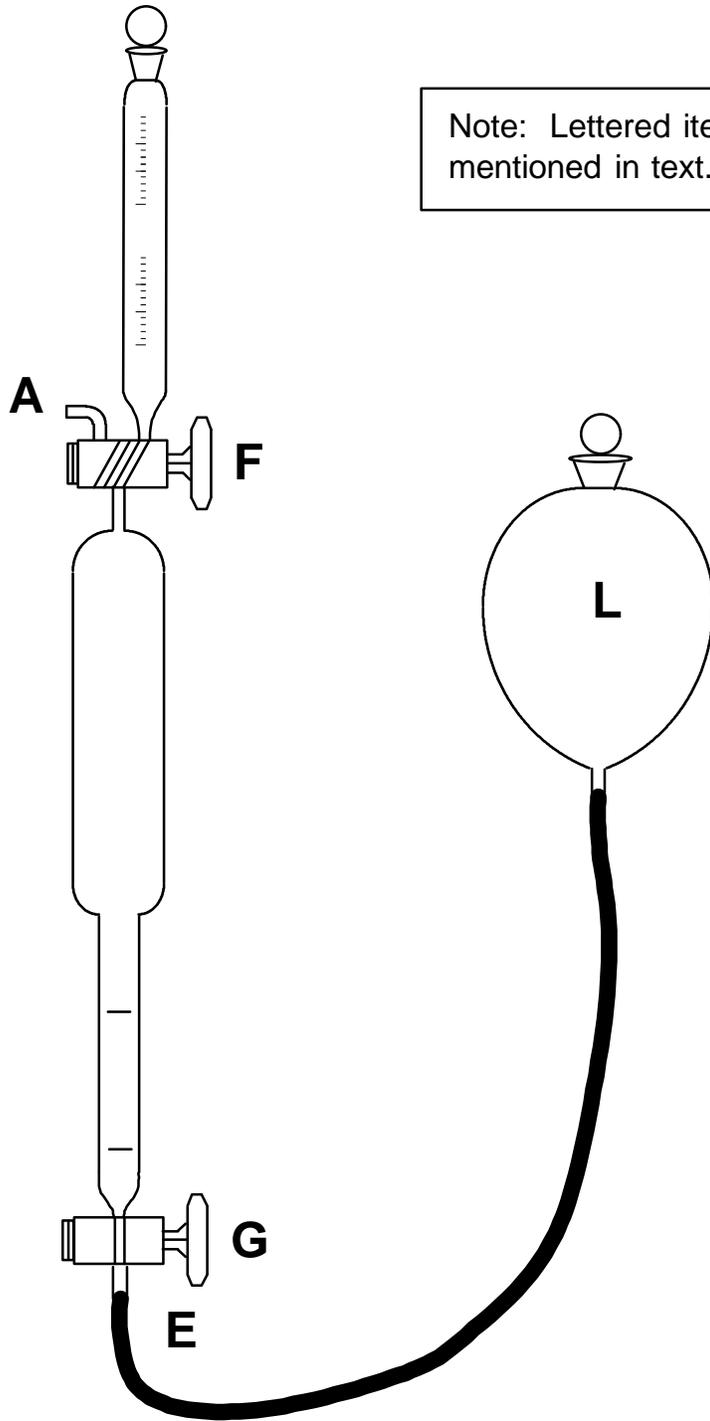
Open (G) and bring starch solution to 100 ml mark by raising (L); then close (G). Open (F) momentarily, to bring gas in burette to atmospheric pressure, and close (F).

Open (G), bring liquid level down to 10 ml mark by lowering (L). Close (G), clamp rubber tubing near (E) and disconnect it from burette.

Rinse graduated cylinder with a standard iodine solution (0.001711 g iodine per ml); fill cylinder and record reading. Introduce successive small amounts of iodine thruthrough (F); shake well after each addition; continue until a faint permanent blue color is obtained. Record reading; subtract from previous reading, and call difference D.

Method 16A Appendix - FIGURE 1

TUTWILER GAS BURET SETUP



Note: Lettered items are mentioned in text.

(e) With every fresh stock of starch solution, perform a blank test as follows: Introduce fresh starch solution into burette up to 100 ml mark. Close (F) and (G). Lower (L) and open (G). When liquid level reaches the 10 ml mark, close (G). With air in burette, titrate as during a test and up to same end point. Call ml of iodine used C. Then, grains H₂S per 100 cubic feet of gas equals 100 (D-C).

(f) Greater sensitivity can be attained if a 400 ml capacity Tutwiler burette is used with a more dilute (0.001N) iodine solution. Concentrations less than 1.0 grains per 100 cubic feet can be determined in this way. Usually, the starch-iodine end point is much less distinct, and a blank determination of end point, with H₂S-free gas or air, is required.