

ISSN 2518-170X (Online),
ISSN 2224-5278 (Print)

ҚАЗАҚСТАН РЕСПУБЛИКАСЫ
ҰЛТТЫҚ ҒЫЛЫМ АКАДЕМИЯСЫНЫҢ
Қ. И. Сәтпаев атындағы Қазақ ұлттық техникалық зерттеу университеті

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РЕСПУБЛИКИ КАЗАХСТАН
Казакский национальный исследовательский
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NEWS

OF THE ACADEMY OF SCIENCES
OF THE REPUBLIC OF KAZAKHSTAN
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ГЕОЛОГИЯ ЖӘНЕ ТЕХНИКАЛЫҚ ҒЫЛЫМДАР СЕРИЯСЫ



СЕРИЯ ГЕОЛОГИИ И ТЕХНИЧЕСКИХ НАУК



SERIES OF GEOLOGY AND TECHNICAL SCIENCES

3 (429)

МАМЫР – МАУСЫМ 2018 ж.
МАЙ – ИЮНЬ 2018 г.
MAY – JUNE 2018

ЖУРНАЛ 1940 ЖЫЛДАН ШЫҒА БАСТАҒАН
ЖУРНАЛ ИЗДАЕТСЯ С 1940 г.
THE JOURNAL WAS FOUNDED IN 1940.

ЖЫЛЫНА 6 РЕТ ШЫҒАДЫ
ВЫХОДИТ 6 РАЗ В ГОД
PUBLISHED 6 TIMES A YEAR

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Қазақстан Республикасы Ұлттық ғылым академиясы "ҚР ҰҒА Хабарлары. Геология және техникалық ғылымдар сериясы" ғылыми журналының Web of Science-тің жаңаланған нұсқасы Emerging Sources Citation Index-те индекстелуге қабылданғанын хабарлайды. Бұл индекстелу барысында Clarivate Analytics компаниясы журналды одан әрі the Science Citation Index Expanded, the Social Sciences Citation Index және the Arts & Humanities Citation Index-ке қабылдау мәселесін қарастыруда. Web of Science зерттеушілер, авторлар, баспашылар мен мекемелерге контент тереңдігі мен сапасын ұсынады. ҚР ҰҒА Хабарлары. Геология және техникалық ғылымдар сериясы Emerging Sources Citation Index-ке енуі біздің қоғамдастық үшін ең өзекті және беделді геология және техникалық ғылымдар бойынша контентке адалдығымызды білдіреді.

НАН РК сообщает, что научный журнал «Известия НАН РК. Серия геологии и технических наук» был принят для индексирования в Emerging Sources Citation Index, обновленной версии Web of Science. Содержание в этом индексировании находится в стадии рассмотрения компанией Clarivate Analytics для дальнейшего принятия журнала в the Science Citation Index Expanded, the Social Sciences Citation Index и the Arts & Humanities Citation Index. Web of Science предлагает качество и глубину контента для исследователей, авторов, издателей и учреждений. Включение Известия НАН РК. Серия геологии и технических наук в Emerging Sources Citation Index демонстрирует нашу приверженность к наиболее актуальному и влиятельному контенту по геологии и техническим наукам для нашего сообщества.

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«ҚР ҰҒА Хабарлары. Геология мен техникалық ғылымдар сериясы».

ISSN 2518-170X (Online),

ISSN 2224-5278 (Print)

Меншіктенуші: «Қазақстан Республикасының Ұлттық ғылым академиясы» РҚБ (Алматы қ.).

Қазақстан республикасының Мәдениет пен ақпарат министрлігінің Ақпарат және мұрағат комитетінде 30.04.2010 ж. берілген №10892-Ж мерзімдік басылым тіркеуіне қойылу туралы куәлік.

Мерзімділігі: жылына 6 рет.

Тиражы: 300 дана.

Редакцияның мекенжайы: 050010, Алматы қ., Шевченко көш., 28, 219 бөл., 220, тел.: 272-13-19, 272-13-18,
<http://nauka-nanrk.kz/geology-technical.kz>

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Редакцияның Қазақстан, 050010, Алматы қ., Қабанбай батыра көш., 69а.

мекенжайы: Қ. И. Сәтбаев атындағы геология ғылымдар институты, 334 бөлме. Тел.: 291-59-38.

Типографияның мекенжайы: «Аруна» ЖК, Алматы қ., Муратбаева көш., 75.

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«Известия НАН РК. Серия геологии и технических наук».

ISSN 2518-170X (Online),

ISSN 2224-5278 (Print)

Собственник: Республиканское общественное объединение «Национальная академия наук Республики Казахстан (г. Алматы)

Свидетельство о постановке на учет периодического печатного издания в Комитете информации и архивов Министерства культуры и информации Республики Казахстан №10892-Ж, выданное 30.04.2010 г.

Периодичность: 6 раз в год

Тираж: 300 экземпляров

Адрес редакции: 050010, г. Алматы, ул. Шевченко, 28, ком. 219, 220, тел.: 272-13-19, 272-13-18,
<http://nauka-nanrk.kz/geology-technical.kz>

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Адрес редакции: Казахстан, 050010, г. Алматы, ул. Кабанбай батыра, 69а.

Институт геологических наук им. К. И. Сатпаева, комната 334. Тел.: 291-59-38.

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News of the National Academy of Sciences of the Republic of Kazakhstan. Series of geology and technology sciences.

ISSN 2518-170X (Online),

ISSN 2224-5278 (Print)

Owner: RPA "National Academy of Sciences of the Republic of Kazakhstan" (Almaty)

The certificate of registration of a periodic printed publication in the Committee of information and archives of the Ministry of culture and information of the Republic of Kazakhstan N 10892-Ж, issued 30.04.2010

Periodicity: 6 times a year

Circulation: 300 copies

Editorial address: 28, Shevchenko str., of. 219, 220, Almaty, 050010, tel. 272-13-19, 272-13-18,
<http://nauka-nanrk.kz/geology-technical.kz>

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Editorial address: Institute of Geological Sciences named after K.I. Satpayev
69a, Kabanbai batyr str., of. 334, Almaty, 050010, Kazakhstan, tel.: 291-59-38.

Address of printing house: ST "Aruna", 75, Muratbayev str, Almaty

NEWS

OF THE NATIONAL ACADEMY OF SCIENCES OF THE REPUBLIC OF KAZAKHSTAN

SERIES OF GEOLOGY AND TECHNICAL SCIENCES

ISSN 2224-5278

Volume 3, Number 429 (2018), 189 – 196

UDC 662.67

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**INVESTIGATION OF THE THERMAL DECOMPOSITION PROCESS
OF KENDYRLIK DEPOSIT OIL SHALES**

Abstract. In the article, experiments on the thermal treatment of Kendyrlík shale by its carbonization and activation were carried out. First, shale was carbonized in an inert argon medium in the temperature range 25-700 °C and then activated by water vapor at a temperature of 850-900 °C. The analysis of the elemental composition of the resulting synthetic gas showed that the highest concentration of combustible gas components (CO, H₂, CH₄) is observed at 900°C (in the absence of H₂S, low CO₂ and a small amount of liquid products - resin). Shale pyrolysis was also carried out in argon medium up to 900 °C. As a result of the analysis of the component composition of liquid products, it was found that mainly isoalkenes, alkanes and isocycloalkanes are formed. However, the elemental composition of the produced gas showed that the volume of gas and its caloric content are significantly lower in comparison with similar parameters for the gas produced during the activation of shale.

Keywords: shale, Kendyrlík, activation, carbonization, pyrolysis, gas.

Introduction. Globally, the significance of shale is its value as a source of energy, an alternative to other types of fossil fuels (for example, oil and coal) [1]. The solution to the problem of the use of oil shale, especially abroad, is mainly considered in the direction of their processing, with the production of shale resin - a substitute for oil and artificial gas (a substitute for natural gas). At the same time, the determining qualitative characteristics are: the content of organic matter and the yield of resin; calorific value (by class); the content of sulfur, rare and dispersed elements in the initial shale, semi-coking resin, gas products and ash residue; composition of the products obtained (resin, gas mixture); the ratio of the yield of the semi-coking resin to the heat of combustion (in groups) [2].

Possessing a high calorific value of combustible mass, shale is one of the low-grade fuels due to the huge amount of ash. The high content of hydrogen (up to 11%) in kerogen and volatile substances (combustible mass), reaching 80%, makes it possible to utilize shale as a raw material for pyrolysis and gasification processes, as well as chemical processing for the production of various oils, motor fuels, phenols, tanning beds, combustible gas, various valuable chemical products for the chemical industry [3]. Liquid hydrocarbons (shale oil-resin), obtained by pyrolysis, are similar in composition to petroleum hydrocarbons and can be considered unconventional (shale) oil [4].

At present, considerable experience in ground processing of oil shale in off-shore retorting technology has been accumulated [5]: Galoter Process (GALOTER, Russia-Estonia), Enefit (modification of Galoter process), Kiviter (Estonia), Alberta-Taciuk Process (ATP) (Australia), Petrosix (Brazil), Tosco II (USA), Fushun (China), Paraho Process (USA), Lurgi-Ruhrgas (Germany), Chevron STB (USA), etc. Energy efficiency of technologies is provided by technological operations optimizing physical and chemical conditions of the main process - pyrolysis process. The obtained industrial results [5, 6] showed the high efficiency of the use of oil shales.

One of the most effective shale processing technologies is the Galoter Process technology for the production of shale oil, motor fuels. This technology is mastered on a large industrial scale in Estonia (Narva). Using the potential heat of raw materials and economic efficiency, it surpasses all the technologies of thermal processing of oil shale that exist in the world today.

According to the Kazakhstan Research Institute of New Chemical Technologies and Materials, at least 25 deposits of oil shale, related to sediments of the Upper Devonian, Lower Carboniferous, Upper Paleozoic, Middle and Upper Jurassic and Paleogene, have been identified on the territory of Kazakhstan. They differ in the composition of the initial substance and in the conditions of formation, which to a large extent determined their quantitative and technological characteristics. The deposits of oil shale in Kazakhstan are extremely poorly studied [7, 8].

One of the promising and largest coal-shale basins is the Kendyrlyk basin (East Kazakhstan region), whose total reserves are estimated at 4,075 million tons, including balance reserves - 708 million tons [8,9]. It is followed by the Baykhozinskoye (in Southern Kazakhstan) and the Priuralsky group of deposits in the west of the country [8].

The main advantage of Kendyrlyk resin is a low sulfur content, which is removed by conventional methods used in refining petroleum products. In Kendyrlyk shale, the sulfur content usually does not exceed 1%, and in many other deposits, the sulfur content in shale is 4-7%, and sometimes 9%. The total thickness of the shale horizons is more than 100 m, the thickness of the beds varies from 1 to 12 m, the calorific value is 4-15 MJ/kg, the yield of the resins is 4-20% [10, 11].

Therefore, the aim of this work is to study the processes of thermal processing of Kendyrlyk shale for the production of hydrocarbon products.

Research methods

Humidity, ash content and volatility of oil shales were determined on the Thermogravimetric Analyzer "ThermosterEltra" (according to ASTM D7582-12 "Standard Test Methods for Proximate Analysis of Coal and Coke by Macro Thermogravimetric Analysis"). The bulk density, the pH of the aqueous extract, the adsorption activity by methyloange were determined in accordance with [12, 13].

Elemental shale analysis was performed using energy dispersive X-ray spectroscopy on a SEM (Quanta 3D 200i) instrument with an attachment for energy dispersive analysis from EDAX at a resolution of: 3.0 nm at 30 kV (high vacuum mode); <12 nm at 3 kV (low vacuum mode); with an accelerating voltage from 200 V to 30 kV and with an increase from x50 to x100000. Elemental analysis is determined from Be to U. Samples were attached to a copper holder using conductive adhesive paper. Previously, a thin conducting layer of carbon was deposited on the surface of the samples in a special vacuum installation for better passage of charges. The energy of the exciting electron beam in the analysis was 15 keV, the working distance was 15 mm.

The thermal decomposition of oil shale was carried out as follows. Previously, the shale was crushed on a hammer mill (Molot-200) to a fraction of 0.1 mm and granular samples with a diameter of 0.8 cm were obtained using a tablet press (model 1000). The obtained shale samples were first subjected to heat treatment at a heating rate of 1-2 deg/min in an inert argon medium in the temperature range of 25-700 °C, and then activation of shale with water vapor within 850-900 °C. Also, the process of pyrolysis of shales in an inert argon medium in the temperature range 25-900 °C was carried out at a heating rate of 10-15 deg/min, in order to obtain mainly liquid products (resins).

The elemental composition of the gas (released in the processes of carbonization and activation) and liquid products (after distillation with the selection of hydrocarbon fractions) was determined on a Chromos GC-1000 chromatograph.

Results and discussion

TheKendyrlyk oil shale was selected as a subject for research. The results of analyzes of the technical and chemical composition of shales are presented in tables 1, 2.

Table 3 and figure 1 show the temperature dependences of the gas components obtained as a result of the carbonization and activation of the Kendyrlik shale. The formation of combustible gas components (CO, H₂, CH₄) occurs in accordance with the basic chemical reactions:

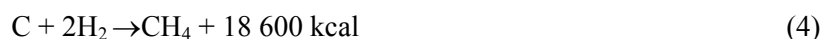
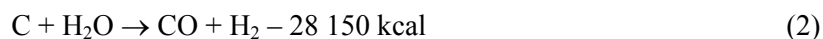


Table 1 – Characteristics of the Kendyrylyk shale

Indicator, wt.%	Value
Total moisture, W_t^f	1-10
Ash content, A^f	63-73
Volatile substances outlet, V^{daf}	20-23
Element composition, wt.%	
C^{daf}	76.88
H^{daf}	9.27
S_t^d	0.23
N^{daf}	1.25
O^{daf}	12.37
Chemical composition of the mineral part, wt.%	
SiO_2	58.2
Al_2O_3	17.2
Fe_2O_3	7.3
CaO	2.3
MgO	1.0
K_2O+Na_2O	10.5
SO_3	3.4

Table 2 – Chemical composition of Kendyrylyk shales

Element	Wt. %	Atom. %
C	25.75	37.80
O	37.41	41.23
Na	0.56	0.43
Mg	0.96	0.70
Al	4.74	3.10
Si	20.05	12.59
K	1.44	0.65
Ca	5.10	2.25
Fe	3.99	1.26

Table 3 – Temperature dependence of gas components obtained from Kendyrylyk shale

Temperature, °C							Gas composition, %							
							O ₂	H ₂	CO ₂	N ₂	CH ₄	CO	C ₂ H ₆	C ₃ H ₆ , C ₃ H ₈
200	–	–	–	–	–	–	53.9	0.30	35.6	8.31	–	–	1.12	–
–	350	–	–	–	–	–	41.9	11.8	24.5	4.22	4.61	6.93	3.8	2.19
–	–	450	–	–	–	–	19.8	20.7	37.6	4.49	3.75	8.93	3.24	1.47
–	–	–	650	–	–	–	15.2	9.63	40.6	4.96	–	24.4	2.75	2.38
–	–	–	–	750	–	–	10.8	9.57	23.8	4.41	–	48.8	2.24	0.29
–	–	–	–	–	850	–	13.76	38.3	2.62	2.21	–	39.8	3.18	0.13
–	–	–	–	–	–	900	4.02	33.4	1.28	6.65	2.86	49.5	2.24	0.04

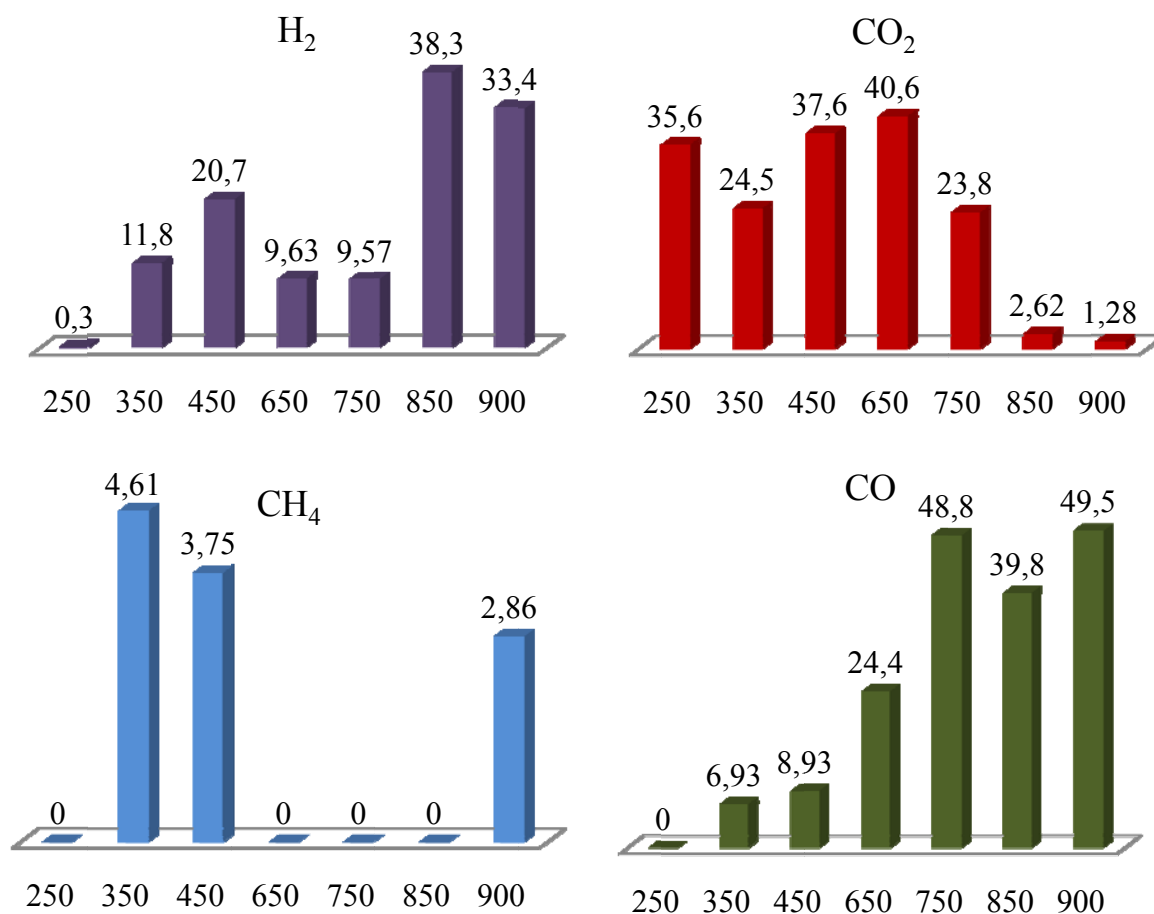


Figure 1 – Temperature dependence of gas components obtained from Kendyrlík shale

The obtained results show that the content of C₂-C₃ hydrocarbons at the whole temperature level is insignificant and is about 2-6%. In the transition from 450 °C to 650 °C, depending on the concentration of H₂ and simultaneously increases the content of CO. Beginning at a temperature of 750 °C, the CO₂ fraction decreases sharply and a significant increase in the calorific value of the gas is observed, due to an increase in CO, which is most likely to occur in accordance with the reaction (3). At a temperature of 850 °C, during the activation process, the H₂ content increases sharply (from 9.57 to 38.3%), due, apparently, to the supply of water vapor. The total fraction of the combustible gas components (CO, H₂, CH₄) increases and becomes greatest at the maximum shale activation temperature of 900°C. At the same time, H₂S is virtually absent during the entire process of the thermal deposition of oil shale.

The greatest oxygen content at 200-350 °C is associated with the release of pyrogenic water and oxygen-containing organic compounds, due to the decomposition of the side groups of macromolecules (since the carbon-oxygen bonds are the least stable in the thermal ratio). With further heating at 450-650 °C, oxygen is also observed in sufficient quantities (but to a lesser extent) because of the thermal decomposition reactions of the most thermostable organomineral complexes and the release of the bulk of the resin and gaseous hydrocarbons. In the temperature range 750-900 °C, decomposition of calcite and dolomite takes part in the formation of oxygen, the content of which can reach up to 50% in the mineral shale [14].

Table 4 shows the material balance of the shale activation of the Kendyrlík deposit.

Table 5 shows the elemental composition of the gas obtained as a result of the pyrolysis of the Kendyrlík shales.

Table 4 – Material Balance of Shale Activation of the Kendyrlík deposit

#	Incoming products	Content			№	Outgoing products	Content		
		g	cm ³	%			g	cm ³	%
1	Shale	500		96.2	1	Solid residue	398.0	306.0	76.5
2	Water (saturated steam)	20	7.8	3.8	2	Generator gas	68.4	59.5	13.2
	Total	520		100	3	Liquid product (resin)	3.6	3	0.7
					4	Water	50	50	9.6
						Total	520		100

Table 5 – Gas composition of pyrolysis of shales of the Kendyrlík deposit

Temperature, °C						Gas composition, vol, %							
						O ₂	H ₂	CO ₂	N ₂	CH ₄	CO	C ₂ H ₆	C ₃ H ₆ , C ₃ H ₈
350	–	–	–	–	–	54.0	3.08	27.5	9.40	0.00	0.15	3.48	2.31
–	400	–	–	–	–	28.2	11.0	28.1	10.7	1.41	16.6	2.75	1.16
–	–	450	–	–	–	52.5	2.32	31.7	9.3	0.01	0.12	1.93	2.07
–	–	–	720	–	–	32.7	4.77	8.75	7.15	–	44.4	1.42	0.78
–	–	–	–	820	–	61.7	6.03	4.12	5.25	0.14	22.4	0.29	0.03
–	–	–	–	–	900	59.5	9.51	1.97	4.93	–	23.9	0.15	–

As it can be seen from the data obtained, the most caloric gas (due to the content of the CO gas generally, 44%) is observed at a temperature of 720 °C, with an insignificant fraction of H₂ (≈5%), the absence of CH₄ and a small concentration of CO₂ (≈9%). A further increase in temperature to 820 °C leads to a significant decrease in the caloric value of the gas due to a significant decrease in CO (from 44.4 to 22.4%). In the course of pyrolysis, when the gas is heated to 900 °C, the C₂-C₃ (up to ≈6%) and CH₄ (up to 1.5%) gas concentrations are insignificant, the CO₂ content is significantly reduced (to ≈2%) and H₂S is practically absent.

In the process of pyrolysis of shales, the vapor-gas mixture was withdrawn to the refrigerator, where the hydrocarbon vapor condenses to form a shale resin. The liquid products obtained in this process in the temperature range 350-500 °C were distilled on a rotary evaporator (at temperatures T < 55 °C and T = 55-61 °C under vacuum) with the selection of hydrocarbon fractions. Figures 2 and 3 show the chromatograms of the obtained liquid pyrolysis products of Kendyrlík shale.

The component composition of fractions of liquid hydrocarbons formed during pyrolysis of shale is represented by a set of C₆-C₂₀ compounds (arenes, alkanes, isoalkanes, isocycloalkanes, alkenes, isoalkenes, isocycloalkenes). According to the results of the analysis (figures 2, 3), the main part of the products consists mainly of isoalkenes, alkanes and isocycloalkanes. Moreover, the hydrocarbon fractions obtained after distillation at T = 55-61 °C (under vacuum) have a much wider set of compounds than when T < 55 °C (under vacuum), mainly due to arenes, isoalkanes, isocycloalkanes.

The material balance of the pyrolysis of the Kendyrlík oil shale is shown in table 6. The results of the data show that the amount of liquid products obtained is much larger and the volume of synthetic gas is smaller compared to similar parameters for products obtained during the activation of shale with water vapor.

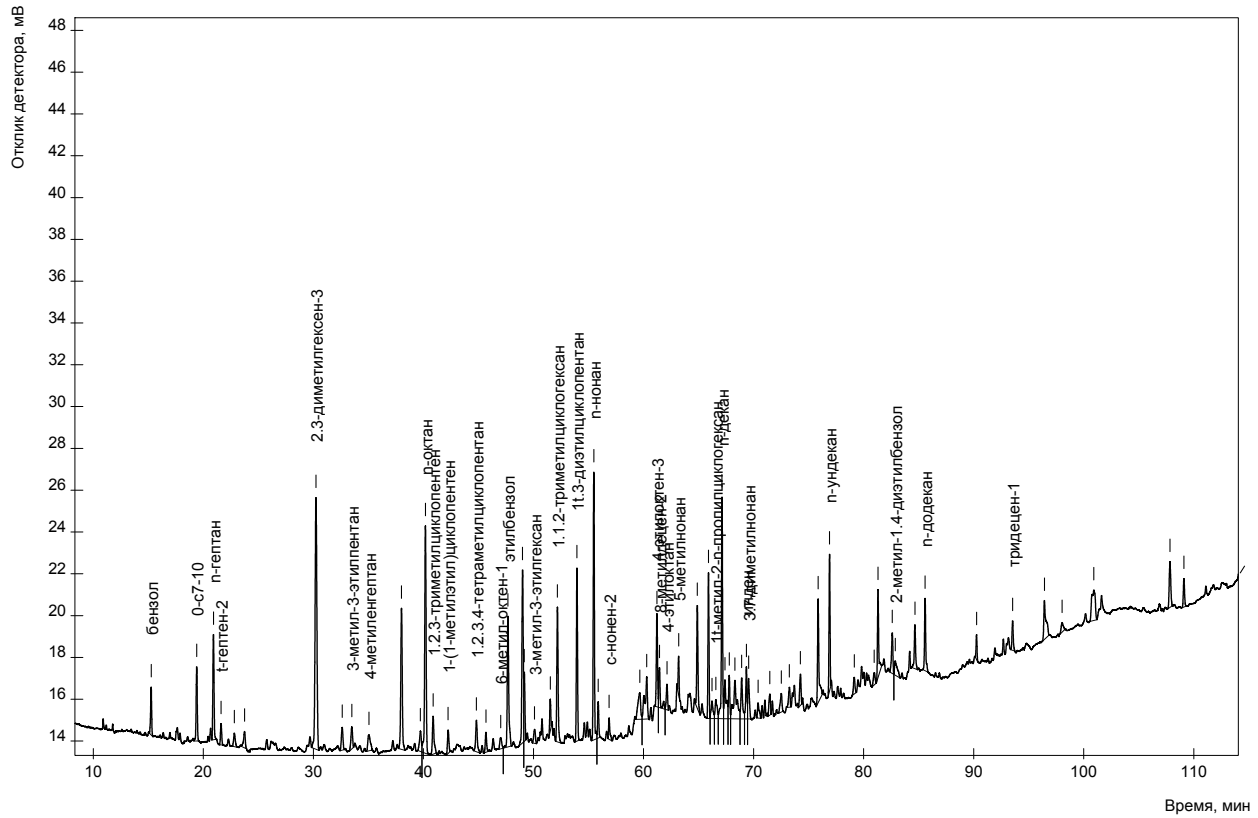


Figure 2 – Chromatogram of liquid pyrolysis products from Kendyrylksk shale obtained by distillation at T < 55 °C (under vacuum)

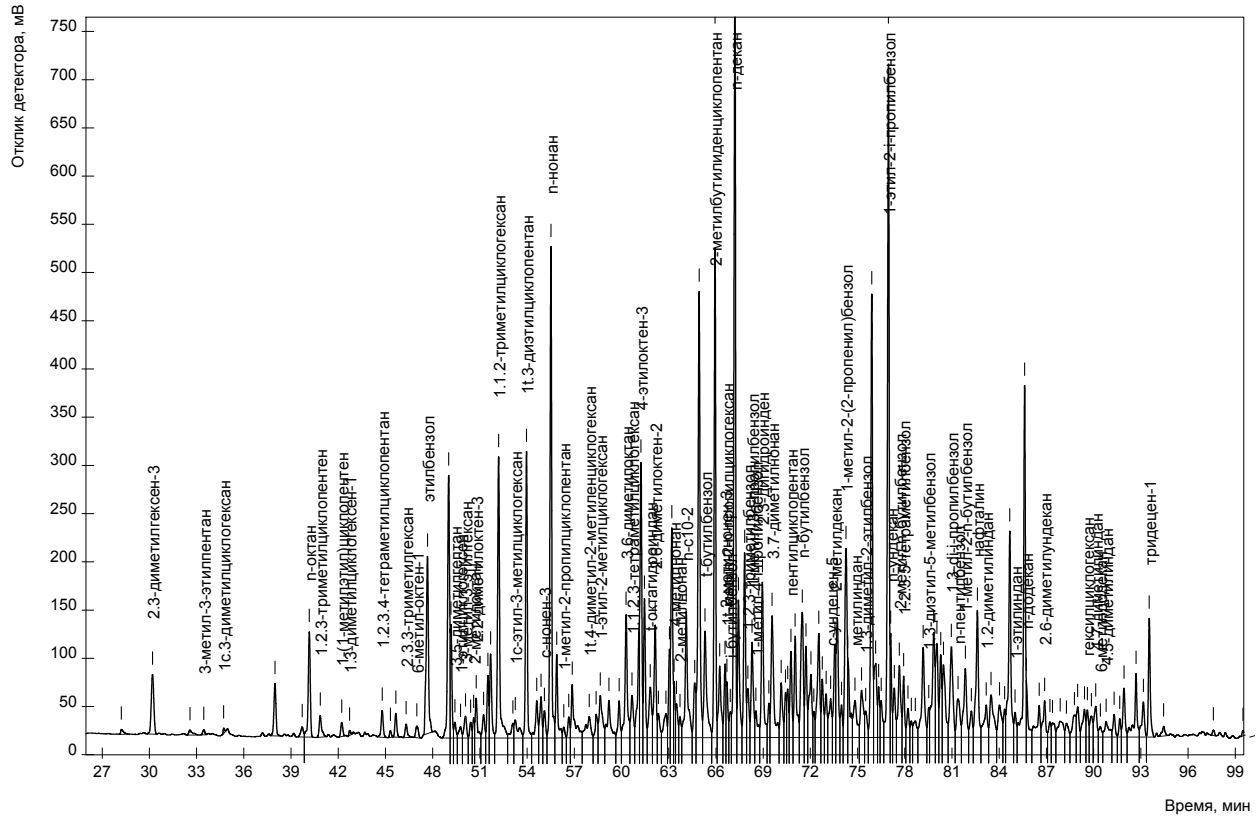


Figure 3 – Chromatogram of liquid pyrolysis products from Kendyrylksk shale obtained by distillation at T = 55-61 °C (under vacuum)

Table 6 – Material balance of pyrolysis of Kendyrylyk shale

#	Incoming products	Content			№	Outgoing products	Content		
		g	cm ³	%			g	cm ³	%
1	Shale	500		100	1	Solid residue	409.0	371.8	81.8
	Total	500		100	2	Generator gas	40.5	35.2	8.1
					3	Liquid product (resin)	29.0	24.2	5.8
					4	Water	21.5	21.5	4.3
						Total	500		100.0

Conclusions. The experiments on the thermal decomposition of the Kendyrylysk oil shale have shown that during the activation of the raw material with water vapor at a temperature of 900 °C a high-calorific synthetic gas with a low content of harmful and ballast substances is formed. Such gas may be suitable for use as an energy fuel (for obtaining thermal and electric energy) and as synthesis gas (CO, H₂). This gas, as well as the resin obtained as a result of pyrolysis (in argon), can be a valuable raw material for the production of motor fuels and other chemicals of chemical engineering (phenols, tannins, etc.).

The present work was carried out within the framework of the scientific and technical program No. 0020 / PTF-15 on the topic: "Development of technologies and creation of a pilot complex for deep processing of Kazakh shales with a feedstock capacity of 250 tons per year", funded by the Science Committee of the Ministry of Education and Science of the Republic of Kazakhstan.

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ИССЛЕДОВАНИЕ ПРОЦЕССА ТЕРМИЧЕСКОГО РАЗЛОЖЕНИЯ ГОРЮЧИХ СЛАНЦЕВ КЕНДЫРЛЫКСКОГО МЕСТОРОЖДЕНИЯ

Аннотация. В статье проведены эксперименты по термической обработке Кендырлыкского сланца путем его карбонизации и активации. Сначала проводили карбонизацию сланца в инертной среде аргона в интервале температур 25-700 °C и затем активацию сланца водяным паром при температуре 850-900 °C. Проведенный анализ элементного состава полученного синтетического газа показал, что наибольшая концентрация горючих компонентов газа (CO, H₂, CH₄) наблюдается при 900 °C (при отсутствии H₂S, низкого содержания CO₂ и малом количестве жидких продуктов – смолы). Также проводили пиролиз сланца в среде

аргона до 900 °С. В результате анализа компонентного состава жидких продуктов выявлено, что образуются преимущественно изоалкены, алканы и изоциклоалканы. Однако элементный состав полученного газа показал, что объем газа и его калорийность существенно ниже по сравнению с аналогичными параметрами для газа, выделяющегося в процессе активации сланца.

Ключевые слова: сланец, Кендырлык, карбонизация, активация, пиролиз, газ.

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КЕНДІРЛІК КЕНІШІНІҢ ЖАНҒЫШ СЛАНЕЦТІҢ ТЕРМИЯЛЫҚ ЫДЫРАУ ҮРДІСІН ЗЕРТТЕУ

Аннотация. Мақалада Кендірліксланецін термиялық өңдеу нәтижелері келтірілген. Алдымен сланец аргон қатысында, инертті ортада 25-700 °С температура интервалында карбонизацияланып, 850-900 °С температурада су буымен активация әдісімен өңделді. Түзілген синтетикалық газдың элементтік құрамын талдау нәтижесінде жанғыш газ компоненттерінің (СО, Н₂, СН₄) айтарлықтай концентрациясы 900 °С байқалды (Н₂С жоқ, СО₂ газы мен сұйық өнім-шайырдың аз мөлшері түзілген). Сонымен қатар аргон қатысында 900 °С-та сланецтің пиролизі жүргізілді. Түзілген сұйық өнімнің компоненттік құрамын талдау нәтижесінде негізінен изоалкендер, алкандар және изоциклоалкандар түзілгені анықталды. Алайда, түзілген газдың элементтік құрамынан анықталғандай газдың көлемі мен оның калориясы сланецті активациялау үдерісі кезінде бөлінетін газдың параметрлерімен салыстырғанда айтарлықтай төмен екені байқалды.

Түйін сөздер: тақтатас, Кендірлік, карбонизация, активация, пиролиз, газ.

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Верстка Д. Н. Калкабековой

Подписано в печать 14.05.2018.
Формат 70x881/8. Бумага офсетная. Печать – ризограф.
24,2 п.л. Тираж 300. Заказ 3.