

## TABLE OF CONTENTS

<b>Preface</b>	v
<b>Contents</b>	vii
<b>Part A –General Context</b>	1
<i>Chapter 1 –Zinc Smelting Industry Perspective and Introduction</i>	3
Introduction	3
The Zinc Smelting Industry	3
Process Principles – Electrolytic Zinc Process	6
Process Principles – Carbothermic Reduction	10
<i>Chapter 2 –Historical Background</i>	13
Zinc Production in Early Times	13
Retort Processes	13
The Electrolytic Process	14
Recovery of Zinc From Leach Residues	15
Direct Leaching of Zinc Concentrates	16
Evolutionary Developments	16
Imperial Smelting Process	17
<i>Chapter 3 –Raw Materials</i>	19
Background	19
Zinc Mineralogy	19
Separation and Concentration of Sulfide Ores	20
Commercial Zinc Concentrates	20
Commercial Terms for Purchase of Standard Zinc Concentrates	25
Commercial Terms for the Purchase of Bulk Concentrates	27
Secondary Materials	28
<b>Part B –The Electrolytic Process</b>	29
<i>Chapter 4 –Roasting</i>	31
Purpose	31
Process Chemistry and Thermodynamics	31
Roasting Methods	36
Principles of Fluid Bed Roasting	38
Commercial Fluid Bed Roasting Equipment	44
Other Forms of Fluid Bed Roasting Equipment	49
Roaster Gas Processing	51
Sulfuric Acid Production	53

<i>Chapter 5 –Leaching and Solution Preparation</i>	57
Purpose	57
Leaching of Calcine	57
Iron Removal	62
Lead-Silver Residue Recovery	72
Thickening and Filtration of Iron And Leach Residues	72
Processing and Disposal of Leach/Iron Residues	74
Direct Leaching of Zinc Concentrates	78
Solvent Extraction	86
<i>Chapter 6 –Solution Purification</i>	93
Purpose	93
Impurity Removal by Precipitation by pH Adjustment	93
Impurity Removal by Cementation (Zinc Dust Purification)	94
Cementation (or Zinc Dust Purification) Practice	97
Equipment Used for Cementation	100
Other Solution Purification Methods	102
Removal of Gypsum	103
Recovery of By-Product Metals	103
Summary of the Behaviour of Impurities, the Effect on Zinc Electrowinning and Control Methods	105
<i>Chapter 7 –Electrolysis</i>	113
Process Principles	113
Cathode Reactions	119
Anode Reactions	124
Electrolyte Conductivity	126
Zinc Cell Performance	127
Plant Operating and Design Features	130
<i>Chapter 8 –Melting and Casting</i>	141
Purpose	141
Cathode Melting	141
Specifications and Alloying	143
Casting	145
Zinc Dust Production	149
<i>Chapter 9 –Material Balance Control and Effluent Treatment</i>	151
Purpose	151
Impurity Outlets	151
Solution Bleed Procedures	152
Liquid Effluent Treatment	155

<i>Chapter 10 –Other Electrolytic Processes</i>	159
General Comparisons	159
Chloride Systems	159
Electrolysis of Aqueous Zinc Chloride	161
Electrolysis of Molten Zinc Chloride	162
Electrolysis of Alkaline Zinc Solutions	164
General Appraisal of Alternative Electrolysis Systems	165
<b>Part C –Carbothermic Reduction Processes</b>	167
<i>Chapter 11 –Carbothermic Reduction</i>	169
Chemical Principles of Zinc Oxide Reduction	169
Reduction From Molten Slags	173
Control of Iron Reduction	176
Condensation of Zinc From Reduction Gases	178
Fuming	182
<i>Chapter 12 –Sintering</i>	185
Purpose and Background	185
The Sintering Process	185
Updraught Sintering	189
Sinter Handling	190
Gas Handling and Cleaning	190
The Structure of Sinter	191
Sinter Machine Capacity and Performance	191
<i>Chapter 13 –Retorting Processes</i>	193
Historical	193
The Horizontal Retort Process	193
The Vertical Retort Process	196
The Electrothermic Retort Process	198
<i>Chapter 14 –Blast Furnace Production of Zinc</i>	201
Development of the Zinc Blast Furnace	201
Process Description	201
Slag Composition	204
Impurities and Zinc Metal Quality	205
Evolution of Furnace Design and Operation	206
Coke Use and Furnace Capacity	208
Supplementary Furnace Feeds	209
<i>Chapter 15 –Thermal Refining Of Zinc</i>	211
Liquation Refining	211
Refining by Chemical Precipitation	211
Refining by Distillation	211

<i>Chapter 16 –Zinc Fuming Processes</i>	215
Introduction	215
The Waelz Kiln Process	215
The Conventional Slag Fuming Furnace Plant	221
Submerged Lance Slag Fuming	225
High Intensity Fuming Processes	229
Fuming in the Shaft Furnace	232
Fume Treatment	234
<i>Chapter 17 –Electric Furnace Reduction Processes</i>	239
Electric Furnace Types	239
Slag Resistance Furnaces	239
Plasma Arc Furnaces	241
The Sterling Process	243
The SKF Plasmadust Process	244
Other Electric Furnace Processes	244
General Conclusions	246
<i>Chapter 18 –Other Pyrometallurgical Reduction Processes</i>	249
The Warner Process	249
The Outokumpu Iron Melt Reduction Process	251
<b>Part D –General and Comparative Aspects of Major Zinc Production Processes</b>	253
<i>Chapter 19 –Treatment of Oxide and Secondary Materials</i>	255
Scope	255
Oxide Ores	255
Secondary Materials	256
<i>Chapter 20 –Energy Consumption</i>	259
Purpose and Scope	259
Energy Consumption for the Electrolytic Process	262
Electrolytic Plant Energy Use Summary	262
Energy Use for the Imperial Smelting Process	262
Energy Use for the Retort Processes	263
<i>Chapter 21 –Costs and Economics of the Electrolytic Zinc Process</i>	265
Purpose and Basis	265
Capital Costs	265
Direct Operating Costs	268
Metal Pricing	270
By-Products	271
Smelter Economics	272
Capacity Limitations and Incremental Expansion	273

<i>Chapter 22 –Costs and Economics of the ISF Process</i>	275
Capital Costs	275
Direct Operating Costs	277
Product Zinc Pricing	278
By-Products	278
Smelter Economics	279
<i>Appendix 1 –Properties of Zinc and Associated Compounds</i>	283
Zinc Metal Properties	283
Cadmium Metal Properties	283
Thermodynamic Properties of Compounds Involved in Zinc Extraction	284
Heat Capacities at Constant Pressure	285
Electrochemical Constants	285
<b>Index</b>	287