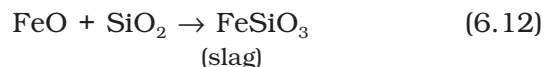


Fig. 6.3: A section of a modern reverberatory furnace

The sulphide ores of copper are heated in **reverberatory furnace** [Fig. 6.3]. If the ore contains iron, it is mixed with silica before heating. Iron oxide 'slags of'* as iron silicate and copper is produced in the form of **copper matte** which contains Cu_2S and FeS .



The SO_2 produced is utilised for manufacturing H_2SO_4 .

(b) Reduction of oxide to the metal

Reduction of the metal oxide usually involves heating it with a reducing agent, for example C, or CO or even another metal.

The reducing agent (e.g., carbon) combines with the oxygen of the metal oxide.



Some metal oxides get reduced easily while others are very difficult to be reduced (reduction means electron gain by the metal ion). In any case, heating is required.

6.4 Thermodynamic Principles of Metallurgy

Some basic concepts of thermodynamics help us in understanding the theory of metallurgical transformations. Gibbs energy is the most significant term. To understand the variation in the temperature required for thermal reductions and to predict which element will suit as the reducing agent for a given metal oxide (M_xO_y), Gibbs energy interpretations are made. The criterion for the feasibility of a thermal reduction is that at a given temperature Gibbs energy change of the reaction must be negative. The change in Gibbs energy, ΔG for any process at any specified temperature, is described by the equation:

$$\Delta G = \Delta H - T\Delta S \quad (6.14)$$

where, ΔH is the enthalpy change and ΔS is the entropy change for the process.

When the value of ΔG is negative in equation 6.14, only then the reaction will proceed. ΔG can become negative in the following situations:

1. If ΔS is positive, on increasing the temperature (T), the value of $T\Delta S$ increases so that $\Delta H < T\Delta S$. In this situation ΔG will become negative on increasing temperature.
2. If coupling of the two reactions, i.e. reduction and oxidation, results in negative value of ΔG for overall reaction, the final reaction becomes feasible. Such coupling is easily understood

* During metallurgy, 'flux' is added which combines with 'gangue' to form 'slag'. Slag separates more easily from the ore than the gangue. This way, removal of gangue becomes easier.

through Gibbs energy ($\Delta_r G^\ominus$) vs T plots for the formation of the oxides (Fig. 6.4). These plots are drawn for free energy changes that occur when one gram mole of oxygen is consumed.

The graphical representation of Gibbs energy was first used by H.J.T. Ellingham. This provides a sound basis for considering the choice of reducing agent in the reduction of oxides. This is known as **Ellingham Diagram**. Such diagrams help us in predicting the feasibility of thermal reduction of an ore.

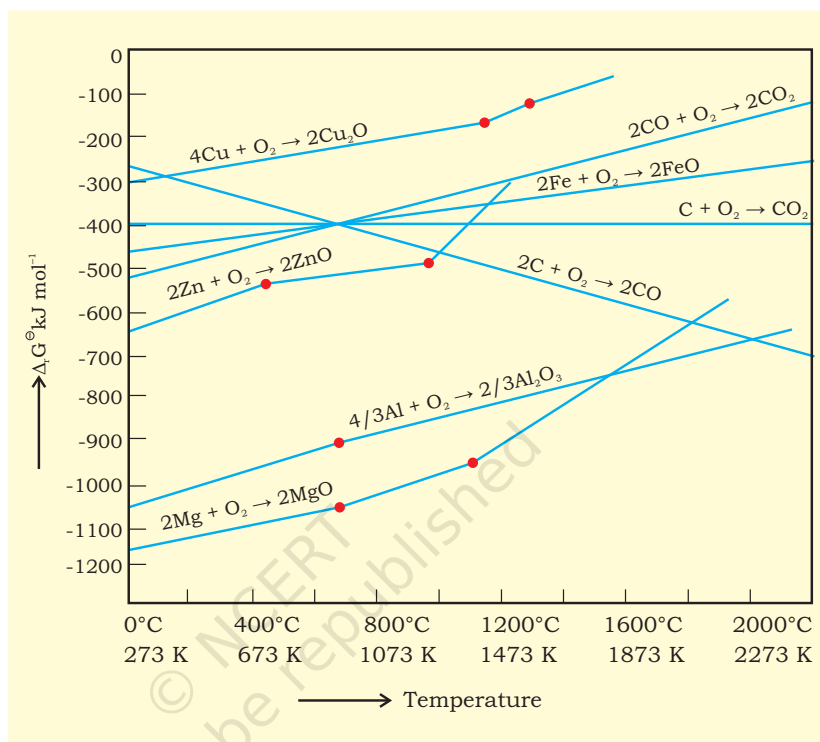
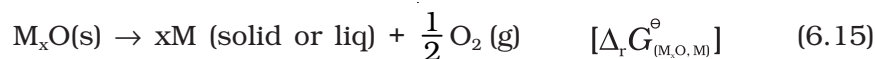


Fig. 6.4: Gibbs energy ($\Delta_r G^\ominus$) vs T plots (schematic) for the formation of some oxides per mole of oxygen consumed (Ellingham diagram)

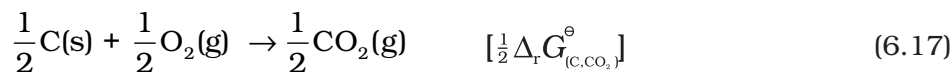
As we know, during reduction, the oxide of a metal decomposes and the reducing agent takes away the oxygen. The role of reducing agent is to provide $\Delta_r G^\ominus$ negative and large enough to make the sum of $\Delta_r G^\ominus$ of the two reactions, i.e., oxidation of the reducing agent and reduction of the metal oxide negative.



If reduction is carried out by carbon the oxidation of the reducing agent (i.e., C) will be there:



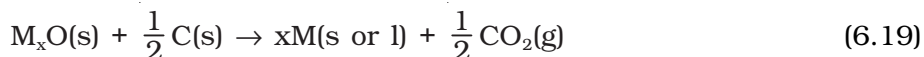
There may also be complete oxidation of carbon to CO_2 .



On coupling (combing) reaction 6.15 and 6.16 we get:



On coupling reaction 6.15 and 6.17 we have



Similarly, if carbon monoxide is reducing agent, reactions 6.15 and 6.20 given below need to be coupled.

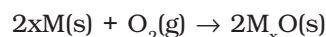


Over all reaction will be as follows:



Ellingham Diagram

- (a) Ellingham diagram normally consists of plots of $\Delta_f G^\circ$ vs T for the formation of oxides of common metals and reducing agents i.e., for the reaction given below.

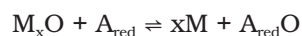


In this reaction, gas is consumed in the formation of oxide hence, molecular randomness decreases in the formation of oxide which leads to a negative value of ΔS as a result sign of $T\Delta S$ term in equation (6.14) becomes positive. Subsequently $\Delta_f G^\circ$ shifts towards higher side despite rising T . The result is positive slope in the curve for most of the reactions for the formation of $M_xO(s)$.

- (b) Each plot is a straight line and slopes upwards except when some change in phase ($s \rightarrow l$ or $l \rightarrow g$) takes place. The temperature at which such change occurs, is indicated by an increase in the slope on positive side (e.g., in the Zn, ZnO plot, the melting is indicated by an abrupt change in the curve) [Fig. 6.4].
- (c) When temperature is raised, a point is reached in the curve where it crosses $\Delta_f G^\circ = 0$ line. Below this temperature, $\Delta_f G^\circ$ for the formation of oxide is negative so M_xO is stable. Above this point, free energy of formation of oxide is positive. The oxide, M_xO will decompose on its own.
- (d) Similar diagrams are constructed for sulfides and halides also. From them it becomes clear that why reduction of M_xS is difficult.

Limitations of Ellingham Diagram

1. The graph simply indicates whether a reaction is possible or not, i.e., the tendency of reduction with a reducing agent is indicated. This is so because it is based only on the thermodynamic concepts. It does not explain the kinetics of the reduction process. It cannot answer questions like how fast reduction can proceed? However, it explains why the reactions are sluggish when every species is in solid state and smooth when the ore melts down. It is interesting to note here that ΔH (enthalpy change) and the ΔS (entropy change) values for any chemical reaction remain nearly constant even on varying temperature. So the only dominant variable in equation(6.14) becomes T . However, ΔS depends much on the physical state of the compound. Since entropy depends on disorder or randomness in the system, it will increase if a compound melts ($s \rightarrow l$) or vapourises ($l \rightarrow g$) since molecular randomness increases on changing the phase from solid to liquid or from liquid to gas.
2. The interpretation of $\Delta_f G^\circ$ is based on K ($\Delta G^\circ = -RT \ln K$). Thus it is presumed that the reactants and products are in equilibrium:



This is not always true because the reactant/product may be solid. In commercial processes reactants and products are in contact for a short time.

The reactions 6.18 and 6.21 describe the actual reduction of the metal oxide, M_xO , that we want to accomplish. The $\Delta_r G^\ominus$ values for these reactions in general, can be obtained from the corresponding $\Delta_f G^\ominus$ values of oxides.

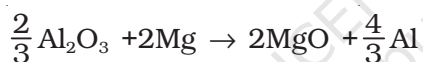
As we have seen, heating (i.e., increasing T) favours a negative value of $\Delta_r G^\ominus$. Therefore, the temperature is chosen such that the sum of $\Delta_r G^\ominus$ in the two combined redox processes is negative. In $\Delta_r G^\ominus$ vs T plots (Ellingham diagram, Fig. 6.4), this is indicated by the point of intersection of the two curves, i.e, the curve for the formation of M_xO and that for the formation of the oxide of the reducing substance. After that point, the $\Delta_r G^\ominus$ value becomes more negative for the combined process making the reduction of M_xO possible. The difference in the two $\Delta_r G^\ominus$ values after that point determines whether reduction of the oxide of the element of the upper line is feasible by the element of which oxide formation is represented by the lower line. If the difference is large, the reduction is easier.

Example 6.1 Suggest a condition under which magnesium could reduce alumina.

Solution The two equations are:



At the point of intersection of the Al_2O_3 and MgO curves (marked "A" in diagram 6.4), the $\Delta_r G^\ominus$ becomes ZERO for the reaction:



Below that point magnesium can reduce alumina.

Example 6.2 Although thermodynamically feasible, in practice, magnesium metal is not used for the reduction of alumina in the metallurgy of aluminium. Why?

Solution Temperatures below the point of intersection of Al_2O_3 and MgO curves, magnesium can reduce alumina. But the process will be uneconomical.

Example 6.3 Why is the reduction of a metal oxide easier if the metal formed is in liquid state at the temperature of reduction?

Solution The entropy is higher if the metal is in liquid state than when it is in solid state. The value of entropy change (ΔS) of the reduction process is more on positive side when the metal formed is in liquid state and the metal oxide being reduced is in solid state. Thus the value of $\Delta_r G^\ominus$ becomes more on negative side and the reduction becomes easier.

6.4.1 Applications (a) Extraction of iron from its oxides

After concentration, mixture of oxide ores of iron (Fe_2O_3 , Fe_3O_4) is subjected to **calcination/roasting** to remove water, to decompose carbonates and to oxidise sulphides. After that these are mixed with limestone and coke and fed into a *Blast furnace* from its top, in which the oxide is reduced to the metal. In the Blast furnace,

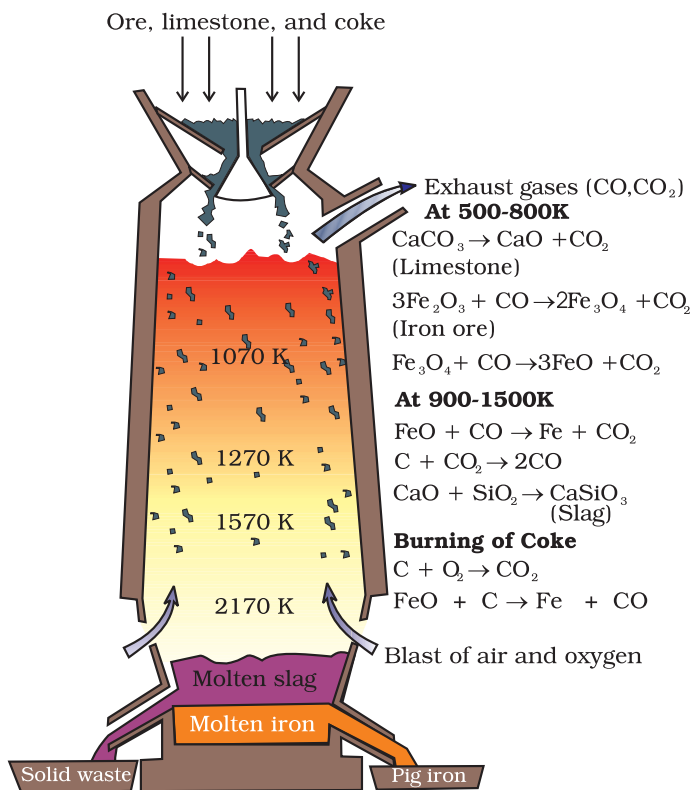
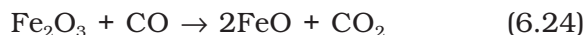


Fig. 6.5: Blast furnace

[Fig. 6.5] reduction of iron oxides takes place at different temperature ranges. A blast of hot air is blown from the bottom of the furnace by burning coke in the lower portion to give temperature upto about 2200K. The burning of coke, therefore, supplies most of the heat required in the process. The CO and heat move to the upper part of the furnace. In upper part, the temperature is lower and the iron oxides (Fe₂O₃ and Fe₃O₄) coming from the top are reduced in steps to FeO. These reactions can be summarised as follows:

At 500 – 800 K (lower temperature range in the blast furnace),

Fe₂O₃ is first reduced to Fe₃O₄ and then to FeO

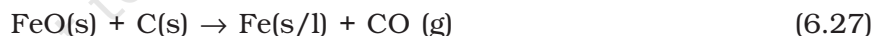


Limestone is also decomposed to CaO which removes silicate impurity of the ore as slag. The slag is in molten state and separates out from iron.

At 900 – 1500 K (higher temperature range in the blast furnace):



Thermodynamics helps us to understand how coke reduces the oxide and why this furnace is chosen. One of the main reduction steps in this process involves reaction 6.27 given below.



This reaction can be seen as a reaction in which two simpler reactions have coupled. In one the reduction of FeO is taking place and in the other, C is being oxidised to CO:



When both the reactions take place to yield the equation (6.27), the net Gibbs energy change becomes:



Naturally, the resultant reaction will take place when the right hand side in equation 6.30 is negative. In $\Delta_r G^\ominus$ vs T plot representing the change Fe → FeO in Fig. 6.4 goes upward and that representing the change C → CO (C, CO) goes downward. They cross each other at about

1073K. At temperatures above 1073K (approx.), the C, CO line is below the Fe, FeO line $[\Delta_r G^\ominus]_{(C,CO)} < [\Delta_r G^\ominus]_{(FeO,Fe)}$. So above 1073 K in the range of temperature 900–1500 K coke will reduce FeO and will itself be oxidised to CO. Let us try to understand this through Fig. 6.4 (approximate values of $\Delta_r G^\ominus$ are given). At about 1673K (1400°C) $\Delta_r G^\ominus$ value for the reaction:

$2FeO \rightarrow 2Fe + O_2$ is $+341 \text{ kJmol}^{-1}$ because it is reverse of $Fe \rightarrow FeO$ change and for the reaction

$2C + O_2 \rightarrow 2CO$ $\Delta_r G^\ominus$ is -447 kJmol^{-1} . If we calculate $\Delta_r G^\ominus$ value for overall reaction (6.27 the value will be -53 kJmol^{-1}). Therefore, reaction 6.27 becomes feasible. In a similar way the reduction of Fe_3O_4 and Fe_2O_3 by CO at relatively lower temperatures can be explained on the basis of lower lying points of intersection of their curves with the CO, CO_2 curve.

The iron obtained from Blast furnace contains about 4% carbon and many impurities in smaller amount (e.g., S, P, Si, Mn). This is known as **pig iron**. It can be moulded into variety of shapes. **Cast iron** is different from *pig iron* and is made by melting pig iron with scrap iron and coke using hot air blast. It has slightly lower carbon content (about 3%) and is extremely hard and brittle.

Further Reductions

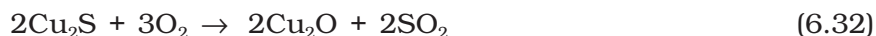
Wrought iron or malleable iron is the purest form of commercial iron and is prepared from cast iron by oxidising impurities in a reverberatory furnace lined with haematite. The haematite oxidises carbon to carbon monoxide:



Limestone is added as a flux and sulphur, silicon and phosphorus are oxidised and passed into the slag. The metal is removed and freed from the slag by passing through rollers.

(b) Extraction of copper from cuprous oxide [copper(I) oxide]

In the graph of $\Delta_r G^\ominus$ vs T for the formation of oxides (Fig. 6.4), the Cu_2O line is almost at the top. So it is quite easy to reduce oxide ores of copper directly to the metal by heating with coke. The lines (C, CO) and (C, CO_2) are at much lower positions in the graph particularly after 500 – 600K. However, many of the ores are sulphides and some may also contain iron. The sulphide ores are roasted/smelted to give oxides:



The oxide can then be easily reduced to metallic copper using coke:

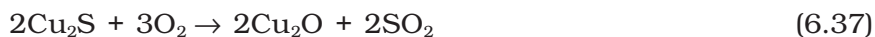


In actual process, the ore is heated in a reverberatory furnace after mixing with silica. In the furnace, iron oxide ‘slags off’ as iron silicate is formed. Copper is produced in the form of **copper matte**. This contains Cu_2S and FeS .



Copper matte is then charged into silica lined convertor. Some silica is also added and hot air blast is blown to convert the remaining

FeS, FeO and Cu₂S/Cu₂O to the metallic copper. Following reactions take place:



The solidified copper obtained has blistered appearance due to the evolution of SO₂ and so it is called **blister copper**.

(c) Extraction of zinc from zinc oxide

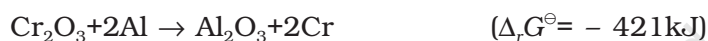
The reduction of zinc oxide is done using coke. The temperature in this case is higher than that in the case of copper. For the purpose of heating, the oxide is made into brickettes with coke and clay.



The metal is distilled off and collected by rapid chilling.

Intext Questions

6.3 The reaction,



is thermodynamically feasible as is apparent from the Gibbs energy value. Why does it not take place at room temperature?

6.4 Is it true that under certain conditions, Mg can reduce Al₂O₃ and Al can reduce MgO? What are those conditions?

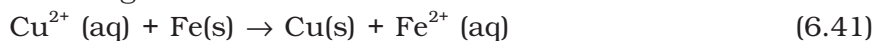
6.5
Electrochemical Principles of Metallurgy

We have seen how principles of thermodynamics are applied to **pyrometallurgy**. Similar principles are effective in the reductions of metal ions in solution or molten state. Here they are reduced by electrolysis or by adding some reducing element.

In the reduction of a molten metal salt, electrolysis is done. Such methods are based on electrochemical principles which could be understood through the equation,

$$\Delta G^\ominus = -nE^\ominus F \quad (6.40)$$

here n is the number of electrons and E[⊖] is the electrode potential of the redox couple formed in the system. More reactive metals have large negative values of the electrode potential. So their reduction is difficult. If the difference of two E[⊖] values corresponds to a positive E[⊖] and consequently negative ΔG[⊖] in equation 6.40, then the less reactive metal will come out of the solution and the more reactive metal will go into the solution, e.g.,



In simple electrolysis, the Mⁿ⁺ ions are discharged at negative electrodes (cathodes) and deposited there. Precautions are taken considering the reactivity of the metal produced and suitable materials are used as electrodes. Sometimes a flux is added for making the molten mass more conducting.

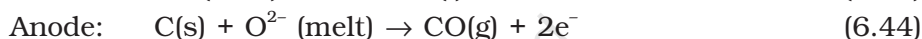
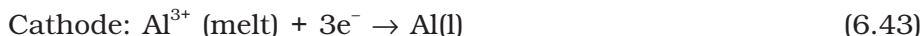
Aluminium

In the metallurgy of aluminium, purified Al_2O_3 is mixed with Na_3AlF_6 or CaF_2 which lowers the melting point of the mixture and brings conductivity. The fused matrix is electrolysed. Steel vessel with lining of carbon acts as cathode and graphite anode is used. The overall reaction may be written as:



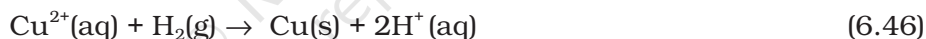
This process of electrolysis is widely known as **Hall-Heroult process**.

Thus electrolysis of the molten mass is carried out in an electrolytic cell using carbon electrodes. The oxygen liberated at anode reacts with the carbon of anode producing CO and CO_2 . This way for each kg of aluminium produced, about 0.5 kg of carbon anode is burnt away. The electrolytic reactions are:



Copper from Low Grade Ores and Scraps

Copper is extracted by *hydrometallurgy* from low grade ores. It is leached out using acid or bacteria. The solution containing Cu^{2+} is treated with scrap iron or H_2 (equations 6.40; 6.46).



Example 6.4

At a site, low grade copper ores are available and zinc and iron scraps are also available. Which of the two scraps would be more suitable for reducing the leached copper ore and why?

Solution

Zinc being above iron in the electrochemical series (more reactive metal is zinc), the reduction will be faster in case zinc scraps are used. But zinc is costlier metal than iron so using iron scraps will be advisable and advantageous.

6.6 Oxidation Reduction

Besides reductions, some extractions are based on oxidation particularly for non-metals. A very common example of extraction based on oxidation is the extraction of chlorine from brine (chlorine is abundant in sea water as common salt) .



The ΔG^\ominus for this reaction is + 422 kJ. When it is converted to E^\ominus (using $\Delta G^\ominus = -nE^\ominus F$), we get $E^\ominus = -2.2$ V. Naturally, it will require an external emf that is greater than 2.2 V. But the electrolysis requires an excess potential to overcome some other hindering reactions (Unit-3, Section 3.5.1). Thus, Cl_2 is obtained by electrolysis giving out H_2 and aqueous NaOH as by-products. Electrolysis of molten NaCl is also carried out. But in that case, Na metal is produced and not NaOH .

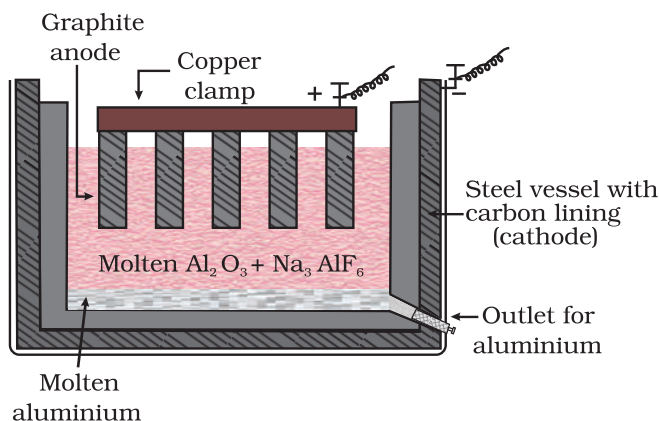
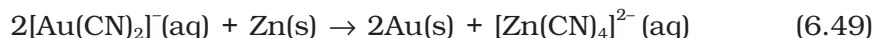
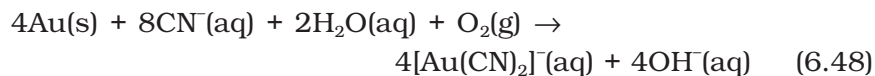


Fig. 6.6: Electrolytic cell for the extraction of aluminium

As studied earlier, extraction of gold and silver involves leaching the metal with CN^- . This is also an oxidation reaction ($\text{Ag} \rightarrow \text{Ag}^+$ or $\text{Au} \rightarrow \text{Au}^+$). The metal is later recovered by displacement method.



In this reaction zinc acts as a reducing agent.

6.7 Refining

A metal extracted by any method is usually contaminated with some impurity. For obtaining metals of high purity, several techniques are used depending upon the differences in properties of the metal and the impurity. Some of them are listed below.

- | | |
|---------------------------|-----------------------------|
| (a) Distillation | (b) Liquation |
| (c) Electrolysis | (d) Zone refining |
| (e) Vapour phase refining | (f) Chromatographic methods |

These are described in detail here.

(a) Distillation

This is very useful for low boiling metals like zinc and mercury. The impure metal is evaporated to obtain the pure metal as distillate.

(b) Liquation

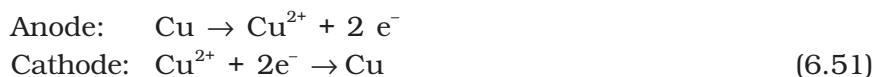
In this method a low melting metal like tin can be made to flow on a sloping surface. In this way it is separated from higher melting impurities.

(c) Electrolytic refining

In this method, the impure metal is made to act as anode. A strip of the same metal in pure form is used as cathode. They are put in a suitable electrolytic bath containing soluble salt of the same metal. The more basic metal remains in the solution and the less basic ones go to the anode mud. This process is also explained using the concept of electrode potential, over potential, and Gibbs energy which you have seen in previous sections. The reactions are:



Copper is refined using an electrolytic method. Anodes are of impure copper and pure copper strips are taken as cathode. The electrolyte is acidified solution of copper sulphate and the net result of electrolysis is the transfer of copper in pure form from the anode to the cathode:



Impurities from the blister copper deposit as anode mud which contains antimony, selenium, tellurium, silver, gold and platinum; recovery of these elements may meet the cost of refining. Zinc may also be refined this way.