Potential Energy savings in compressed air systems in industrialized cities. A case study in Barranquilla and Cartagena

Hernan Hernandez Herrera¹, Jorge Iván Silva-Ortega², Vicente Leonel Martínez Díaz¹, Aliana Gomez Pons³, Zaid García Sanchez⁴.

¹Universidad Simón Bolívar, Facultad de Ingenierías, Barranquilla, Colombia.
²Research Group in Energy Optimization GIOPEN - Universidad de la Costa, Barranquilla Colombia.
³Accounts Department, Universidad de Cienfuegos, Cuba- e-mail:
⁴Center of Energy and Environmental Studies Department, Universidad de Cienfuegos, Cuba.

Abstract. The increase of energy consumption, global warming, resource depletion and the rise of policies focused on climate change and greenhouse gas emissions reductions, have promoted to countries and industries the implementation of strategies focused on increase energy efficiency and reduce GHG emissions. Compressed Air Systems (CASs) are one of the most widespread systems used in industry. In countries such as China, USA, Australia, France and Italy, CASs accounts around 10% of the overall electricity costs. In Colombia the energy used in the industrial sector, rise the 33 % of the total energy consumption, equal to 481.429 TJ/year; the electricity consumption is a 13 % of this value, equivalent to 13,3 TWh/year. This paper determine the potentials energy saving of CASs for two industrial cities of the Colombian Caribbean Coast region, showing that there is a high energy saving potential, around 50 GWh/year and a reduction of CO₂ emissions of 10,702 tons of CO₂/year, which can be taken in consideration by the government and organizations to develop projects focused on reduce energy consumption and mitigate CO₂ emissions.

1. Introduction
Worldwide energy consumption will increase 1.2% per year to 2040, being the industrial sector the biggest consumer, with about 54% of the total energy consumption [1, 2]. This growth is led by gas consumption and electricity uses as it is shown in Figure 1.
In Colombia the energy used in the industrial sector, rise the 33\% of the total energy consumption, equal to 481.429 TJ/year; the electricity consumption is a 13\% of this value, equivalent to 13,3 TWh/year [3]. In Colombia is estimated that the electricity uses will have a growth rate of 52\% between 2016 and 2030 [4] highlighting the Cost-Caribbean region as the fastest growing. Figure 2 shows this trend by region.

This increase in energy consumption, the global warming, the resource depletion and the rise of policies focused on climate change and greenhouse gas emissions reductions, have promoted to countries and industries the implementation of strategies focused on increase energy efficiency and reduce GHG emissions [5-7]. Colombia is committed to this, and the government has proposed a group of policies which includes: The Indicative Action Plan (PROURE), Law 1715, National Development Plan (PND) and the Colombian Low Carbon Development Strategy (ECDBC) [8]. These policies focus on reducing 20\% of GHG by 2030 considering an inertial scenario, a commitment
proposed by Colombia at COP 21 [9]. The implementations of good practices in compressed air systems are outstanding strategies to develop the indicative action plan for energy efficiency 2017-2022 [4].

Compressed Air (CA) is one of the most widespread systems used in pneumatic systems to operate valves and cylinders, transporting products, cleaning, among others uses, due to factors such as good transportability, speed, cleanliness, and riskless [10-16]. In many countries as China, USA, Australia, France and Italy Compressed Air Systems (CASs) accounts around the 10% in the overall electricity costs for industries [17, 18]. In Colombia this value reaches the 8 %, equivalent to 1.39 TWh/year [19-21]. However, CASs has been recognized as one of the most expensive forms of energy, only about the 19 % of the consumed energy reaches the end use point [22, 23]. Energy losses can be caused by heat, inefficient uses, pressure drops, inadequate storage, leaks, among others [24, 25]. According with [26] the energy cost required to operate a CASs can be up 75 % of total life cycle cost, higher than investment and maintenance which represents the 13 % and 12 % respectively [27, 28].

The energy efficiency measures applied in CASs such as: reducing the compressors pressure, matching the supply and demand, adequate storage capacity, reducing the air intake temperature, optimizing the air compressor location and to reduce leaks, may give energy savings between 20-60 % with a usual payback lower than two years [29-31]. Furthermore, energy savings, increase energy efficiency in CASs, may ensure other Non-Energy Benefits (NEBs) such as: maintenance cost reduction, capital avoidance, productivity improvement [32, 33]. These are reasons why CASs can be considered as one of the main targets in the implementation of energy efficiency actions at country, region and industry level [11].

In some industries, staff are quick to identify energy losses from pump systems, hot surfaces, but do not pay same attention to the losses involved in the generation of compressed air, because they do not produce dirt, residues or accidents; also, the wrong approach considering compressed air as cheap, or even it is considered a free source of energy [34-36]. Another aspect is that CASs is often considered as a common utility and in most cases, they are not assigned to a specific area and therefore they become difficult to manage [37]. However, the only moment where CASs gets all the attention is when the air losses and pressure drops interfere with the normal operation of the plant [26]. This paper analyzes the potential savings in CASs for two important cities in the Caribbean Coast Region of Colombia if the different energy efficiency measures are taken there is a potential energy savings around 50GWh/year and reduction the CO2 emission in 10 702 tonnes of CO2/year.

2. Potential energy savings in Compressed Air Systems.
CASs are composed by two fundamental areas: Supply and Demand. In the Supply side the inlet air is converted in compressed air, this side include compressors, controls, air dryers, air receivers, filters and drains; in the demand side the air is carry out to the end use equipment and it is comprises of distribution lines, filters, pressure and flow controls and end-use consumers as is shown in Figure 3.
Figure 3. CASs structure and elements divided according to supply and demand sides. Source of data: Prepared by the authors based on data from: [16, 32].

In [6, 26, 37] have found that the 50-70% of the overall energy efficiency measures are related to demand side, the main measures are: air leaks reduction, inappropriate uses, reduction artificial demand, recover waste heat, inefficiencies in air system distribution and an inadequate maintenance. On the supply side the main measures are: to improve compressor operation and control, to reduce intake air temperature and to install new technologies based in efficiency concept. Table 1 shows these strategies, energy savings, applicability, payback period and costs.

Table 1. Strategies for saving Electricity in CASs. Source of data: Prepared by the authors based on [6, 26, 37].

| Energy savings strategy | Annual Energy savings % | Applicability % | Potential Contribution % | Payback Period (Months) | Annual Cost ($$) |
|-------------------------|-------------------------|-----------------|--------------------------|-------------------------|-----------------|
| Using cooler intake air | 10                      | 40              | 4                        | 5                       | 1400            |
| Compressors Controls    | 10                      | 30              | 3                        | 8                       | 7900            |
| Compressors pressure reduction | 15          | 50              | 7,5                      | 4                       | 2800            |
| Reducing air leaks      | 30                      | 53              | 15,9                     | 3                       | 3900            |
| Eliminating or reducing compressors air used | 25 | 10 | 2,5 | 6 | 7300 |
| Air compressor Waste Heat Recovery | 20 | 20 | 4 | 10 | 2700 |
| Improving filter maintenance | 2    | 40              | 0,8                      | -                       | -              |
| Use variable speed drives | 15          | 25              | 3,8                      | -                       | -              |
| **Total**               | **41,5**               |                 |                          |                         |                 |

3. Energy savings in Barranquilla and Cartagena Cities.

3.1 Structure of manufacturing sector.

In Colombia, the manufacturing sector is formed by 23 divisions, as product of the revision 3.1 A.C updated by the Statistics Administrative Department (DANE), adopting the revision 4 A.C which corresponds with the fourth revision of the International Standard Classification of All Economic Activities [38, 39]. This sector is made up by more than 8000 companies. Tables 2 shows a detailed
structure of the manufacturing sector, the number of companies by division and the electricity consumption in Barranquilla and Cartagena cities respectively.

3.2 Energy savings by divisions.
A study developed by [19, 20, 21] in more than five hundred manufacturing companies in the country established the percent of electricity consumption in CASs by divisions of total electricity consumption. The CASs electricity share costs in all divisions are around 8%, highlighting divisions such as textile manufacturers, where it was reached a 24%. Table 3 shows these values.

Figure 4 shows the energy savings potential in the CASs in Barranquilla and Cartagena for all divisions. In most of the divisions the saving potentials in the city of Barranquilla are greater than Cartagena, only in the sectors of Manufacture of chemicals and chemical products, Manufacture of rubber and plastics products, Manufacture of other non-metallic mineral products and Manufacture of coke and refined petroleum products, the saving potential is greater in Cartagena.

Table 2. A Detailed structure of manufacturing section in Barranquilla and Cartagena: Data source: Prepared by the authors based on [38, 39].

| Section     | Division | Description                                                                 | Number of companies in Barranquilla | Electricity consumption (Kwh/year) | Number of companies in Cartagena | Electricity consumption (Kwh/year) |
|-------------|----------|------------------------------------------------------------------------------|-------------------------------------|-----------------------------------|----------------------------------|-----------------------------------|
| C. Manufacturing | 10       | Manufacture of food products                                                 | 70                                  | 164.761.051                       | 16                               | 34.030.948                        |
|             | 11       | Manufacture of beverages                                                    | 9                                   | 90.604.089                        | 4                                | 33.773.345                        |
|             | 12       | Manufacture of tobacco products                                             | -                                   | -                                 | -                                | -                                 |
|             | 13       | Manufacture of textiles                                                     | 10                                  | 37.070.428                        | -                                | -                                 |
|             | 14       | Manufacture of wearing apparel                                               | 22                                  | 2.505.818                         | -                                | -                                 |
|             | 15       | Manufacture of leather and related products                                  | 6                                   | 9.760.246                         | -                                | -                                 |
|             | 16       | Manufacture of wood and of products of wood and cork, except furniture;       | 3                                   | 154.376                           | 4                                | 189.657                           |
|             |          | manufacture of articles of straw and plaiting materials                      |                                     |                                   |                                  |                                   |
|             | 17       | Manufacture of paper and paper products                                      | 5                                   | 48.111.729                        | -                                | -                                 |
|             | 18       | Printing and reproduction of recorded media                                 | 21                                  | 6.167.848                         | -                                | -                                 |
|             | 19       | Manufacture of coke and refined petroleum products                           | 7                                   | 886.154                           | 9                                | 124.953.234                       |
|             | 20       | Manufacture of chemicals and chemical products                              | 27                                  | 85.756.298                        | 21                               | 606.271.720                       |
|             | 21       | Manufacture of pharmaceuticals, medicinal chemical and botanical products    | 7                                   | 30.993.542                        | -                                | -                                 |
|             | 22       | Manufacture of rubber and plastics products                                  | 22                                  | 47.623.089                        | 13                               | 161.469.858                       |
|             | 23       | Manufacture of other non-metallic mineral products                           | 23                                  | 98.529.920                        | 8                                | 162.296.034                       |
|             | 24       | Manufacture of basic metals                                                  | 10                                  | 75.179.118                        | 4                                | 1.158.365                         |
|             | 25       | Manufacture of fabricated metal products, except machinery and equipment     | 23                                  | 10.631.964                        | 10                               | 2.191.413                         |
|             | 26       | Manufacture of computer                                                     | -                                   | -                                 | -                                | -                                 |
| Section | Division                                                                 | Description                                             | Number of companies in Barranquilla | Electricity consumption (Kwh/year) | Number of companies in Cartagena | Electricity consumption (Kwh/year) |
|---------|--------------------------------------------------------------------------|---------------------------------------------------------|------------------------------------|-----------------------------------|----------------------------------|-----------------------------------|
| 27      | electronic and optical products                                          | Manufacture of electrical equipment                    | -                                  | -                                 | -                                | -                                 |
| 28      | Manufacture of machinery and equipment N.E.C.                            | 14                                                     | 4,861,090                         | 3                                 | 1,490,521                        |                                   |
| 29      | Manufacture of motor vehicles, trailers and semi-trailers               | 3                                                      | 138,526                           | -                                 | -                                | -                                 |
| 30      | Manufacture of other transport equipment                                 | -                                                      | -                                 | -                                 | -                                | -                                 |
| 31      | Manufacture of furniture                                                 | 14                                                     | 8,318,401                         | -                                 | -                                | -                                 |
| Total   |                                                                         | 296                                                    | 722,053,687                       | 92                                | 1,127,825,09                    | 5                                 |

**Table 3.** CASs electricity share costs of total electricity consumption in all divisions.

| Divisions                                                                 | % of electricity Consumption | Divisions                                                                 | % of electricity Consumption |
|--------------------------------------------------------------------------|------------------------------|--------------------------------------------------------------------------|------------------------------|
| Manufacture of food products                                             | 10                           | Manufacture of pharmaceuticals, medicinal chemical and botanical products | 3.2                          |
| Manufacture of beverages.                                               | 11                           | Manufacture of rubber and plastics products                              | 12.8                         |
| Manufacture of tobacco products                                          | 2                            | Manufacture of other non-metallic mineral products                        | 4.2                          |
| Manufacture of textiles                                                  | 24                           | Manufacture of basic metals                                              | 2                            |
| Manufacture of wearing apparel                                           | 12                           | Manufacture of fabricated metal products, except machinery and equipment  | 4.3                          |
| Manufacture of leather and related products                              | 15                           | Manufacture of computer, electronic and optical products                  | 6.8                          |
| Manufacture of wood and of products of wood and cork, except furniture;  | 17                           | Manufacture of electrical equipment                                       | 2.7                          |
| manufacture of articles of straw and plaiting materials                  |                              |                                                                          |                              |
| Manufacture of paper and paper products                                  | 3                            | Manufacture of machinery and equipment.                                   | 2.8                          |
| Printing and reproduction of recorded media                              | 9                            | Manufacture of motor vehicles, trailers and semi-trailers                 | 4.1                          |
| Manufacture of coke and refined petroleum products                       | 5.1                          | Manufacture of other transport equipment                                  | 7.7                          |
| Manufacture of chemicals and chemical products                           | 4.1                          | Manufacture of furniture                                                  | 6.8                          |
Figure 4. Savings potential in the compressed air system in the city of Barranquilla and Cartagena for different divisions.

Although in Cartagena there are three times fewer industries than in Barranquilla, the energy savings potential are greater due to the fact that the existing industries are large consumers of electricity.

3.3 Potential of CO$_2$ reduction.

Figure 5 shows the impact in the reduction of CO$_2$ emissions, considering the specific emission factor for power generation in Colombia of 0.2129 kgCO$_2$/kWh (Roa and Castellanos, 2018). The total reduction is equivalent to 10.702 tonnes of CO$_2$/year, 4.939.169 in Barranquilla and 5.763.157 in Cartagena.

Figure 5. Potential of CO$_2$ reduction in energy efficiency measures are applied.
4. Conclusions.
Compressed Air Systems (CASs) are one of the most widespread systems used in industry. In countries such as China, USA, Australia, France and Italy CASs accounts around 10% of the overall electricity costs. However, CASs has been recognized as one of the most expensive form of energy, applied energy efficiency measures may give between 20-60 % of energy savings with a usual payback lower than two years. These are reasons why CASs can be considered as one of the main targets systems for the implementation of energy efficiency actions in many country, regions and industry levels.

The implementation of good practices in CASs is one of the strategies to be developed by governments focused on reduce energy consumption. This paper shows the potential energy savings and CO₂ reduction in CASs for two cities of the Colombian Caribbean Coast region, which are around 50GWh/year and 10 702 tonnes of CO₂/year, these results can be used by the government and organizations to implement energy efficiency projects in the identified energy savings potentials, which is related with the Colombia commitment focused on reduce a 20% of GHG by 2030, considering an inertial scenario, as it was proposed during COP 21.

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