Analytical Separations for Rare Earth Elements and Impurities in Rare Earth Concentrates

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Utilizing combinations of co-precipitation, solvent extraction and chromatography to design efficient analytical and preparative scale separations

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RRMC
Radiobioassay & Radiochemical Measurements Conference
RRMC 2013
Rohnert Park, California
October 21 -October 25, 2013

Application of EXC to Large Scale Separations

Limitation	Consequence(s)
High cost of resins	High Value Products
	Resin Stability
	Analytical Applications

Application of EXC to Large Scale Separations

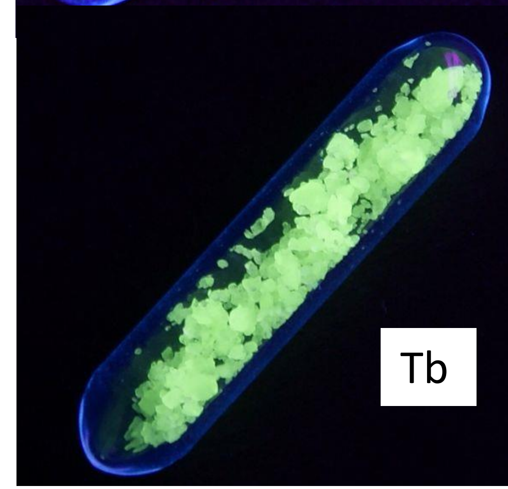
Limitation	Consequence(s)
Low Capacity	High Value Products
	Scavenge trace elements from large stream
	Add value to existing stream
	Enable better analytical results

Rare Earths?


PLJ 243

PLUG-IN SUPPLY
INC




Eu

Tb


MOLYCORP

U.S. PRODUCTION Molycorp plans to restart production from its Mountain Pass, Calif., mine in 2012. It would be the only operating rare-earths mine in the U.S.

CONCERN GROWS OVER RARE-EARTHS SUPPLY

Government tries to respond to U.S. vulnerability in these **CRITICAL MATERIALS**

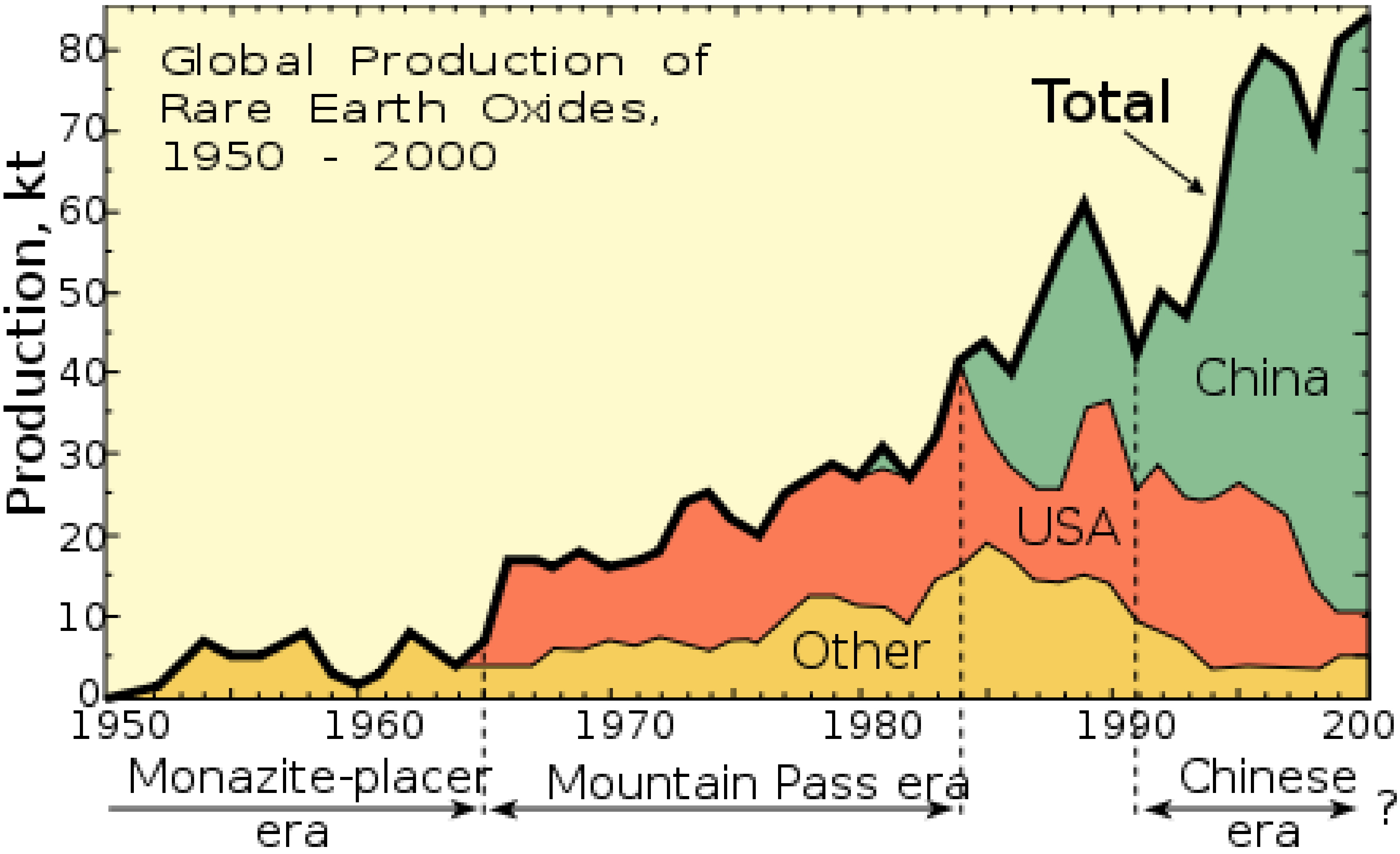
DAVID J. HANSON, C&EN WASHINGTON

comprehensive bills focused on energy," says Jeffery A. Green, of J. A. Green & Co., a Washington, D.C., consulting company specializing in the rare-earths problem. "The spectrum runs from just studying the issues to actually getting out there to rev up production."

Congress is most concerned about the use of rare earths in national security and energy-efficiency technologies. According to the CRS report, DOD estimates the U.S. uses about 5% of the world's production of rare earths for defense purposes. For instance, the agency uses samarium cobalt magnets for disk drive motors on aircraft, tanks, and missile systems; in lasers for mine detection and various countermeasures; and in satellite communications and radar aboard ships and submarines. SmCo magnets are seen as ideal for such defense purposes because they retain their magnetic strength at elevated temperatures.

Gareth P. Hatch, founding principal of

Production



Global Production of Rare Earth Oxides, 1950 - 2000
Total
China
USA
Other
Production, kt
0
10
20
30
40
50
60
70
80
1950
1960
1970
1980
1990
200
Monazite-placer era
Mountain Pass era
Chinese era
?

Production

World Mine Production and Reserves (2009 Data)		
Country	Production (Metric Ton)	Reserves (Metric Ton)
United States	insignificant	13,000,000
Australia	insignificant	5,400,000
Brazil	650	48,000
China	120,000	36,000,000
Commonwealth of Independent States	not available	19,000,000
India	2,700	3,100,000
Malaysia	380	30,000
Other countries	not available	22,000,000
World total (rounded)	124,000	99,000,000

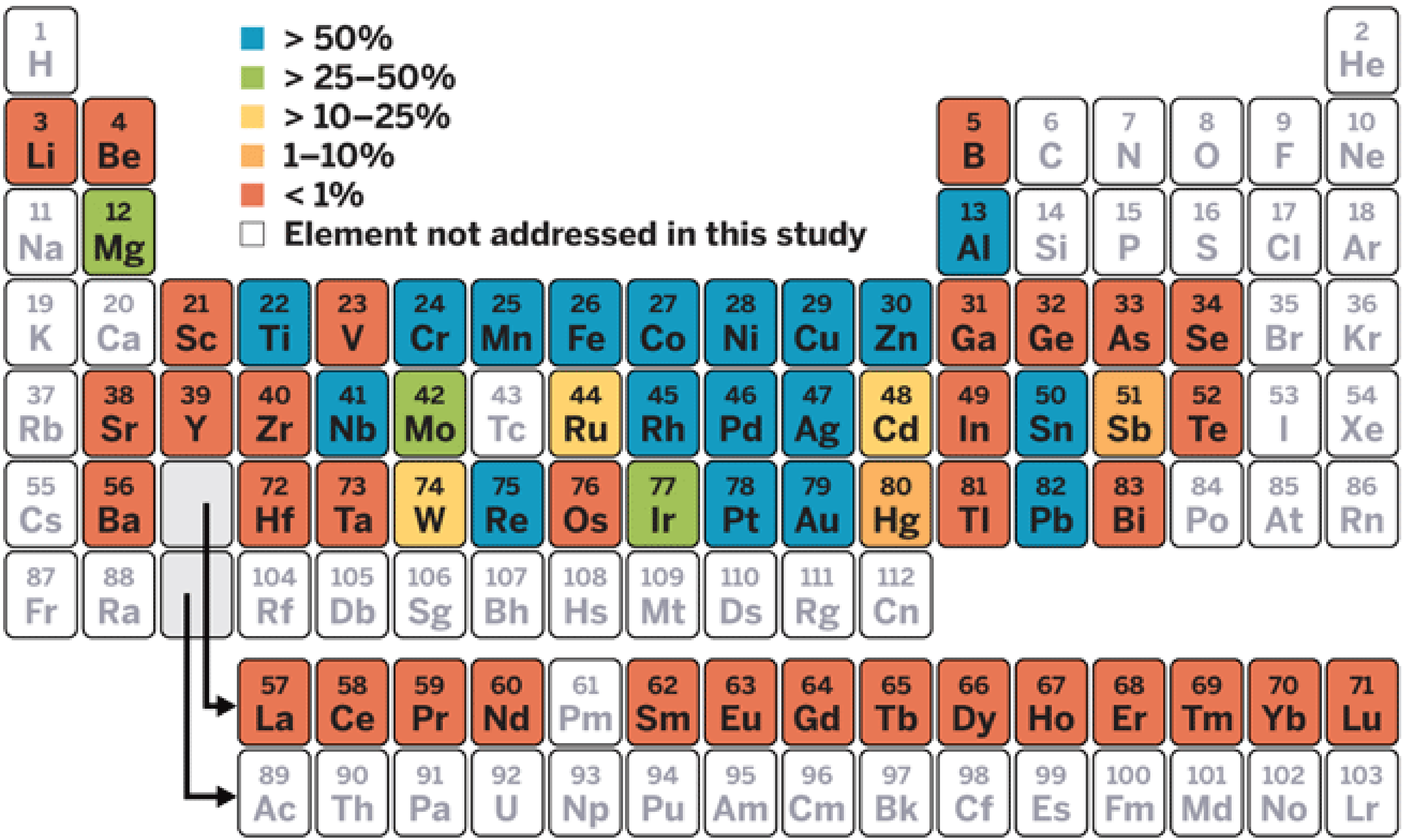
http://geology.com/articles/rare-earth-elements/

Metal	$/kg	Uses
La	15	Batteries (10 kg La in a Prius)
Ce	15	Catalytic Converter, Polishing
Pr	105	Alloys, Arc Lights, Welding Glasses
Nd	98	Magnets, Lasers
Sm	40	
Eu	**4000**	
Gd	210	
Tb	**2100**	
Dy	**1100**	
Ho	**1000**	
Er	275	
Tm	**4600-13000**	Lasers, Portable XRay Sources
Yb	**1000**	Atomic Clocks, Stress Gauges
Lu	**10000**	Few (Catalyst)
Y	68	Phosphors, Synthetic Garnets
Sc	**15000**	Alloys, Lamps, Dental Lasers
Au	45000	

DOE Critical Materials for Clean Energy

US DOE Critical Materials Strategy, December 2011.

REUSE STATS Global postconsumer recycling rates for many metals show lots of room for improvement.



SOURCE: UN Environment Program

C&E News, May 30, 2011 Volume 89, Number 22 p. 9
DOI:10.1021/CEN060211130455

Bastnäsite

$(Ce, La)CO_3F$

$(Y, Ce)CO_3F$

Table 2.3 Rare earth element distribution in bastnasite (w.r.t. 100% REO)

Rare earth	Bastnasite, Mountain Pass, California, U.S.	Bastnasite, Bayan Obo, Nei Monggol, China
La	33.2000	23.0000
Ce	49.1000	50.0000
Pr	4.3400	6.2000
Nd	12.0000	18.5000
Sm	0.7890	0.8000
Eu	0.1180	0.2000
Gd	0.1660	0.7000
Tb	0.0159	0.1000
Dy	0.0312	0.1000
Ho	0.0051	trace
Er	0.0035	trace
Tm	0.0009	trace
Yb	0.0006	trace
Lu	0.0001	trace
Y	0.0913	0.5000

Monozite

monazite-Ce (Ce, La, Pr, Nd, Th, Y)PO_4 monazite-Nd (Nd, La, Ce, Pr)PO_4

monazite-La (La, Ce, Nd, Pr)PO_4 monazite-Sm (Sm, Gd, Ce, Th)PO_4

Table 2.4 Rare earth distribution in monazite from different locations

Rare earth	Australia, North Staradbroke Island, Queensland	Australia, Capel, Western Australia	Brazil, East coast	China, Nangang, Guang-dong	India	U.S., Green Cove Springs, Florida	U.S., Bear Valley, Idaho	Australia, Mount Weld
La	21.50	23.90	24.00	23.35	23.00	17.50	26.23	26.00
Ce	45.8	46.02	47.00	42.70	46.00	43.70	46.14	51.00
Pr	5.3	5.04	4.50	4.10	5.50	5.00	6.02	4.00
Nd	18.6	17.38	18.50	17.00	20.00	17.50	16.98	15.00
Sm	3.1	2.53	3.00	3.00	4.0	4.90	2.01	1.8
Eu	0.8	0.05	0.0550	0.10		0.16	1.54	0.4
Gd	1.8	1.49	1.00	2.03		6.60	0.77	1.0
Tb	0.29	0.04	0.1	0.70		0.26		0.1
Dy	0.64	0.69	0.35	0.80		0.90	Tb,Dy:0.31	0.2
Ho	0.12	0.05	0.035	0.12		0.11		0.1
Er	0.18	0.21	0.07	0.30		0.04		0.2
Tm	0.03	0.01	0.005	trace		0.03		trace
Yb	0.11	0.12	0.02	2.40		0.21		0.1
Lu	0.01	0.04		0.14		0.03	Ho-Lu:0.15	trace
Y	2.50	2.41	1.4	2.40	Eu-Y: 1.50	3.20	1.39	trace

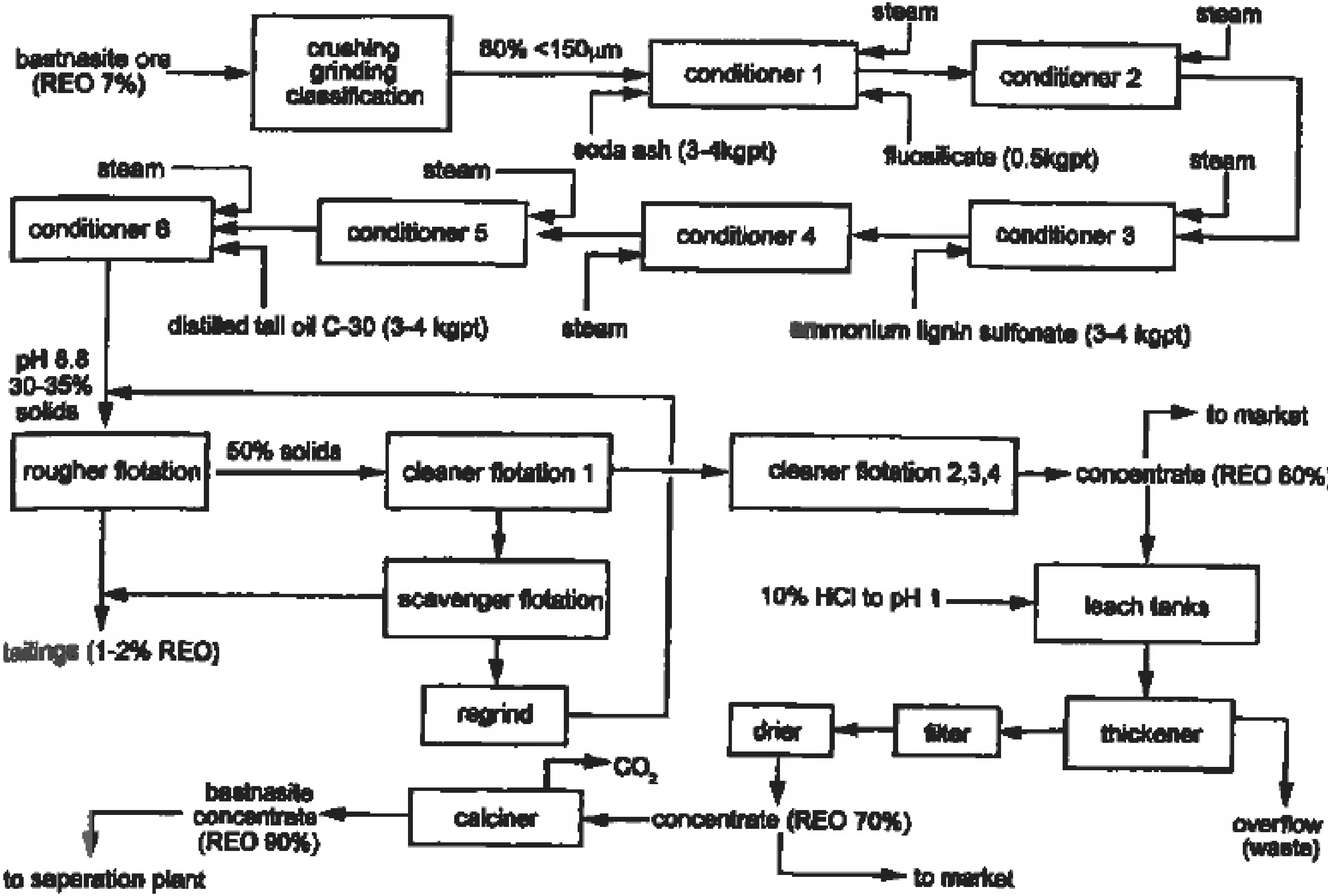


Figure 3.9 Simplified flowsheet for the recovery of bastnasite at the Molycorp plant (Aplan 1988).

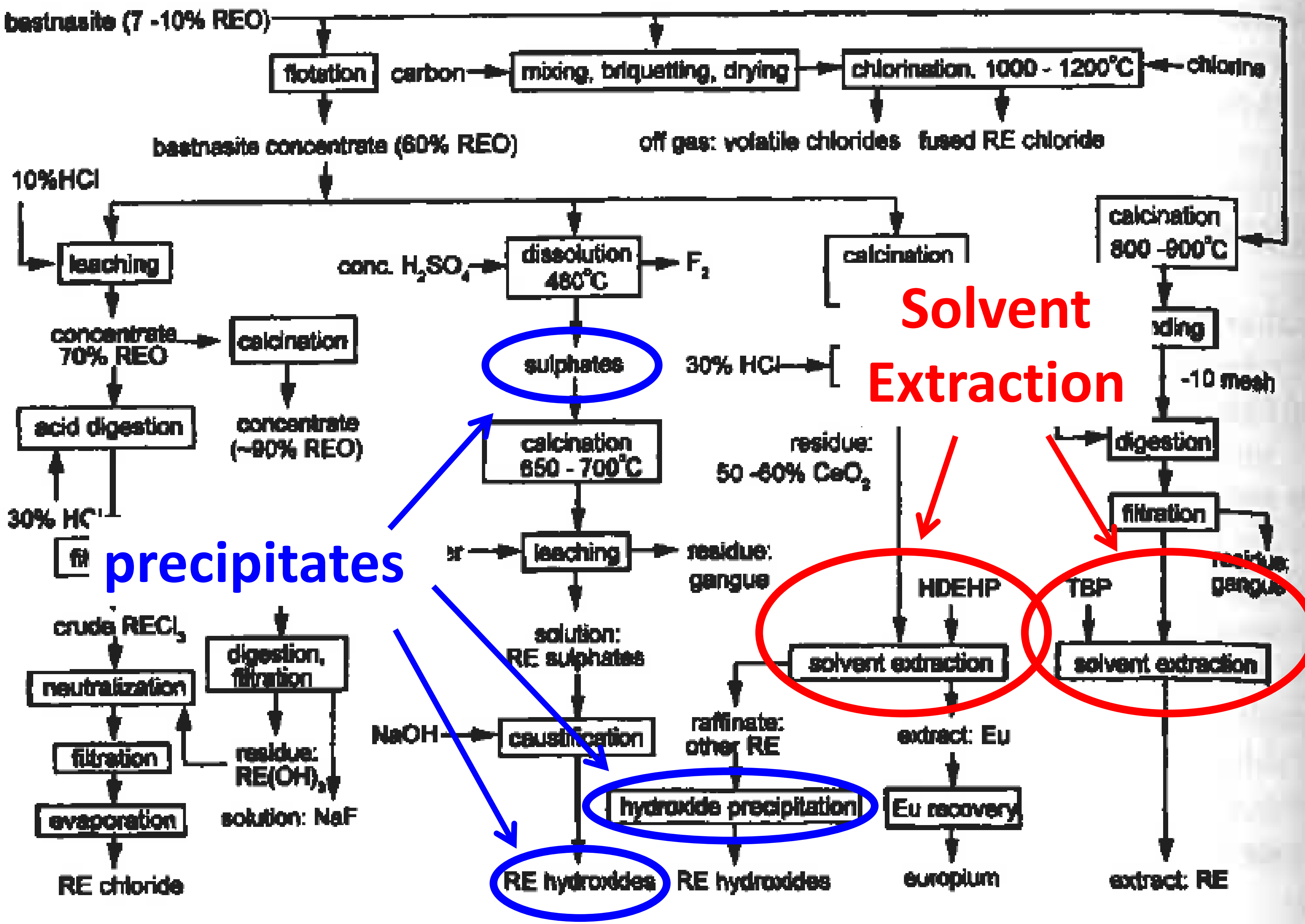
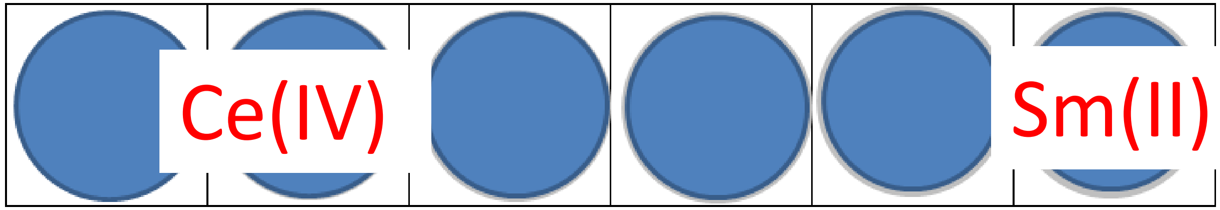
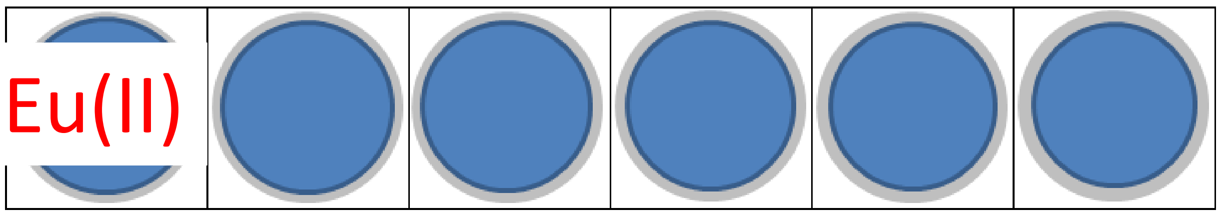


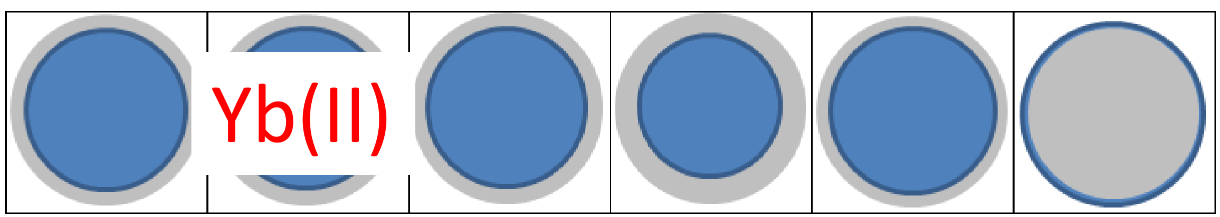
Figure 3.15 Chemical processing of bastnasite.



Ionic Radius (CN =8)	1.160	1.143	1.126	1.109	1.093	1.079
Element	**La**	**Ce**	**Pr**	**Nd**	**Pm**	**Sm**
Z	57	58	59	60	61	62
					(Am = 1.090)	

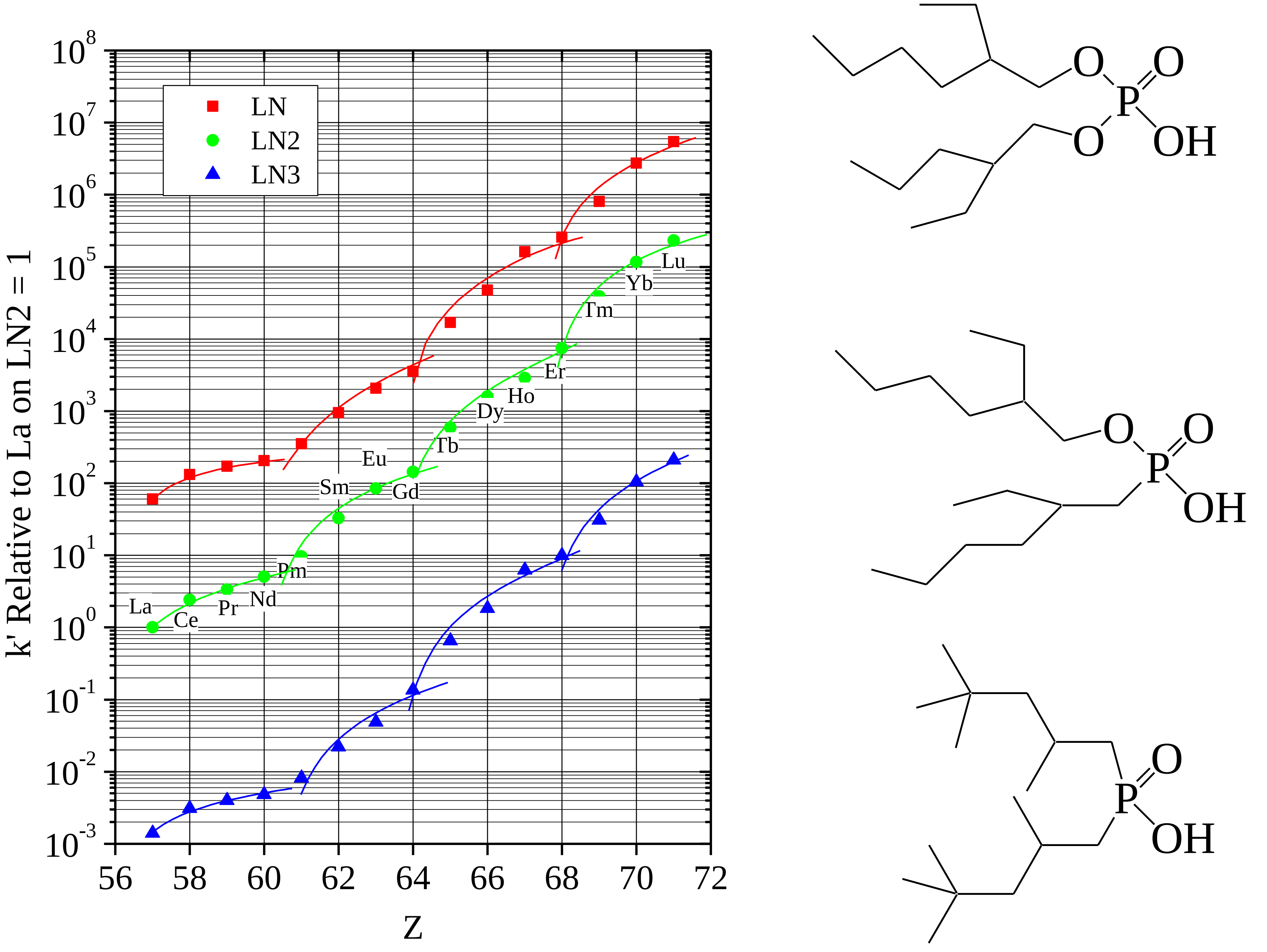


Ionic Radius (CN =8)	1.066	1.053	1.040	1.027	1.015	1.004
Element	**Eu**	**Gd**	**Tb**	**Dy**	**Ho**	**Er**
Z	63	64	65	66	67	68

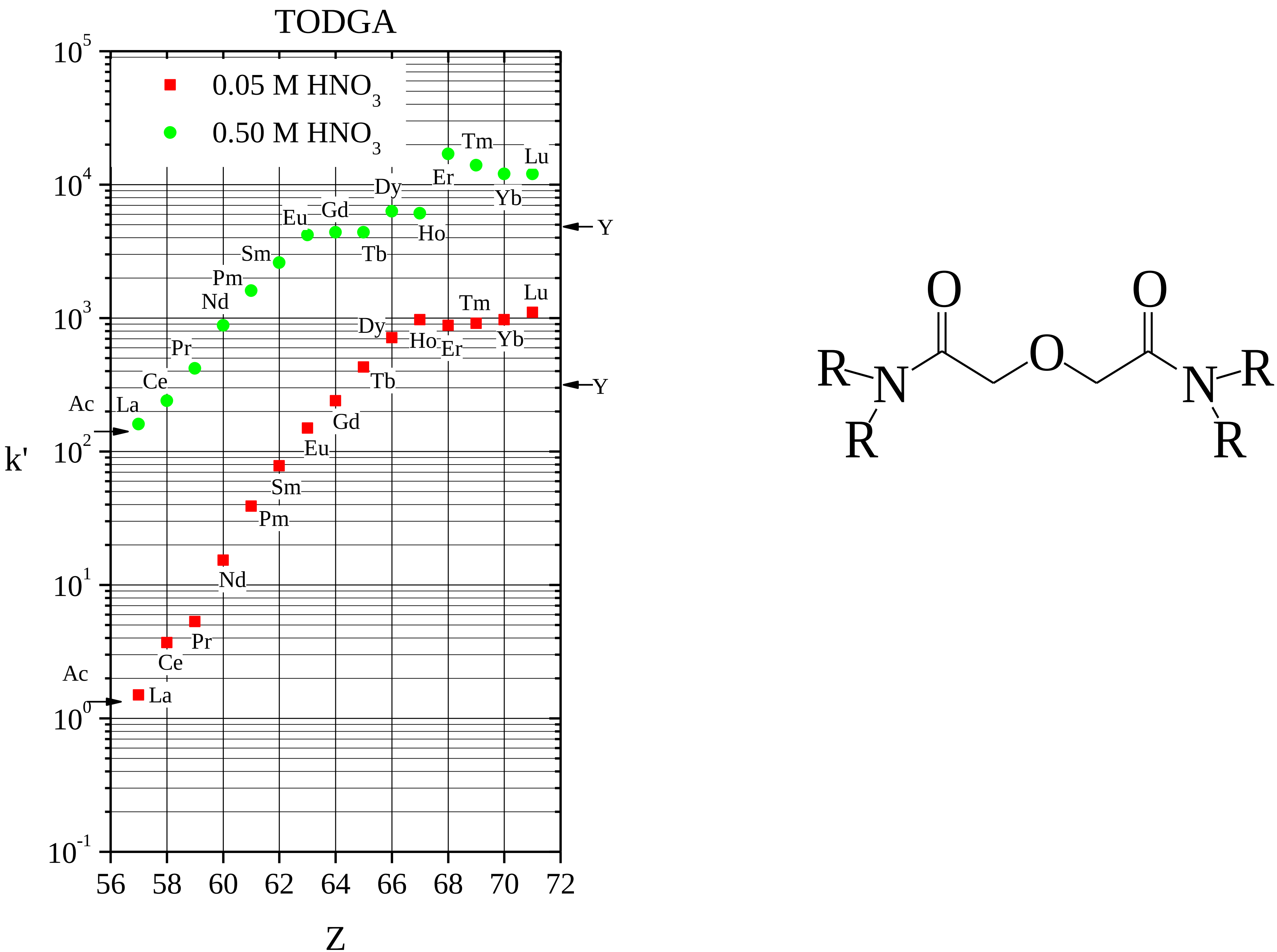


Ionic Radius (CN =8)	0.994	0.985	0.977	0.870	1.019	1.120
Element	**Tm**	**Yb**	**Lu**	**Sc**	**Y**	**Ac (CN=6)**
Z	69	70	71	21	39	89

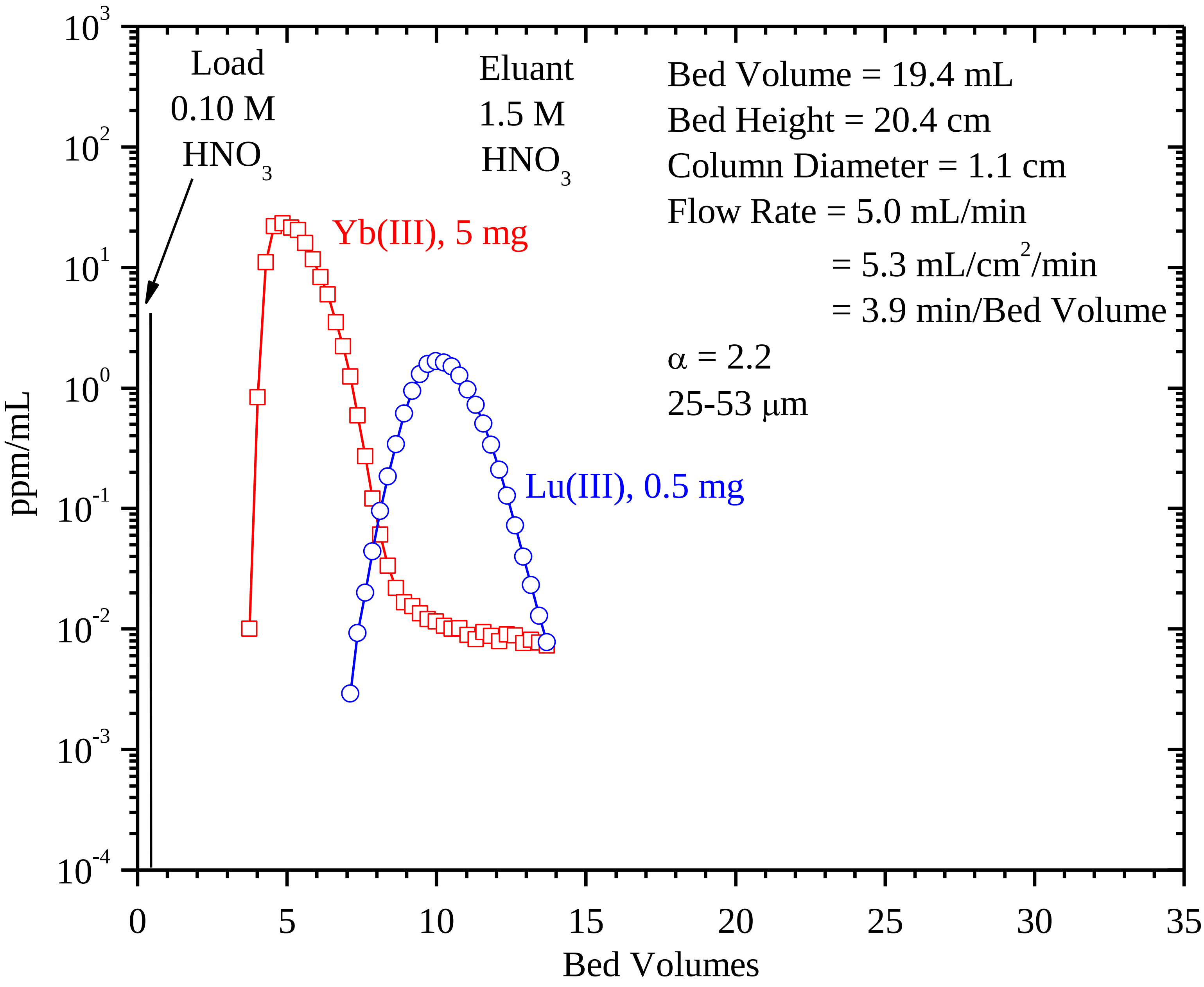
La(6) = 1.032



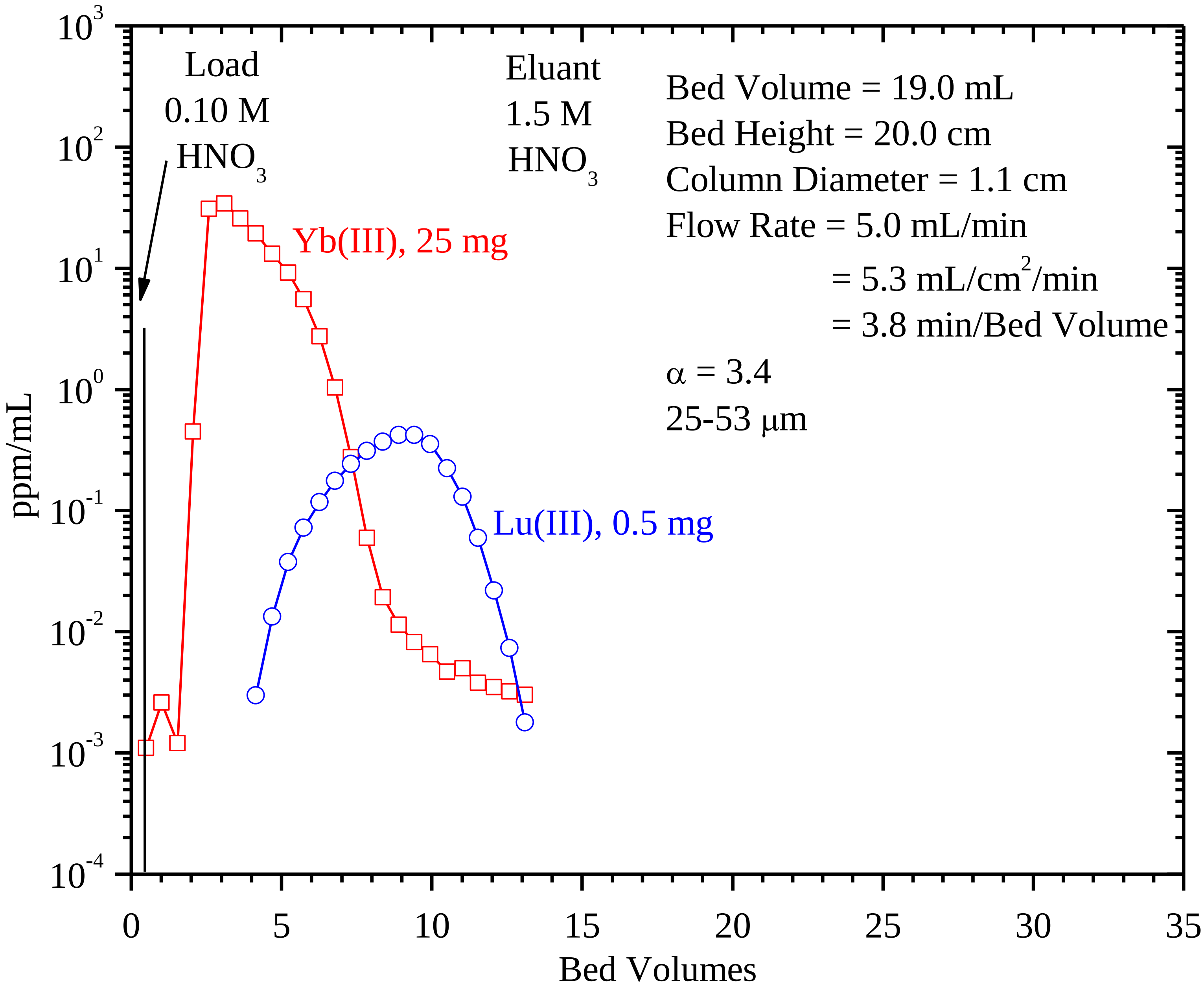
k' Relative to La on LN2 = 1
Z
LN
LN2
LN3
La
Ce
Pr
Nd
Pm
Sm
Eu
Gd
Tb
Dy
Ho
Er
Tm
Yb
Lu
O
P
OH


TODGA
0.05 M HNO3
0.50 M HNO3
k'
Z
10^5
10^4
10^3
10^2
10^1
10^0
10^-1
56
58
60
62
64
66
68
70
72
Ac
La
Ce
Pr
Nd
Pm
Sm
Eu
Gd
Tb
Dy
Ho
Er
Tm
Yb
Lu
Y
O
R
N

Lu/Yb Separation on LN2 Resin, 50°C, 5 mg Yb

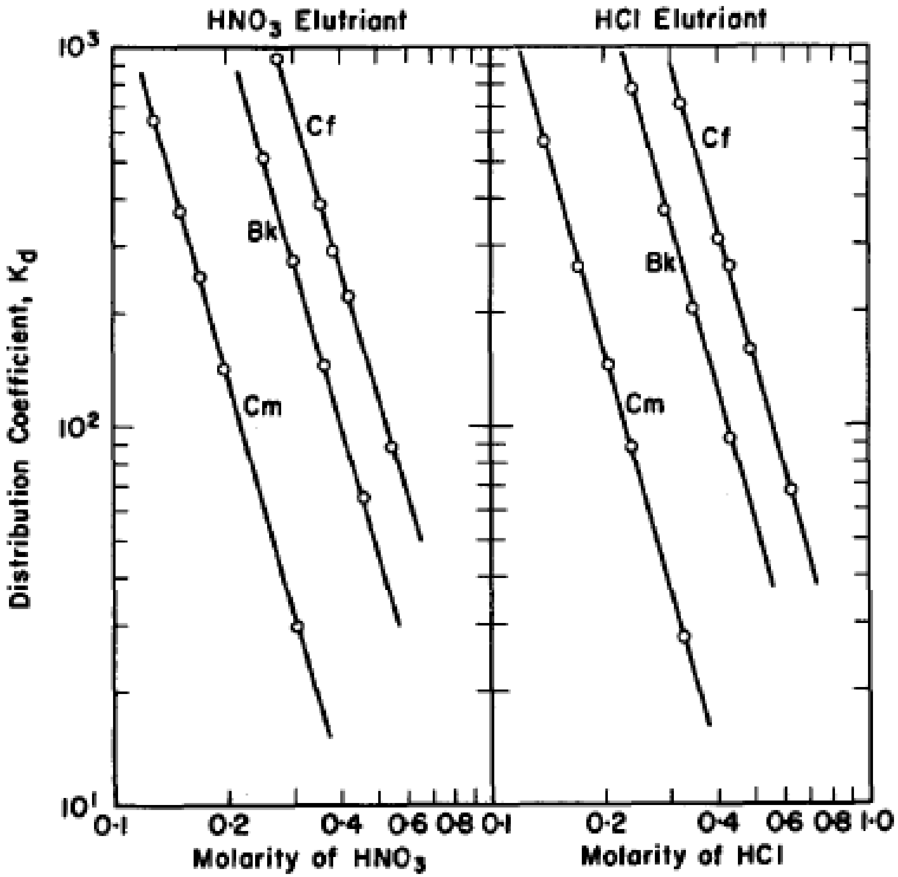


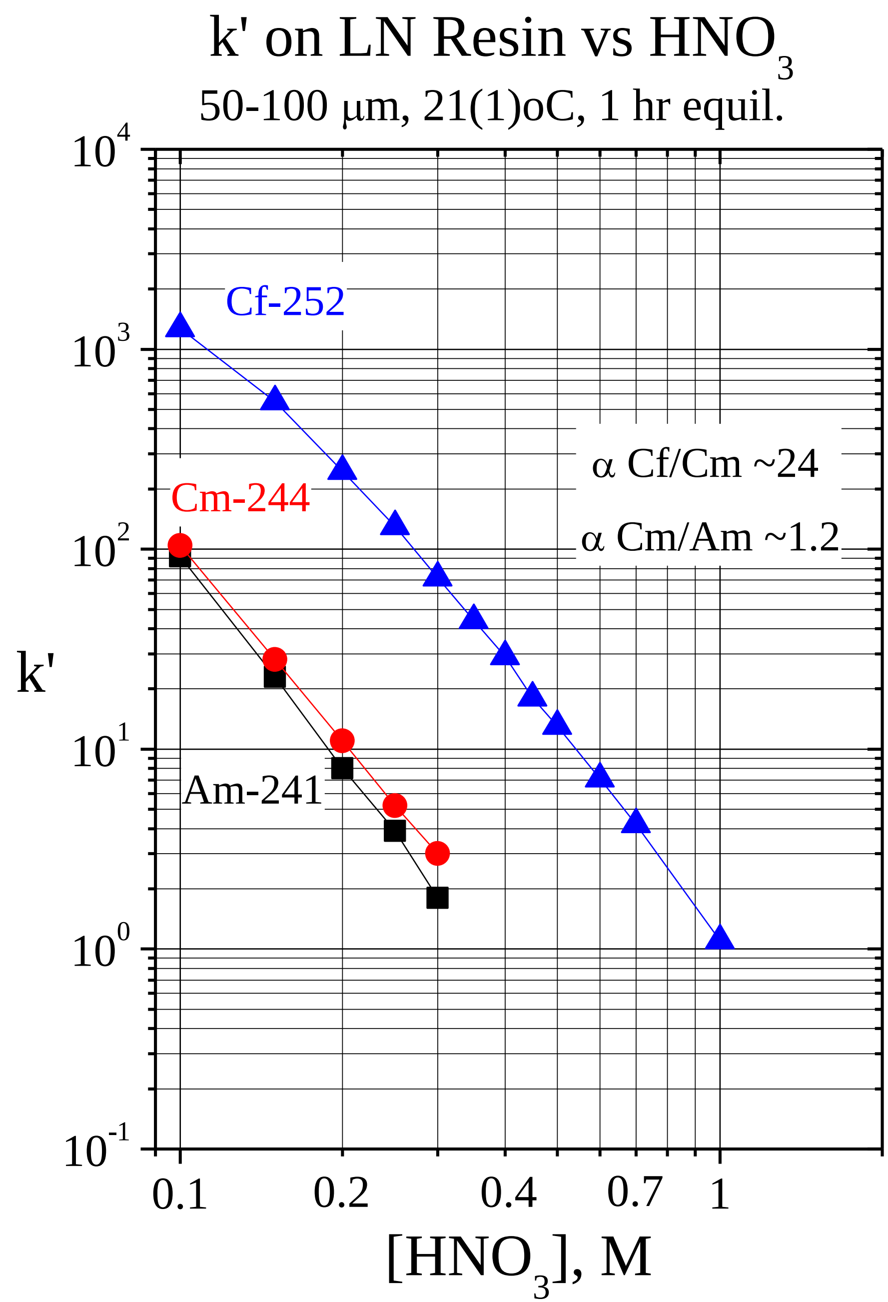
Lu/Yb Separation on LN2 Resin, 50^{o}C, 25 mg Yb

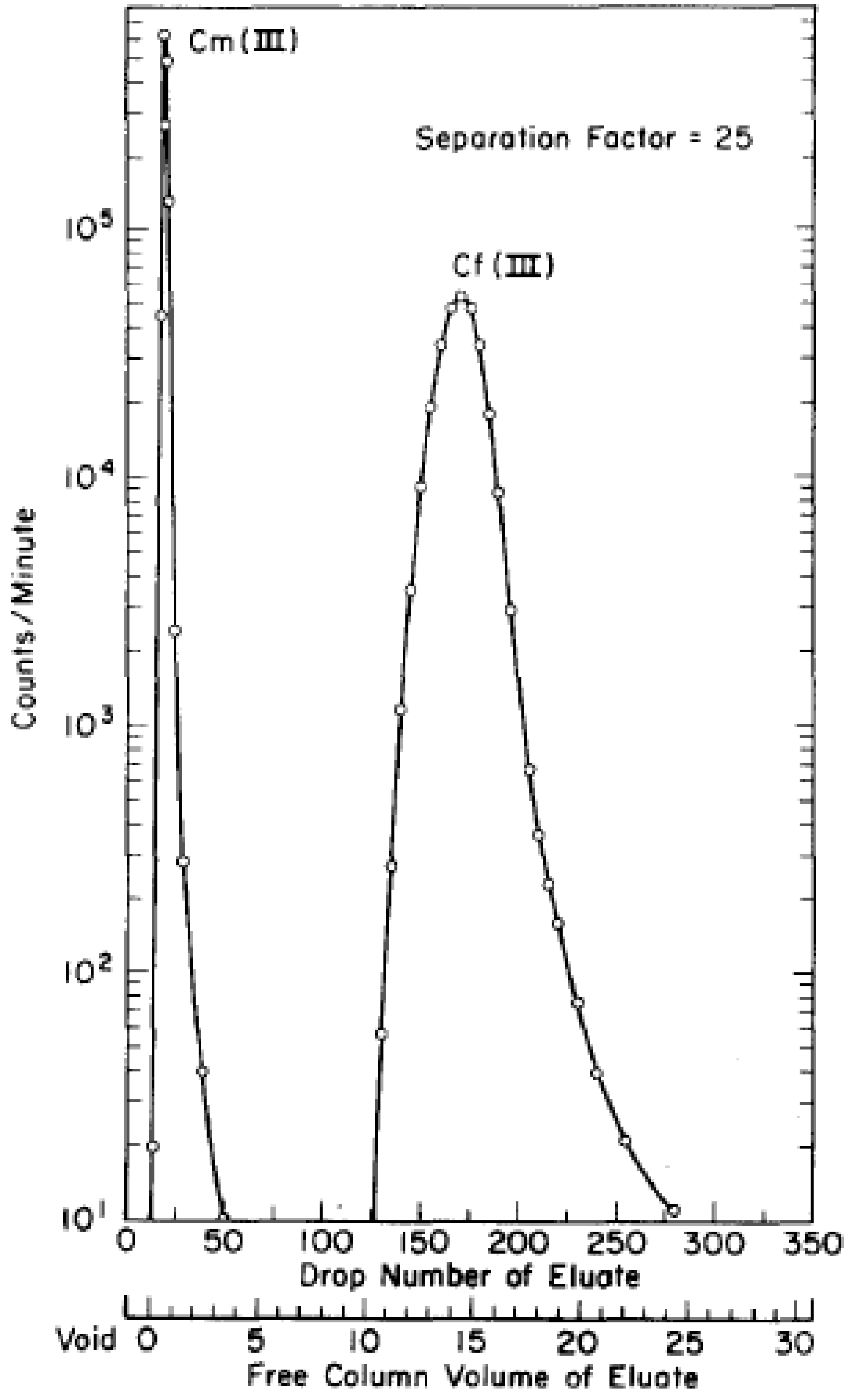


$^{244}Cm\ (xn, \beta^-)\ ^{252}Cf$

$^{252}Cf \rightarrow ^{248}Cm$







THE EXTRACTION CHROMATOGRAPHY OF AMERICIUM, CURIUM, BERKELIUM AND CALIFORNIUM WITH DI(2-ETHYLHEXYL)ORTHOPHOSPHORIC ACID*

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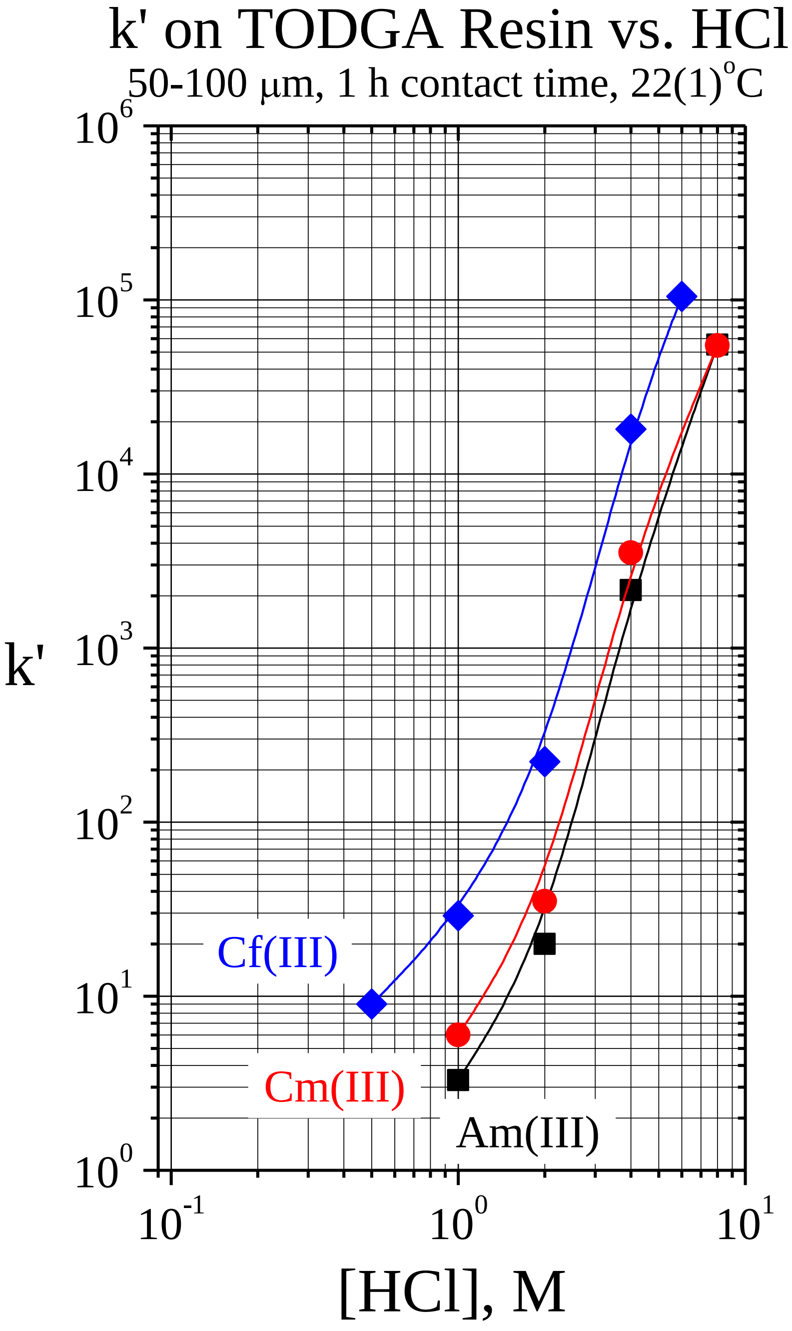
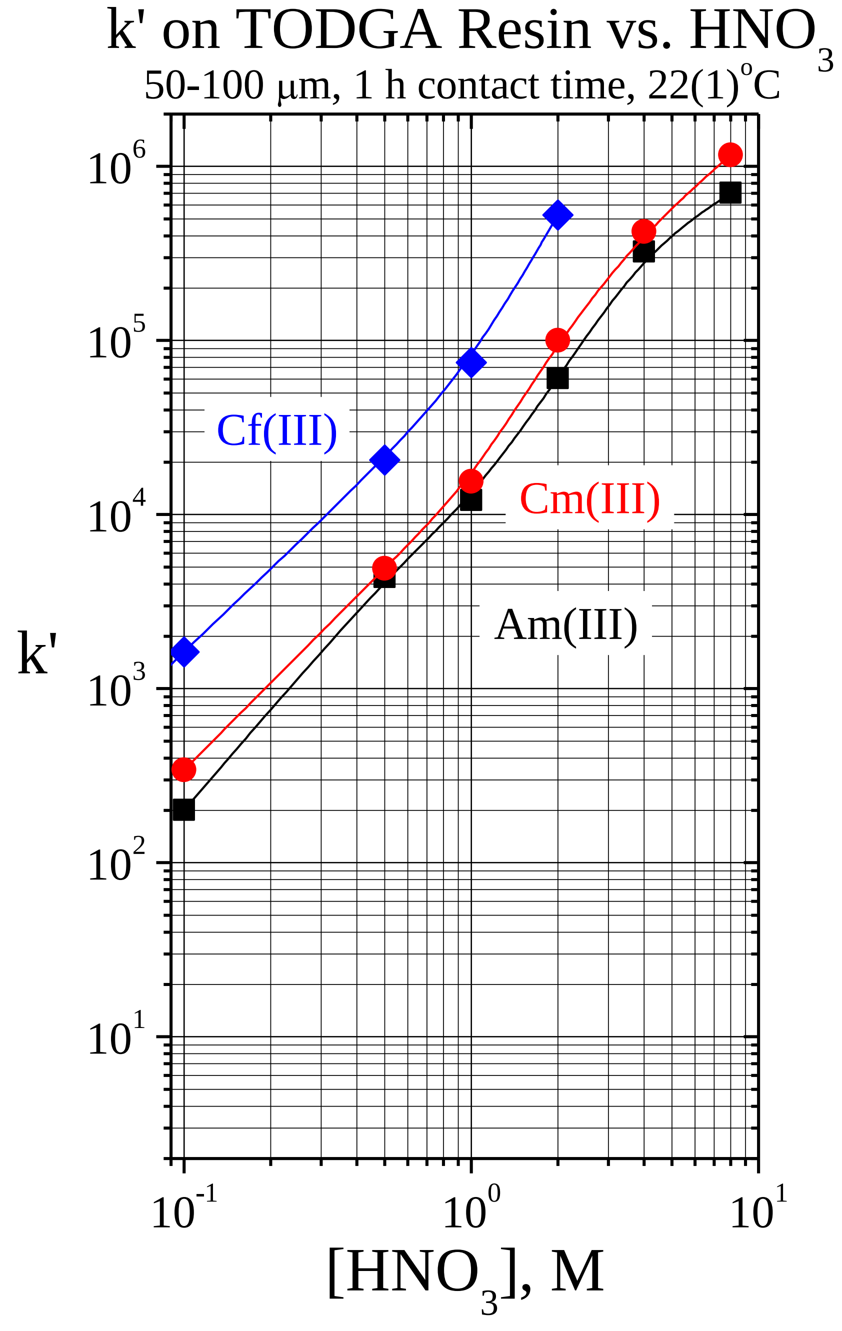
Chemistry Division, Argonne National Laboratory, Argonne, Ill. 60439

J. inorg. nucl. Chem., 1969, Vol. 31, pp. 3255 to 3271.

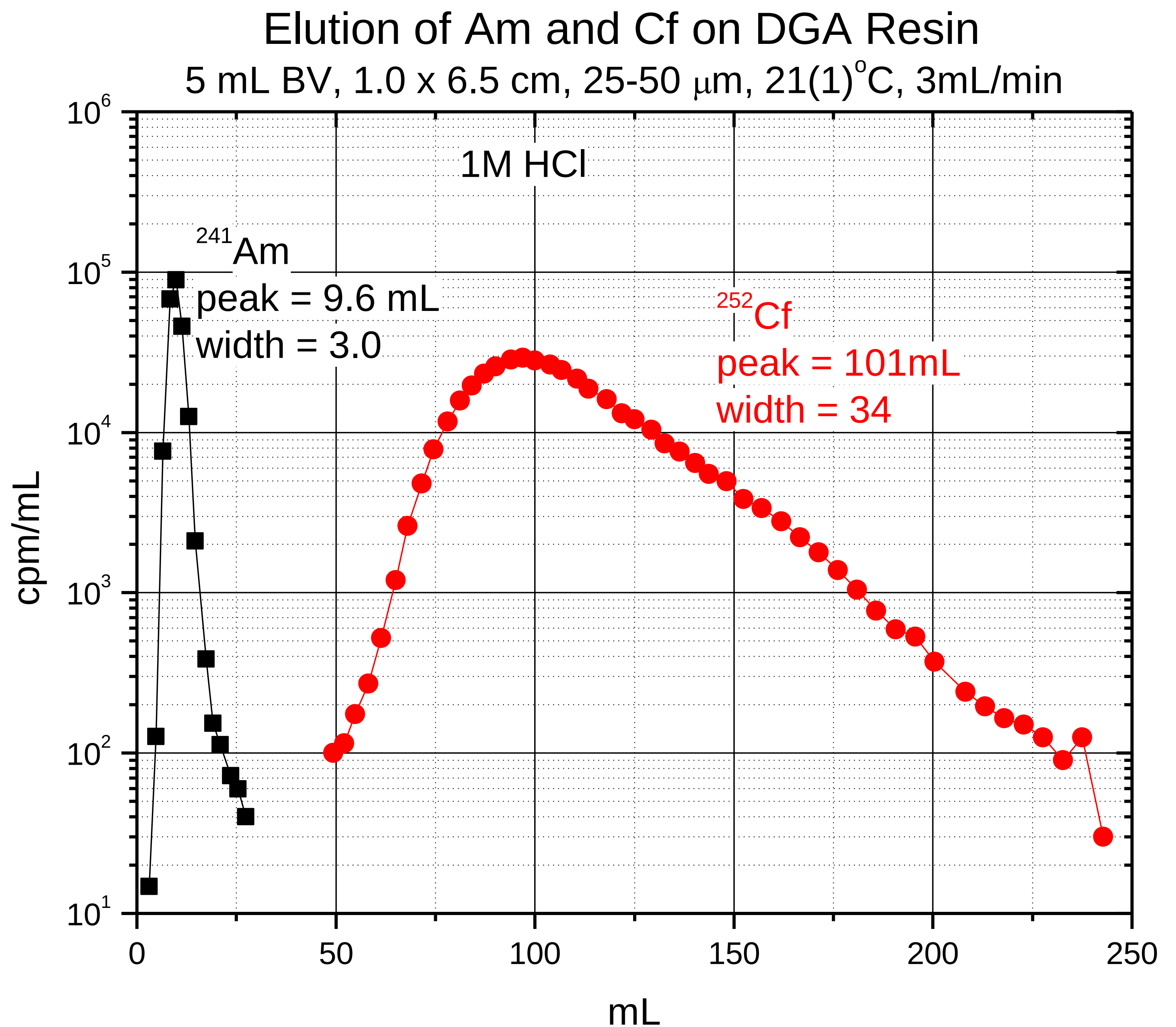
Fig. 11 The elution of Cm(III) and Cf(III) with 0·41 N HCl from HDEHP on Celite: 88·2 mg HDEHP/g of dry bed, flow rate 1·3 ml/cm²/min, 60°C. Column bed size 0·0620 cm² × 10 cm, bed density 0·371 g/ml, drop volume 39 μl/drop, $f = 0{\cdot}72$.



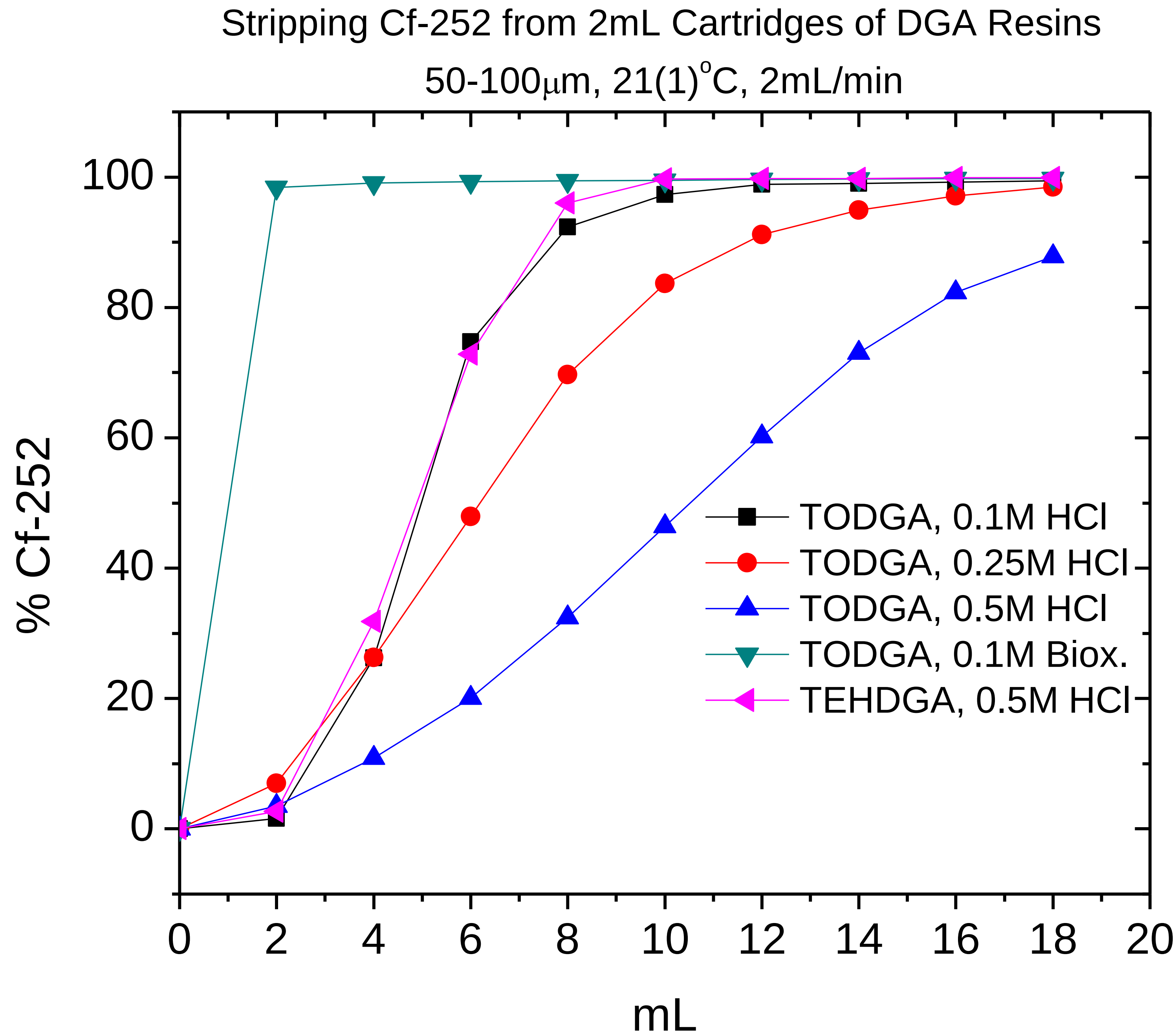
k' on TODGA Resin vs. HCl
50-100 μm, 1 h contact time, 22(1)°C
k'
[HCl], M
Cf(III)
Cm(III)
Am(III)



k' on TODGA Resin vs. HNO3
50-100 μm, 1 h contact time, 22(1)°C
k'
[HNO3], M
Cf(III)
Cm(III)
Am(III)



Elution of Am and Cf on DGA Resin
5 mL BV, 1.0 x 6.5 cm, 25-50 μm, 21(1)°C, 3mL/min
1M HCl
241Am
peak = 9.6 mL
width = 3.0
252Cf
peak = 101mL
width = 34
cpm/mL
mL
10^6
10^5
10^4
10^3
10^2
10^1
0
50
100
150
200
250


Stripping Cf-252 from 2mL Cartridges of DGA Resins
50-100μm, 21(1)°C, 2mL/min
% Cf-252
mL
0
20
40
60
80
100
0
2
4
6
8
10
12
14
16
18
20
TODGA, 0.1M HCl
TODGA, 0.25M HCl
TODGA, 0.5M HCl
TODGA, 0.1M Biox.
TEHDGA, 0.5M HCl

Displacement Chromatography

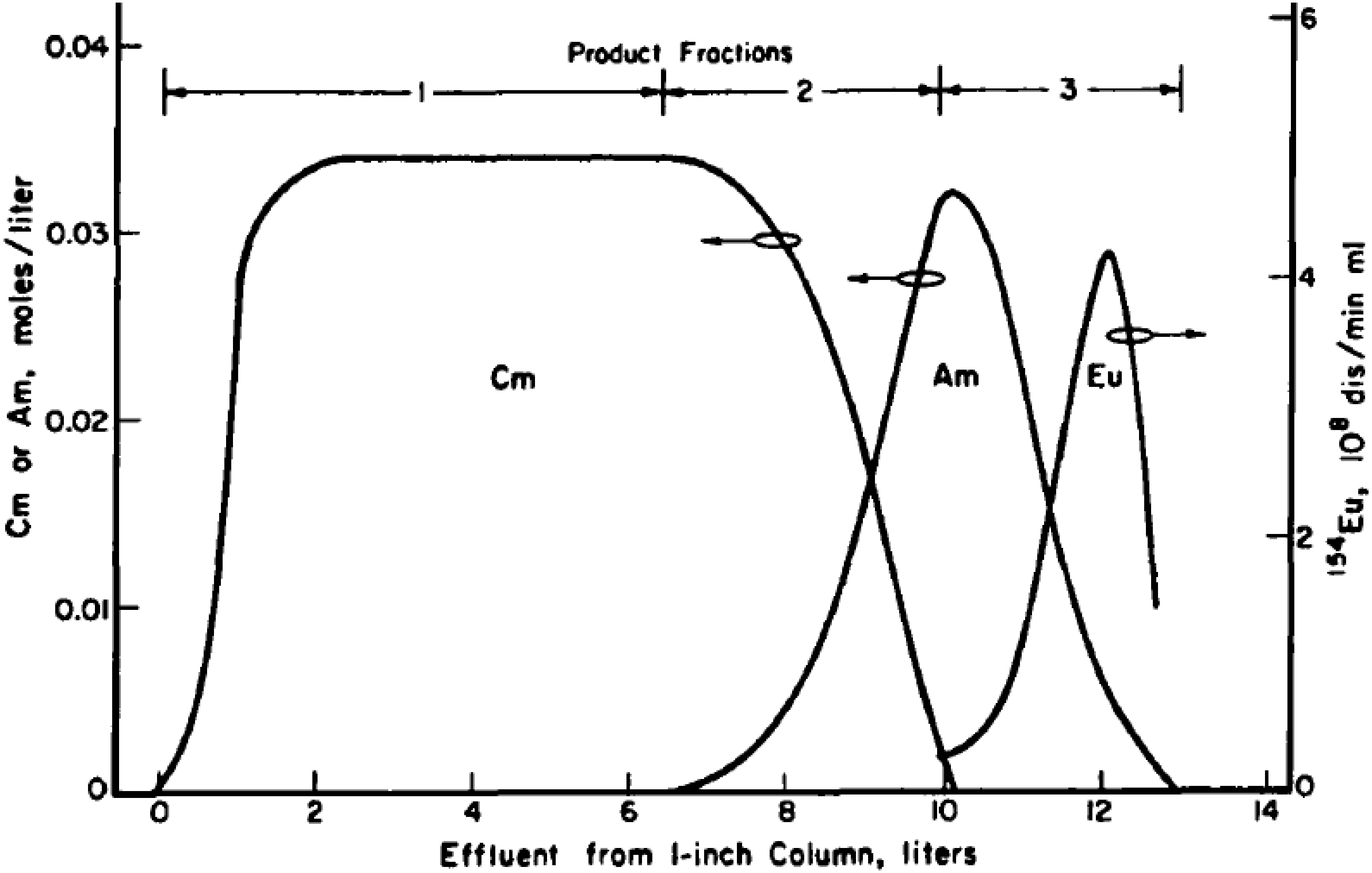


FIGURE 9

Typical Elution Diagram for Separation Using Displacement Development with DTPA in System Shown in Figure 8. Reprinted with permission from J. T. Lowe, W. H. Hale, Jr., and D. F. Hallman, Ind. Eng. Chem., Process Design Develop., 10, 131 (1971). Copyright by the American Chemical Society.

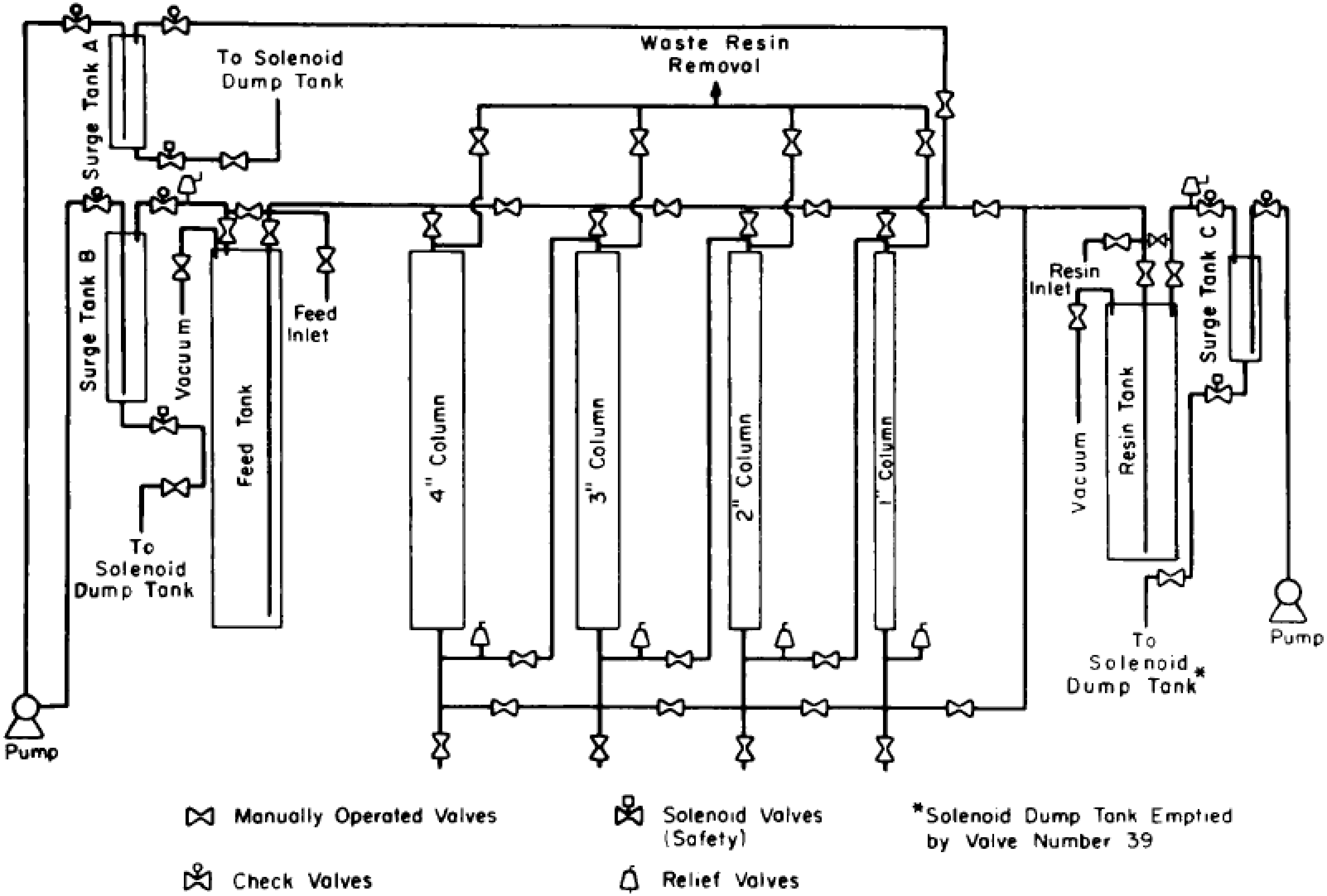
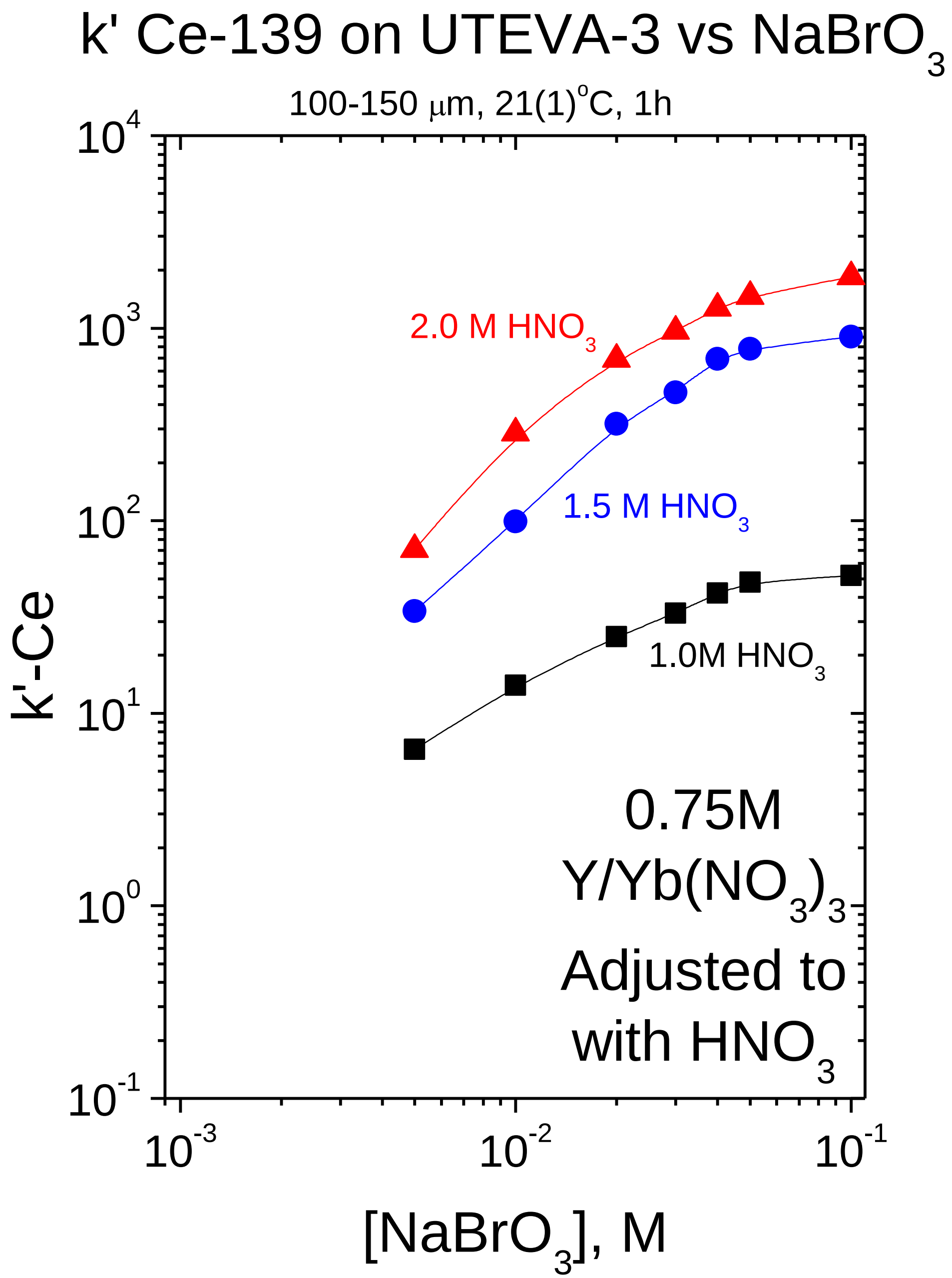
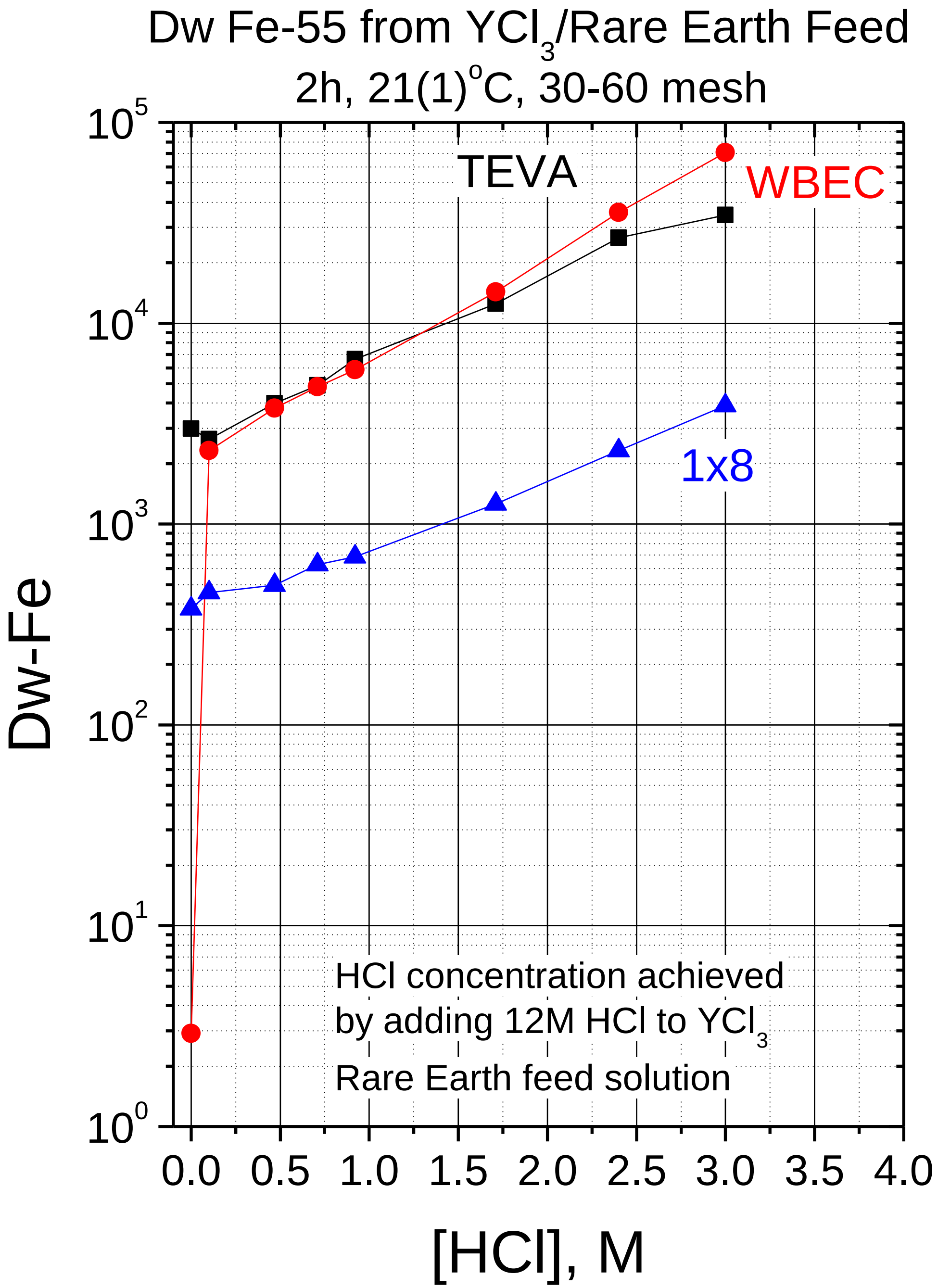


FIGURE 8. Flow Diagram for Displacement Development Separation of Actinides on the 100-g Scale. Reprinted with permission from J. T. Lowe, W. H. Hale, Jr., and D. F. Hallman, Ind. Eng. Chem., Process Design Develop., 10, 131 (1971). Copyright by the American Chemical Society.

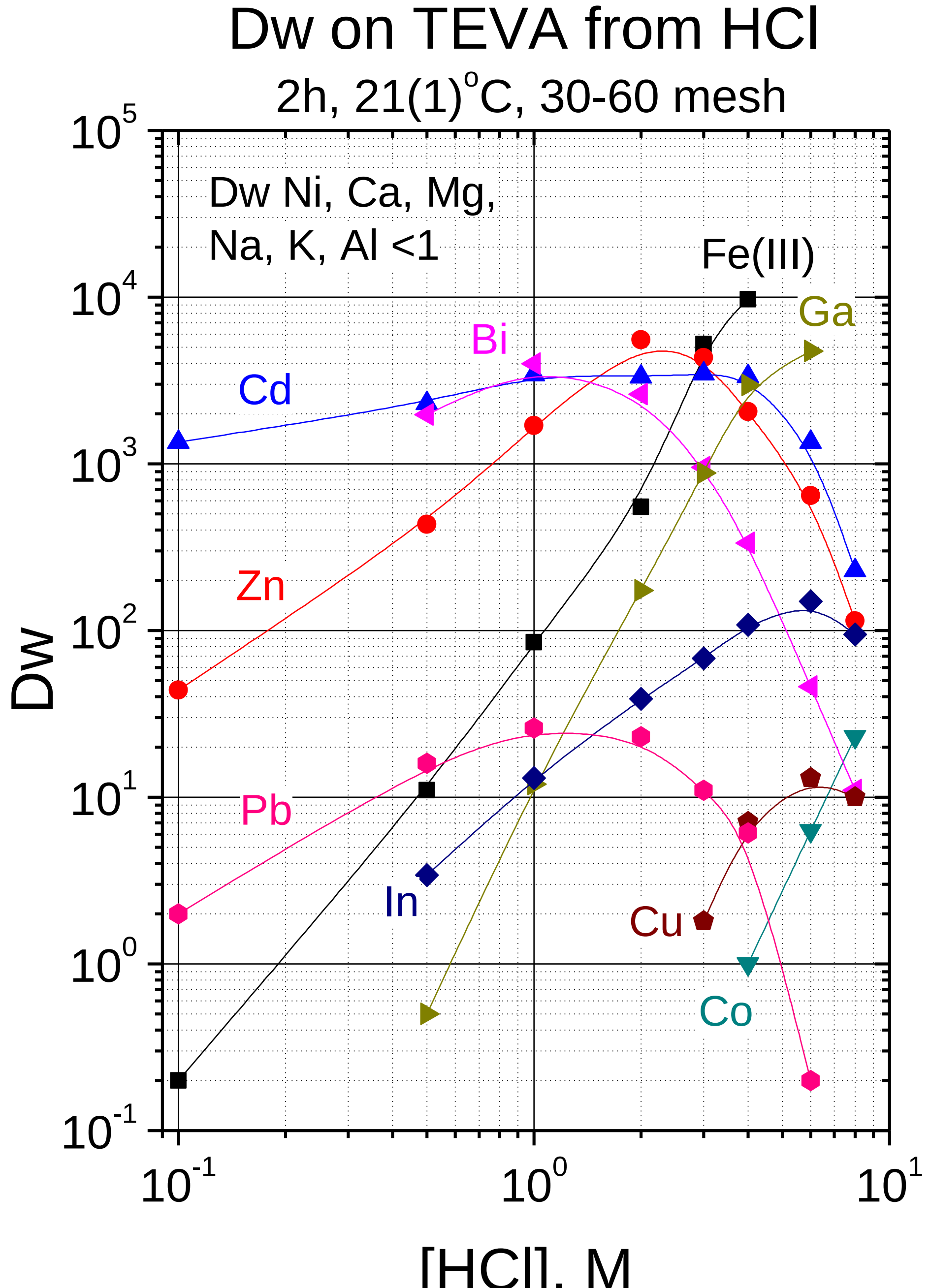
Cerium Removal



Iron Removal



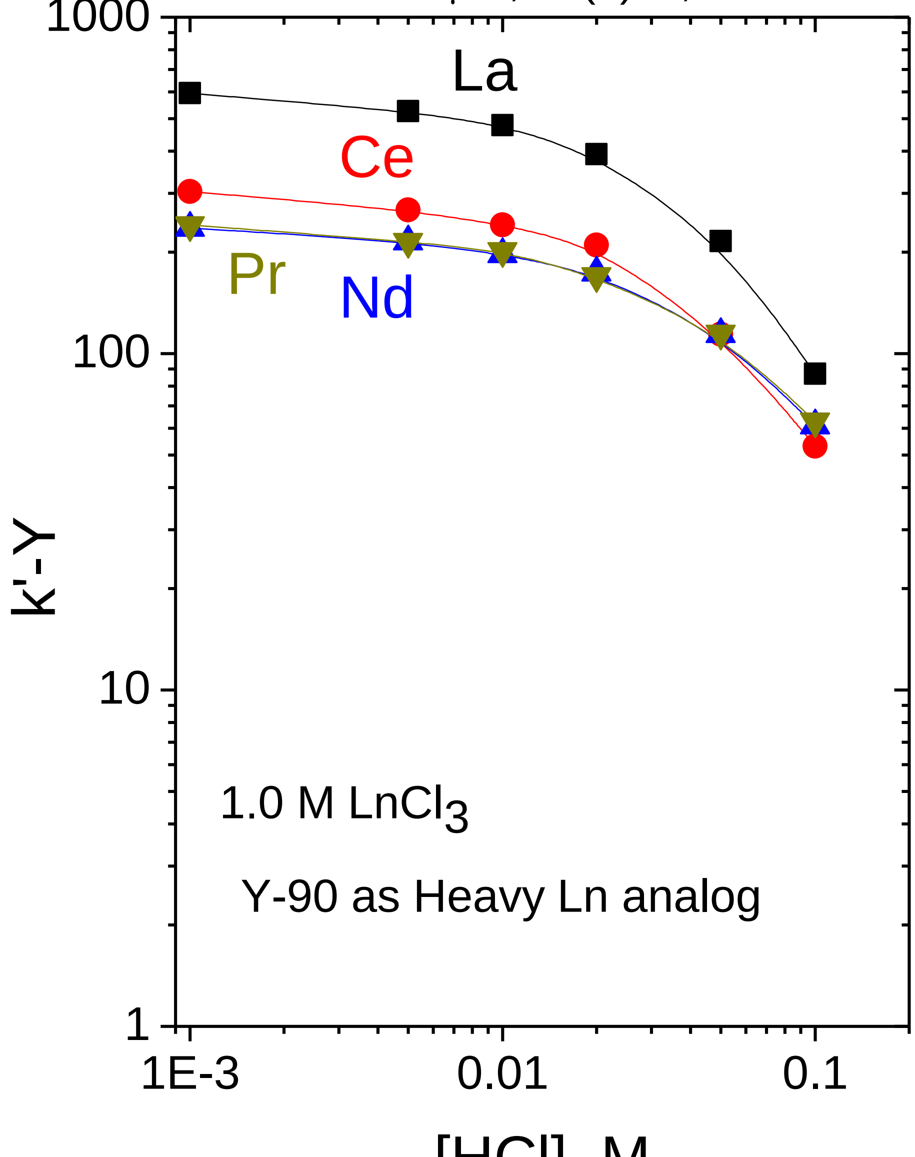
Iron Removal



Heavy Lanthanide Separations

k' Y-90 on LN2 from 1M $LnCl_3$ vs HCl

50-100 μm, 21(1)°C, 2h



Sc Separations (analysis)