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Influence of chemical and biogenic leaching on surface area and particle size of laterite ore

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Abstract: Currently there is a decline in the world's nickel sulfide deposits, which are the main source of this metal. Due to the fact, that more than 70% of nickel reserves are in the form of oxide ores, more attention is nowadays paid on laterites. Leaching processes using different organic acids are widely described in the literature, but there is a lack of works linking influence of leaching process with the surface area and particle size distribution. Therefore, the main aim of this study was to examine how citric acid produced by microorganisms and citric acid added as chemical affected the specific surface and particle size distribution of mineral particles. The laterite ore was obtained from Szklary deposit, Poland. This study also compared the effect of chemical citric acid and filtrate after cultivation of *Aspergillus niger* on nickel extraction. It was observed that higher nickel recovery correspond to higher surface area of particles. The highest yield of nickel extraction was observed for a citric acid concentration of 1 mol/dm³ (67%). The specific surface area after leaching was 159 m²/g. An analysis of particle size distribution showed increase in the median particle size of particles after leaching with citric acid. It may suggest that dissolution of Polish laterites follows a shrinking core-shrinking particle model.

Keywords: *nickel, laterite ore, leaching, citric acid, Aspergillus niger*

Introduction

Nickel is an important metal used for a wide variety of applications. World deposits of this metal are in the forms of sulfide and oxide (laterites) ores. Currently, the majority of nickel is obtained by exploiting the sulfide ores. In laterites, nickel is associated with either iron oxide or silicate compounds and due to its complex structure it is difficult to treat the ore by flotation. This increases the expenditure of energy and generates costs of the process (Ministry of the Environment, 2001).

Due to the fact that more than 70% of the world reserves of this metal is in the form of non-sulfide ores, more attention is directed to laterites (Moskalyk and Alfantazi, 2002; Elias, 2002; Gleeson et al., 2003; Dalvi et al., 2004; Watling, 2008).

Starting from the 1950s, the world production of nickel from laterite has been increasing (Dalvi et al., 2004).

The laterites are usually treated using pyrometallurgical and hydrometallurgical processes. During past few decades, also bioleaching has been applied as environmentally friendly and low cost process. Metal recovery from non-sulfide ores using microorganisms is based on activity of heterotrophic fungi and bacteria. Extraction of metals is an effect of organic acid, chelating and complexing compounds “produced” by these microorganisms into the liquid medium. Most common microorganisms used are fungi like *Aspergillus* and *Penicillium* and also some chemolithotrophic microorganisms (*Acidithiobacillus ferrooxidans*, *Acidithiobacillus caldus*, *Leptospirillum ferrooxidans*) (Bosecker, 1986; Coto et al., 2001; Valix et al., 2001a; Alibhai et al., 1993; Tzeferis, 1994; Mohapatra et al., 2007; Simate and Ndlovu 2007, 2008; Simate et al., 2009).

Recently, *Acidithiobacillus ferrooxidans* bacteria are also used to bioleach laterite nickel ores under anaerobic conditions (Hallberg et al., 2011, du Plessis et al., 2011 and Behera et al., 2012). The obtained results are promising for extraction of metals from the low grade laterite ores. However, practical application of this method to the industry involves many difficulties to overcome.

Table 1. Chemical leaching of nickel oxide ore using different organic acids.

Organic acid	Mineral material	Metal	Yield of extraction, %	References
Citric acid	Limonite, nontronite,	Co	65-95	Tang and Valix, 2006
Lactic acid/Malic acid	New Caledonia	Ni	15-35	
Citric acid	Laterites: After Caron process	Co	85	Coto et al., 2008
Citric acid	Laterite ore, Indonesia	Co	55	Li al., 2010
Citric acid + ammonium hydrogen bifluoride		Co	85.7	
Citric acid	Saprolite	Ni	80	Valix et al., 2001b
	Weathered saprolite	Ni	60	
	Limonite			
	Nontronite	Ni	20	
		Ni	5	
Oxalic acid	Oxide ores, Gaspé, Canada	Cu	7	Mulligan et al., 2004
		Fe	35	
		Ni	14	
		Zn	32	
Citric acid	Oxide ores, Gaspé, Canada	Cu	30	
		Fe	6	
		Ni	60	
		Zn	10	
Oxalic acid	Chromite Overburden, Sukinda Mines, Odisha, India	Ni	39	Behera et al., 2013
Citric acid		Ni	21.5	

To extract metal from laterites organic acids, both chemical grade and those produced by microorganisms, are used. It has been shown that the dissolution rate of metals depends on the concentration of acid in the broth. The mineral composition of ore also affects the effectiveness of metal dissolution (Alibhai et al., 1993; Burgstaller and Schinner, 1993; Tzeferis, 1994; Tzeferis and Agatzini-Leonardou, 1994; Castro et al., 2000). Different organic acids used as leaching reagents are presented in Table 1. Citric acid used as a lixiviant is considered to be most effective in selective extraction of nickel and cobalt from non-sulfide ores (Pradhan et al., 2006).

Material and methods

The raw material used in the laboratory experiments was the laterite ore obtained from the Szklary deposit (Poland). Samples used in the experiment were crushed and milled.

An X-ray diffraction analysis (Fig. 1) showed the presence of magnetite (Fe_3O_4), insignificant quantities of goethite grains (FeOOH), small grains of silica minerals (mainly chalcedony), magnesite and magnesium silicate minerals and fragments of montmorillonites (pimelite, vermiculite and garnierite). The chemical analysis of the sample is presented in Table 2.

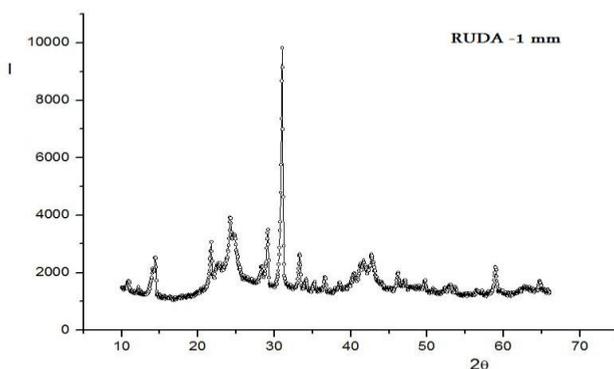


Fig. 1. X-ray diffraction pattern of laterite ore sample. Fraction –1 mm

Table 2. Chemical composition of nickel laterite ore from Szklary deposit

Co, ppm	Fe, %	Mg, %	Ni, %
177	8.51	7.31	1.17

The particle size distribution determined by laser diffraction using Malvern Mastersizer 2000 equipped with HydroMU dispersion unit (Malvern UK) showed that D_{10} , D_{50} , D_{90} sizes were 4.75, 28.62 and 303.70 μm respectively. The particles specific surface area was measured by the Brunauer-Emmett-Teller (BET) method for the

helium/nitrogen mixture using a FlowsorbII apparatus (Micrometrics) and was 44.76 m²/g. The bulk density was 1.12 g/cm³ and the density was found as 2.53 g/cm³.

Leaching experiments were carried out for different concentrations of citric acid (0.027, 0.25, 0.5 and 1.0 mol/dm³) at ambient temperature for 49 days. Samples contained 100 cm³ of citric acid solution and 2.5% (w/v) of laterite ore. Deionized water and chemical grade reagents were used. The fungal culture filtrates were also used as the leaching reagent. A microorganism, *Aspergillus niger* Ł0581 producing mainly citric acid, was obtained from the Institute of Fermentation Technology and Microbiology, Lodz University of Technology.

First, nutrient broth was prepared. The Czapek-Dox growth medium was used (Table 3). Microorganisms were cultivated for four days and after this time the mixture was autoclaved and filtered to remove dead biomass. Only filtrates, citric acid concentration of 0.027 mol/dm³, were taken for further leaching experiments. Samples contained 100 cm³ of broth and 2.5% (w/v) of laterite.

The process was monitored by analyzing changes of nickel concentration, specific surface area and particle size distribution of mineral particles. The ICP-OES method was used to measure concentration of nickel ions in the solution.

Table 3. Growth medium Czapek-Dox for microorganism *A. niger* Ł0581

Component	Amount, g/dm ³
NaNO ₃	2.0
K ₂ HPO ₄	2.0
KCl	0.5
MgSO ₄ ·7H ₂ O	0.5
FeSO ₄ ·7H ₂ O	0.02
ZnSO ₄ ·7H ₂ O	0.02
CuSO ₄ ·5H ₂ O	0.08
Sucrose	30

Results and discussion

Nickel leaching recoveries for different leaching reagents are presented in Fig. 2. The highest yield of nickel extraction was observed for 1.0 (67%) and 0.5 mol/dm³ citric acid (65%). The reported recovery of nickel for *A. niger* broth was very low, which suggested that it was not effective as a lixiviant. After two weeks of the process there was a decrease in the nickel concentration, probably due to either biosorption or complexation of metal by organic compounds present in the broth.

Except of changes in the nickel concentration during leaching process using different leaching reagents, also the effect of leaching process on the surface area of the laterite ore particles was examined. The results are shown in Fig. 3 and Table 4. In

the early leaching step of the process, the surface area decreased in all samples. To explain this phenomenon, samples of laterite ore were analyzed after contact with deionized water. Obtained results showed that decrease in the surface area of particles was caused by dissolution of the smallest grains. The smaller particle, the higher is the surface area, therefore reduce in the proportion of fine grains resulted in a decrease of the specific surface area of the sample.

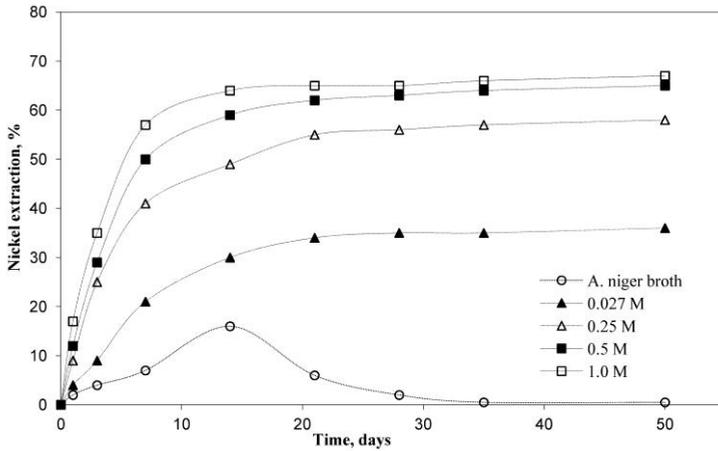


Fig. 2. Nickel extraction changes in time for different concentrations of citric acid and *A.niger* broth

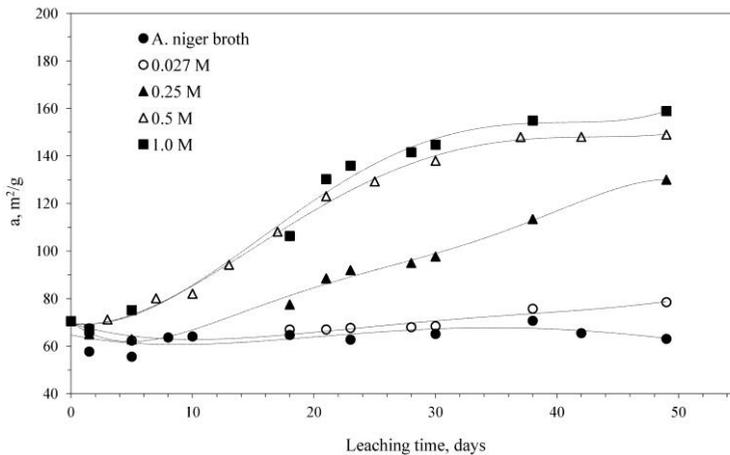


Fig. 3. Average values of specific surface area of Szklary laterite ore (fraction -1 mm) during leaching with different concentrations of citric acid and microbial broth of *A.niger*

For water suspension of ore, after decrease in the surface area during first days this value was maintained at a constant level (Table 4). In the case of leaching with different concentrations of citric acid (0.027-1.0 mol/dm³), after significant decrease in

the surface area the gradual increase of surface was observed in time. The largest increase in the specific surface area was obtained for the leaching process with 1.0 mol/dm³ citric acid (159 m²/g), and the lowest value for the *A. niger* broth. The specific surface area was in this case only 63 m²/g.

Table 4. A specific surface area changes of laterite ore, during leaching and bioleaching

Lixiviant	<i>a</i> , m ² /g			
	<i>t_i</i>	<i>t₃₆</i>	<i>t_f</i>	$\Delta a (t_f - t_{36})$
Water	70.5	57.1	55.9	(-) 1.2
<i>A. niger</i> broth	70.5	57.7	63.1	5.40
0.027 M citric acid	70.5	67.5	78.5	11.0
0.25 M citric acid	70.5	65.0	130	65.0
0.5 M citric acid	70.5	66.6	149	82.4
1.0 M citric acid	70.5	67.0	159	92.0

t_i – initial value, *t₃₆* – specific surface area after 36 h, *t_f* – final value (after 49 days)

A correlation of final surface area value with a yield of nickel extraction was observed. The higher degree of metal extraction corresponded to the higher specific surface area. Similar correlations for increasing the particle surface with greater yield of metal leached (black shale ore) was observed by Schubert (2007). Changes in the particle surface area during leaching processes can be explained by formation of a porous layer (also called a ash layer). The ash layer is formed by part of ore particle that has been difficult to leach (Levenspiel, 1999, Burghard and Bartelmus, 2001).

Table 5. *D*₁₀, *D*₅₀, *D*₉₀ for different lixiviant determined at the beginning of the process (*t_i*), after 36 h (*t₃₆*) and 49 days (*t_f*)

Lixiviant	Time	<i>D</i> ₁₀ , μm	<i>D</i> ₅₀ , μm	<i>D</i> ₉₀ , μm	<i>a</i> , m ² /g
H ₂ O	<i>t_i</i>	4.75	28.6	304	70.5
	<i>t_f</i>	4.46	31.3	480	55.9
<i>A. niger</i> broth	<i>t₃₆</i>	6.57	36.4	374	
	<i>t_f</i>	5.34	42.1	397	63.1
0.027 M citric acid	<i>t₃₆</i>	5.79	36.7	477	
	<i>t_f</i>	5.47	36.6	471	78.5
0.25 M citric acid	<i>t₃₆</i>	6.44	38.2	506	
	<i>t_f</i>	7.48	42.8	475	130
0.5 M citric acid	<i>t₃₆</i>	7.17	43.2	510	
	<i>t_f</i>	7.25	47.6	498	149
1.0 M citric acid	<i>t₃₆</i>	6.98	45.5	628	
	<i>t_f</i>	8.54	49.6	541	159

To properly determine changes taking place in the solid phase during the leaching process, measurements of particle size distribution of leachable material after 36 h and at the end of the process (after 49 days) were carried out. The results for the various concentrations of leaching solutions are shown in Table 5, which lists the volume fraction of the particles taken from the cumulative particle size distribution curve. All data were compared to initial values. It can be concluded that there is a correlation between the increase in the specific surface area and particle size distribution. The specific surface of the grains increased with increasing the concentration of citric acid. In the case of the lowest concentration (0.027 mol/dm^3) the distribution of particles after 49 days of leaching was similar to baseline (suspension of ore and water). The maximum surface area was obtained with 1.0 mol/dm^3 citric acid concentration.

Conclusions

The experiments demonstrated that citric acid may serve as an effective reagent for extraction of nickel from Polish laterites. It was observed, that specific surface area of laterite ore particles changed during leaching and it was correlated with the concentration of a lixiviant used in the process. Higher nickel recovery corresponded to higher surface area of mineral particles. The highest yield of metal extraction was achieved for 1 mol/dm^3 citric acid and was equal to 67%. The specific surface area was in this case $159 \text{ m}^2/\text{g}$. The analysis of particle size distribution before and after the process showed the increase in the median particle size (D_{50}), probably due to decrease of percentage of the smallest grains. It may suggest that leaching of the investigated laterite ore using citric acid follows the shrinking core-shrinking particle model.

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