

Ammonia removal from digested swine wastewater using a high-performance rotating reactor

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Abstract. The livestock industry generates significant wastewater pollution, challenging agricultural sustainability. Even with anaerobic digestion, digested wastewater often exceeds discharge standards due to high ammonia content, resulting in a low C/N ratio that inhibits aerobic biological treatment. Therefore, pretreatment to reduce ammonia is necessary. The High-Performance Rotating Reactor (HP2R) has shown promise in removing high ammonia concentrations from synthetic wastewater via stripping. This study examined HP2R's effectiveness on digested swine wastewater under various conditions, assessing the impact of pre-alkalinization (pH_i), rotating speed (ω), gas flow rate (Q_G), and wastewater flow rate (Q_L) on ammonia removal efficiency (ARE) and the overall liquid mass transfer coefficient (K_{La}). Results indicated HP2R could effectively remove ammonia in a laboratory-scale batch mode, with ARE ranging from 33 % to 78 % under different conditions. The K_{La} values (0.0014 s^{-1} to 0.0038 s^{-1}) showed improved mass transfer compared to conventional packed columns.

Keywords: air stripping, ammonia, swine wastewater, HP2R

Classification numbers: 3.4.2, 3.7.1, 3.7.4.

1. INTRODUCTION

In Vietnam, the livestock industry vastly contributes to agricultural production, accounting for 25.2 % of the sector's GDP with a steady growth of 4-6 % per year [1]. This results in massive waste generation, with around 80 million tons of animal waste annually in 2015 [2]. Swine farms discharge about 5.6 million m^3 of wastewater per day, comparable to cow and buffalo farming [3]. Swine wastewater, consisting of pig urine, manure, leftover food, sediment, and washing water [4], contains high levels of organic substances, nitrogen, phosphorus, and residual antibiotics [5]. Anaerobic digestion, used by 59.7 % of swine farms, is the primary treatment method [6]. However, the digested wastewater still has high nitrogen content ($\text{TN} >$

400 mg/L) [7], leading to eutrophication and hindering aerobic biological processes due to its low C/N ratio [8].

Regarding digested swine wastewater, the nitrogen content is mostly in the form of ammonia-nitrogen or ammonium due to the decomposition of amines with the absence of oxygen during the anaerobic digestion process [9]. There are several physical/chemical approaches to ammonia removal such as chemical precipitation, ammonia stripping, ion exchange, adsorption, and membrane filtration [10 - 12]. However, for the ammonia removal and recovery for the upstream influent like digested swine wastewater, ammonia stripping is the most available and popular on the market [13]. Air stripping is a less chemical-intensive and commonly used process for ammonia removal from wastewater, relying on the conversion of ammonium ions to ammonia at high pH (above 10), which is then stripped to the gas phase [10, 14]. The most common equipment for this is the packed column, which enhances the contact surface area using objects like Raschig rings or wire mesh [15]. This method has been successful in removing and recovering ammonia from concentrated wastewater streams such as landfill leachate [16, 17], pig slurry [18], and anaerobic digestion [19]. For example, ammonia removal from landfill leachate (2000 mg/L) reached 98 % in 4-9 days using a pilot-scale column packed with Raschig rings at pH 12.1 [16]. However, packed columns have a major drawback: higher gas-to-liquid flow rate ratios increase the risk of flooding due to pressure drop and liquid hold-up, requiring higher investment costs and larger space [10, 13]. This risk is exacerbated by carbonate deposition and high liquid feeding [20, 21].

A novel design to improve ammonia stripping and reduce equipment size is the rotating packed bed (RPB) [22]. This compact design offers high mass transfer and shortened liquid retention time, benefiting applications like VOCs stripping [23], CO₂ absorption [24], ClO₂ generation [25], and ammonia removal [14, 26, 27]. Yuan et al. demonstrated that RPBs have a significantly higher mass transfer rate (K_{La} 12.3-18.1 h⁻¹) compared to conventional stripping columns (K_{La} 3.5-9 h⁻¹), achieving ammonia removal efficiencies of 60-95% at pH 11 and an initial concentration of 1000 mg/L [26]. However, horizontal RPB designs encountered slow liquid exit and bed clogging [28]. Solutions include a steep casing bottom or higher casing height. The High-Performance Rotating Reactor (HP2R) with a vertical bed design avoids these issues [14]. HP2R's horizontal bed design offers stability at high speeds, easy mobilization, less space usage, and resistance to clogging and flooding without a large, sloping casing bottom. Experiments achieved significant ammonia removal efficiency (83-93 %) with a double cycle of stripping at pH 10-12.

These findings show that the HP2R has high potential as an alternative to packed columns for ammonia removal from wastewater. While various parameters affecting ammonia removal efficiency have been studied, the application to real wastewater remains unclear due to a lack of studies and the challenge of high suspended solids causing fouling [29]. This study focused on the ammonia removal efficiency of HP2R from digested swine wastewater under different conditions. The effects of pre-alkalinization (pH_i 10 - 12), rotating speed (ω 900 - 1200 rpm), gas flow rate (Q_G 116 - 415 L/min), and wastewater flow rate (Q_L 0.05 - 0.20 L/min) on ammonia removal efficiency and the overall liquid mass transfer coefficient (K_{La}) were evaluated. This study also compared ammonia stripping between swine and synthetic wastewater to assess the impact of suspended solids. The results provide fundamental information for future applications of HP2R in ammonia removal and recovery from swine wastewater.

2. MATERIALS AND METHODS

2.1. Digested swine wastewater characteristic

Digested swine wastewater was collected from a household swine farm in Vinh Tuong commune, Vinh Phuc province, Vietnam. Samples were taken from the farm's anaerobic tank discharge and stored in 20-L plastic containers, then transferred to the Institute of Environmental Technology's laboratory. Containers were refrigerated at 4 °C to preserve the wastewater's characteristics. Experiments were conducted the day after collection to avoid any variations. The total nitrogen (TN) exceeded Vietnam's National Technical Regulation (QCVN 62:2016/BTNMT Standard A) [30]. The wastewater's TN, mainly ammonia (NH₃-N) at 657 mg/L (> 99 % of TN), is suitable for air stripping. Original characteristics are detailed in Table 1.

Table 1. Characteristic of the digested swine wastewater and the comparison with the discharge standard.

| Parameters | Unit | Digested swine | QCVN 62:2016/BTNMT Standard A [30] |
|---|------|----------------|------------------------------------|
| pH | - | 7.5 ± 1.0 | 6 – 9 |
| Biological oxygen demand - BOD ₅ | mg/L | 430 ± 95 | 40 |
| Chemical oxygen demand - COD | mg/L | 1120 ± 182 | 100 |
| Total suspended solids - TSS | mg/L | 143 ± 23 | 50 |
| Total nitrogen - TN | mg/L | 660 ± 93 | 50 |
| Ammonia nitrogen - NH ₃ -N | mg/L | 657 ± 101 | - |

2.2. HP2R equipment characteristics and experimental procedures

In this study, ammonia removal was performed using HP2R equipment previously used for simulated wastewater [14]. The packed bed volume (V_B) is 7.74×10^{-4} m³, with a bed height (Z_B) of 0.039 m, inner radius (r_i) of 0.024 m, and outer radius (r_o) of 0.083 m (Figure 1a and Table 2). A diaphragm pump (EHN-C36VH4R, Iwaki, Japan) ensured stable liquid feeding, while an air blower (TJ-750, Tongjin, China) with variable frequency control adjusted air feeding. An anemometer (Kestrel 5500, Kestrel, USA) monitored the air velocity in the outlet pipe.

Table 2. Characteristic of the packed bed of the HP2R equipment.

| Parameters | Unit | Characteristic |
|---|----------------|---------------------------|
| Packed bed inner radius (r_i) | m | 0.024 |
| Packed bed outer radius (r_o) | m | 0.083 |
| Packed bed average radius (r_{avg}) | m | 0.054 |
| Packed bed axial height (Z_B) | m | 0.039 |
| Packed bed volume (V_B) | m ³ | 7.74×10^{-4} |
| Packing material | - | Stainless-steel wire mesh |

Figure 1b presents the experiment on ammonia-nitrogen removal from digested swine wastewater using HP2R equipment. The experiments varied conditions of pH (pH_i 10-12), rotational speed (ω 300 - 1200 rpm), gas flow rate (Q_G 116 - 415 L/min), and liquid flow rate (Q_L 0.05 - 0.2 L/min) at a controlled temperature of 30 ± 1 °C. Pre-alkalinization was achieved by adding solid NaOH. The HP2R was set to stable rotational speed and gas flow rate. After reaching the desired pH, the alkalized wastewater was continuously fed to the HP2R at a constant rate. The output air was captured to prevent ammonia emission, and wastewater samples were collected after 10 minutes of operation. Each sample was collected in triplicate,

stored in sealed beakers, and analyzed immediately to prevent ammonia evaporation. Data was analyzed and plotted using MS Excel.

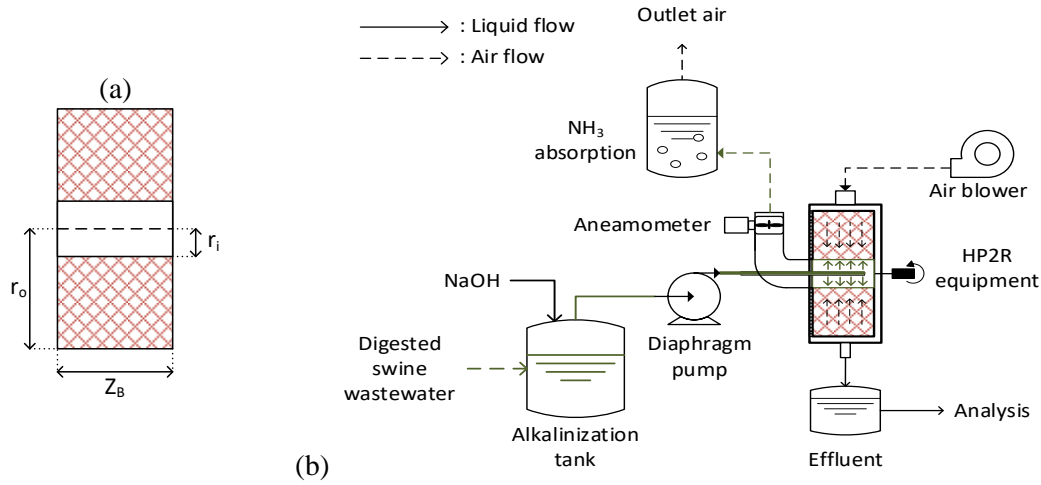


Figure 1. The basic design parameters of the packed bed (a) and a schematic diagram of ammonia stripping (b) from digested swine wastewater using HP2R equipment.

2.3. Ammonia analysis and theoretical calculation

The ammonia concentration in the liquid samples was measured by the ammonia-selective electrode method [31] using the HI 4101 ammonia-selective electrode (HI 4101, Hanna, USA) and read by read and displayed by the pH/ISE/mV meter (HI 5222, Hanna, USA). The ammonia removal efficiency (ARE) was calculated based on the change in ammonia concentration of the swine wastewater samples as follows:

$$ARE (\%) = \frac{C_{Li} - C_{Lo}}{C_{Li}} \times 100\% \tag{1}$$

where the C_{Li} and C_{Lo} are the input and output concentrations, respectively, of ammonia concentration.

In this study, the mass-balance concept and the two-film theory were employed for the computation of the overall-liquid volumetric mass transfer coefficient (K_La). The K_La (relative to the unit liquid volume) is the common characteristic to be considered in design, scale-up, and optimization of gas-liquid contactors like stripping columns [32]. In this study, the K_La was calculated to understand the overall transfer rate of ammonia from the liquid phase into the gas phase per unit of time. This computation was proposed to determine the mass transfer of centrifugal vapor-liquid contacted by Chen *et al.* [33, 34]. The calculation of K_La was derived from the differential volume with the cross-sectional area and the thickness of the thin film with the assumption of the neglect of gas-side mass transfer resistance. The expression for K_La calculation is presented as follows [33]:

$$K_La = \frac{Q_L}{V_B} \frac{\ln\left[\left(1 - \frac{1}{S}\right) \frac{C_{Li} + 1}{C_{Lo} + 1}\right]}{1 - \frac{1}{S}} \tag{2}$$

where Q_L is the swine wastewater flow rate (m^3/s), V_B is the volume of the packed bed (m^3), and S is the stripping factor which is defined as follows [33]:

$$S = H_C \frac{Q_G}{Q_L} \quad (3)$$

where H_C (0.000824) is the dimensionless Henry's law constant of ammonia at 30 °C according to the NIST Chemistry Webbook [35], Q_G is the gas flow rate of the system.

3. RESULTS AND DISCUSSION

3.1. Effect of pre-alkalinization (pH_i) of digested swine wastewater on the ARE

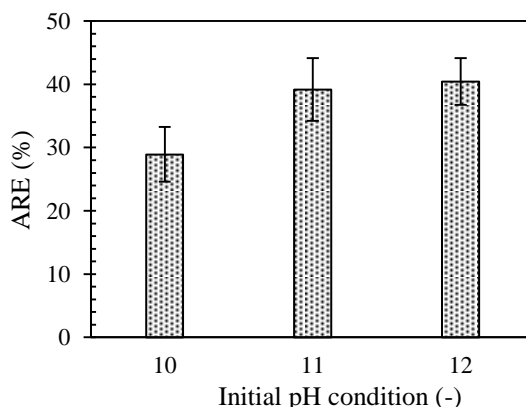


Figure 2. The effect of digested swine wastewater pre-alkalinization on the ammonia removal efficiency ($Q_G = 216$ L/min, $Q_L = 0.10$ L/min, $\omega = 300$ rpm, $C_{Li} = 657$ mg/L).

The effect of pH_i on ammonia removal from digested swine wastewater using the HP2R equipment is presented in Figure 2. The operational conditions were kept constant at Q_G of 216 L/min, Q_L of 0.10 L/min, ω of 300 rpm, while the pH varied from 10 to 12. The higher pH_i might exhibit higher ARE, while it could trigger the clogging phenomenon inside the packing and liquid output. The pH_i of digested swine wastewater had a significant effect on the ARE since it influences the ammonia species distribution. The ARE increased from 28.92 % to 39.18 % when the initial pH condition was raised from 10 to 11. This result was even higher than that of the ammonia stripping from synthetic wastewater (17.20 % to 27.40 %) in the previous study at a similar rotating speed of 300 rpm [14]. This could be explained by the higher Q_G (216 L/min) in this study than the Q_G (85 L/min) of the synthetic wastewater experiment. According to the species distribution diagram of ammonia by Jiang *et al.*, the proportion of NH_3 in the solution increases from 40 % at pH 9 to 80 % at pH 10, consequently to almost 100 % at pH 11 [36]. The proportion of NH_3 , however, remains almost unchanged between pH 11 and 12. That explained the negligible difference between ARE at pH 11 (39.18 %) and pH 12 (40.45 %). The pH_i above 11 was also a preference for ammonia stripping conditions in previous studies using packed columns [16, 18]. Bonmati and Flotats recorded a significant improvement in ammonia removal when the alkalization of pig slurry was conducted to pH 11 compared to the raw sample [18]. Regarding the swine wastewater in this study, the sight of precipitated solid in the output sample was detected at high initial pH_i of 11 and 12 which was absent in the synthetic ammonia water in the previous study [14]. This could be the result of the carbonate salts of metal from swine wastewater and partial co-precipitation of suspended solids after pre-alkalinization.

3.2. Effect of rotational speed (ω) on the ARE and $K_{L}a$

The effect of the rotational speed on the ARE and the $K_{L}a$ from digested swine wastewater using the HP2R equipment is shown in Figure 3. In this experiment, the alkalization was selected at pH_i of 11, while other parameters were kept constant at Q_G of 216 L/min, Q_L of 0.10 L/min. The $K_{L}a$ of ammonia stripping was calculated to investigate its trend under the variation of rotating speed since it has been reported that higher centrifugal force contributed to intensified mass transfer in the rotating packed bed [33]. The ammonia removal from digested swine wastewater drastically increased as the rotating speed went faster. The ARE significantly rose from 39.18 % to 53.02 % as ω changed from 300 rpm to 600 rpm. The ARE value continued to increase but at a slower pace to 58.45 % and 62.77 % at ω of 900 rpm and 1200 rpm, respectively. Regarding the conventional packed column, the ammonia removal efficiency from wastewater could only be improved by the increment of the gas-to-liquid flow rate ratio. It could be done by either increasing the gas feed to the column or expanding the circulation time (longer hydraulic retention time) of the wastewater [17]. However, the novel advance of the HP2R equipment is that the ARE could also be significantly improved by accelerating the rotational speed [14]. It was the result of intensified mass transfer, particularly from 0.0012 s^{-1} to 0.0027 s^{-1} as the ω increased from 300 to 1200 rpm, respectively, in the ammonia removal from digested swine wastewater. This indicated that the $K_{L}a$ of ammonia stripping from swine wastewater with higher TSS content was similar to the result of synthetic ammonia-contained water ($K_{L}a$ of 0.0009 s^{-1} to 0.0028 s^{-1}) [14]. At higher rotating speeds, the collision between liquid and contact media under large centrifugal acceleration created special flow patterns of the liquid [37]. At ω from 900 to 1200 rpm, the flow pattern shifted from droplet form into thin-film form which enhanced the surface area of liquid to contact with the gas flow. This effect was also recorded in the stripping of ammonia in the synthetic wastewater which was reported by Yuan *et al.* [26, 27].

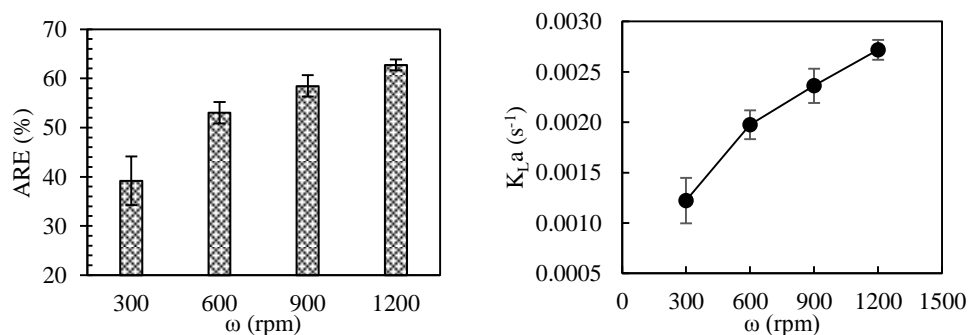


Figure 3. The effect of ω of HP2R on the ammonia removal and the overall liquid-phase mass transfer coefficient ($K_{L}a$) from digested swine ($Q_G = 216 \text{ L/min}$, $Q_L = 0.10 \text{ L/min}$, $\text{pH}_i = 11$, $C_{L_i} = 657 \text{ mg/L}$).

Another benefit of operating at a higher rotating speed was more stability and even distribution of the wastewater inside the packing. This benefit was indicated in the decrease of the standard deviation in both the ARE and the $K_{L}a$ results (Figure 3). Moreover, the precipitated solid found in the output sample was denser at the ω of 900 – 1200 rpm compared to that of ω of 300 rpm. This finding showed that a higher rotating speed was capable to discard the solid contents of the wastewater away from the packing which consequently avoided possible clogging or fouling during operation. Despite having higher ARE and mass transfer, the decision on selecting the optimal rotating speed should be carefully considered since a higher rotating speed means higher energy consumption and the overheating problem of the rotor shaft [14].

3.3. Effect of gas flow rate (Q_G) on the ARE and $K_{L,a}$

The effect of Q_G on the ammonia removal and the $K_{L,a}$ from digested swine is presented in Figure 4. The results indicated that increasing the fresh air loading to the system enhanced the ARE and the $K_{L,a}$ of ammonia removal from digested swine wastewater of HP2R at both rotating speed stages. The ARE significantly increased from around 45 % to 75 % as the Q_G increased from 116 L/min to 415 L/min. Similar to the ARE, the enhancement in the mass transfer of ammonia removal from digested swine wastewater was also recorded as the $K_{L,a}$ nearly doubled from 0.0020 s^{-1} to 0.0038 s^{-1} . The improvement of ARE and $K_{L,a}$ between ω of 900 rpm and 1200 rpm was insignificant by 4 - 6 % and 0.0003 to 0.0005 s^{-1} , respectively. The comparable effect of Q_G on the ARE from landfill leachate was recorded in the results of Ferraz *et al.* [17]. The authors reported that the Q_G of 4500 L/h derived almost 99 % of ARE after 24 h with the $K_{L,a}$ of 0.18 h^{-1} while it took 12 days to achieve a similar ARE with only 0.0154 h^{-1} of $K_{L,a}$. In comparison with the ammonia stripping from synthetic ammonia-contained wastewater, the $K_{L,a}$ of 0.0032 s^{-1} was achieved at a higher gas-to-liquid ratio ($Q_G/Q_L = 2910$) compared to the result of Yuan *et al.* [26] using the horizontal-bed equipment ($Q_G/Q_L = 1600$) and Viet *et al.* [14] using the same equipment ($Q_G/Q_L = 1600$). The higher solid content of swine wastewater compared to the synthetic sample might require a larger dosage of fresh air to achieve similar $K_{L,a}$ since it might partially accumulate the contact area of gas and liquid phases.

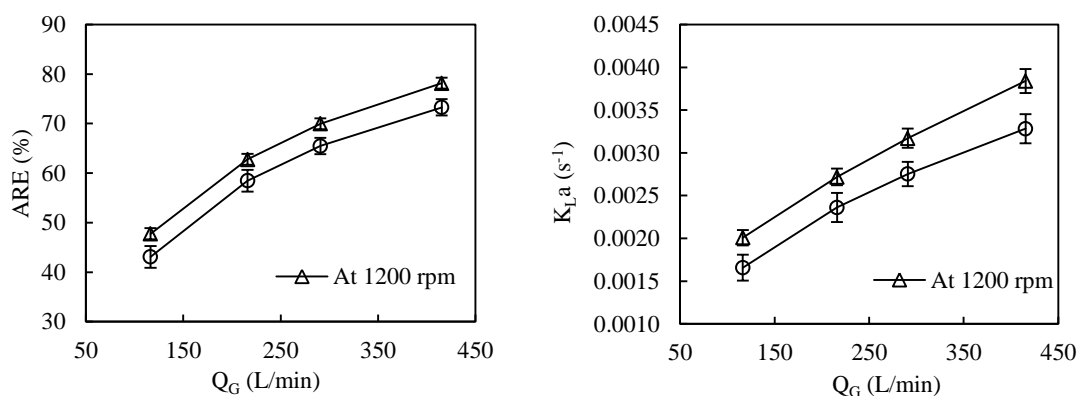


Figure 4. The effect of Q_G on the ammonia removal and the overall liquid-phase mass transfer coefficient ($K_{L,a}$) from digested swine ($Q_L = 0.10$ L/min, $pH_i = 11$, $\omega = 900$ rpm and 1200 rpm, $C_{Li} = 657$ mg/L).

In this study, the ARE of 73.29 % and $K_{L,a}$ of 0.0033 s^{-1} were achieved at Q_G of 415 L/min, equivalent to Q_G/Q_L of 4150, which was much greater than the maximum ratio of the conventional packed column in previous studies with swine wastewater (from 45 to 400) [16, 17]. In a design process of a conventional packed column, the Q_G/Q_L is normally limited due to the pressure drop and the flooding point of liquid [38]. The flooding phenomenon often occurs when the liquid downward flow is blocked by the excessive load of gas and remains bubbled in the top surface of the packed column. Therefore, despite the enhanced ARE and $K_{L,a}$, the Q_G/Q_L in the conventional column is normally limited (around 400) to avoid such column fouling. The HP2R, on the other hand, could be operated in a much larger Q_G/Q_L ratio (over 4000) with the high centrifugal field generated by the accelerated rotating bed, resulting in higher ARE and $K_{L,a}$ without encountering the flooding and fouling of the system. However, an adequate gas flow rate should be carefully selected for HP2R to avoid the turbulence of the absorption unit.

3.4. Effect of wastewater flow rate (Q_L) on the ARE and $K_{L,a}$

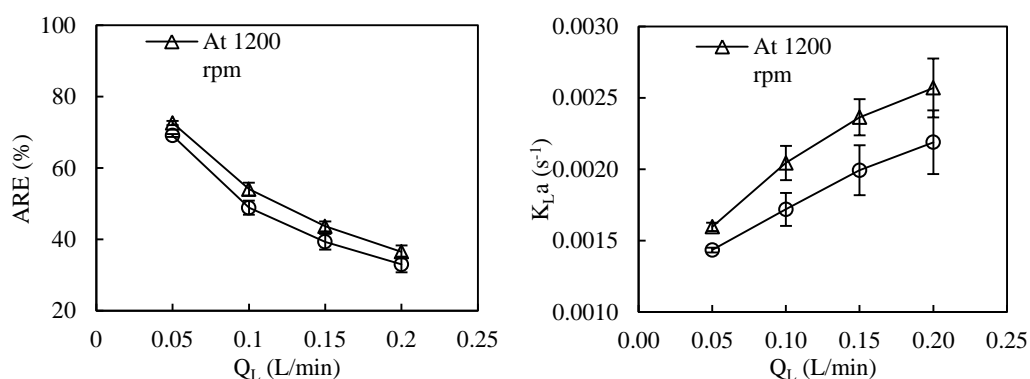


Figure 5. The effect of Q_L on the ammonia removal and the overall liquid-phase mass transfer coefficient ($K_{L,a}$) from digested swine ($Q_G = 216$ L/min, $pH_i = 11$, $\omega = 900$ rpm and 1200 rpm, $C_{Li} = 657$ mg/L).

The effect of Q_L on the ammonia removal and the $K_{L,a}$ from digested swine is presented in Figure 5. In this experiment, the Q_G of 216 L/min instead of 415 L/min was selected to avoid the turbulence of the absorption unit during the experiment. The results indicated that both ARE and $K_{L,a}$ significantly depended on the variation of Q_L from 0.05 to 0.20 L/min, but it was an opposite trend. Regarding the ARE, the higher feeding rate of swine wastewater from 0.05 L/min to 0.20 L/min reduced by two folds from approximately 70 to 35 % at both ω of 900 and 1200 rpm. The higher Q_L led to significant loading of wastewater and also reduced the Q_G/Q_L ratio which resulted in lower ARE. Viet *et al.* discussed that a higher liquid flow rate may cause the disturbance of liquid flow leading to an unstable ClO_2 stripping process [25]. Yuan *et al.* also stated that the compensatory effect of a high liquid flow rate was responsible for the decrease in liquid retention time and stripping factor that consequently reduce the ARE [26]. In contrast, the mass transfer was in an increasing trend at higher Q_L . Specifically, when the Q_L changed from 0.05 to 0.20 L/min, the $K_{L,a}$ value drastically increased from 0.0014 s^{-1} to 0.0022 s^{-1} and 0.0016 s^{-1} to 0.0026 s^{-1} at ω of 900 rpm and 1200 rpm, respectively. Although the higher wastewater flow rate might have lower ARE, the actual separation rate of ammonia from the liquid phase over time could be significantly improved as the higher mass of ammonia was transferred into the gas phase.

The opposite trend of ARE and $K_{L,a}$ indicated that the selection of operational conditions, especially Q_L , is crucial when it takes to the real application. Besides the ammonia removal efficiency, the higher $K_{L,a}$ reflects the shorter recirculation time of wastewater for ammonia removal. Moreover, a higher concentration of ammonia in the gas phase and an adequate gas flow rate may be preferable for the effective recovery unit. The comparison of ammonia removal from swine wastewater is presented in Table 3. These methods include ammonia stripping and struvite precipitation, which are two suitable methods for ammonia removal and recovery from a concentrated stream. At a higher Q_G/Q_L ratio of 4150, the maximum ARE from swine wastewater in this study (73.29 %) was comparable to that of the stripping process from synthetic wastewater [14, 26]. This finding indicated that a higher dosage of fresh air might be necessary for the stripping of ammonia from solid-contaminated wastewater like swine wastewater or even fresh pig slurry. Compared to a conventional packed column, the HP2R equipment possessed considerable $K_{L,a}$ (11.88 h^{-1}) which was 10 times higher than that of a much larger column (0.83 h^{-1}) [18]. The obtained results were even higher than the innovative heated spraying system of Cao *et al.* for ammonia removal from swine wastewater ($K_{L,a} = 0.297$ h^{-1}) [39]. The ARE from single batch of stripping using HP2R, however, was lower than that of

the struvite electrochemical precipitation method of Huang *et al.* [40]. In further studies and future applications, the ARE by stripping with HP2R could be improved by the elongated HRT with less chemical consumption and easy operation.

Table 3. Comparison of high-concentration ammonia removal methods from swine wastewater and others.

| Method | Wastewater type | C_{Li} $\text{NH}_3\text{-N}$ (mg/L) | Equipment size | Experimental condition | | | | ARE (%) | K_{La} | Ref. |
|--|--------------------|---|--|------------------------|------------------------------------|---------------------------------|-----------|---|--|--------------------------|
| | | | | HRT (h) | Chemical addition | T_{Li} ($^{\circ}\text{C}$) | Q_G/Q_L | | | |
| Air stripping using HP2R | Digested swine ww. | 657 ± 101 | $d = 16.6 \text{ cm}$ $Z_B = 3.9 \text{ cm}$ $V_B = 0.774 \text{ L}$ | Instant single batch | NaOH pH = 11 | 30 | 4150 | 73.29 | 0.0033 s^{-1} 11.88 h^{-1} | This study |
| | Synthetic ww. | 1000 ± 100 | | | NaOH pH = 12 | | | 3052 | 74.9 | 0.0047 s^{-1} |
| Horizontal rotating packed bed | Synthetic ww. | 1000 | $V_B = 0.4 \text{ L}$ | Instant single batch | NaOH pH = 11 | 30 | 1600 | 69 | 0.0037 s^{-1} | Yuan <i>et al.</i> [26] |
| Stripping via heated spraying system | Swine ww. | 611 ± 8 | $V_{\text{Tank}} = 5 \text{ L}$ | 264 | NaOH pH = 9 | 55 | - | 97.11 | 0.297 h^{-1} | Cao <i>et al.</i> [39] |
| Air stripping in packed column | Fresh swine ww. | 3.39 g/kg (Fresh slurry) 3.68 g/kg (Digested slurry) | $d = 5 \text{ cm}$ $h = 97.5 \text{ cm}$ $V = 1.913 \text{ L}$ | 4 (circulation mode) | NaOH pH = 12 | 80 | 75 | 98.8% (Fresh slurry) 96% (Digested slurry) | 1.2 h^{-1} (Fresh slurry) 0.83 h^{-1} (Digested slurry) | Bonmati and Flotats [18] |
| Struvite electrochemical precipitation | Digested swine ww. | 426 ± 21 | 1L reaction vessel | 2 | Magnesium plate HCl/NaOH pH = 9 | - | - | >90% | - | Huang <i>et al.</i> [40] |

4. CONCLUSIONS

This study comprehensively investigated ammonia removal from digested swine wastewater using HP2R. The results showed that HP2R effectively removed ammonia in a laboratory-scale batch mode, with ammonia removal efficiency (ARE) ranging from 33 % to 78 % under various gas and liquid flow rates. Pre-alkalinization at pH 11, rotational speeds (ω) of 900-1200 rpm, and an initial ammonia concentration of 660 mg/L enhanced the mass transfer rate ($K_{La} = 0.0014\text{-}0.0038 \text{ s}^{-1}$). This performance surpassed conventional packed columns ($K_{La} = 1.2 \text{ h}^{-1}$) and heated spraying systems ($K_{La} = 0.297 \text{ h}^{-1}$). Higher rotational speeds (900 - 1200 rpm) improved ARE and K_{La} , making HP2R comparable to other methods like conventional stripping and struvite precipitation. Swine wastewater required more fresh air than synthetic wastewater to achieve similar ARE and K_{La} . At high pre-alkalinization pH, carbonate salts and co-precipitated solids formed, risking clogging, which could be mitigated by high rotational speeds. These findings provide a basis for future studies on continuous HP2R operation and its field application.

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CRedit authorship contribution statement. Viet M. Trinh: Experimental conduction, Manuscript preparation, Manuscript revision. Phuong Thao Nguyen: Experimental conduction, Formal analysis. Van Tuyen Trinh: Funding acquisition, methodology, manuscript revision. Huu Tung Pham: Experimental conduction. Van Manh Do: Manuscript revision. Thanh Long Ngo: Supervision

Declaration of competing interest. The authors declare that they have no known competing financial interests or personal relationships that could have appeared to influence the work reported in this paper.

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