Comparison of dye wastewater treatment methods: A review

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Abstract

Wastewater is produced by numerous dyes producing and dye consuming industries in their process activities especially the textile industry. These effluents become toxic and harmful to the living things and the environment if not properly treated before being discharged to the environment. In recent decades dye wastewater has become a growing water pollution problem because it is one of the most difficult to treat. To put an end to this problem, viable, efficient, and sustainable method of treatment of dye wastewater and color removal needs to be established. Several research papers have been done over the years on various treatment method of dye wastewater with evolving options; this paper is to bring together both the conventional and new methods. Some of the conventional and new methods researched over the years include activated sludge, coagulation, adsorption, membrane separation processes and electrochemical process etc. Although there is currently no uniform standard or method of treatment universally adopted, many countries have put in place allowable limits of composition of dischargeable wastewater. This paper seeks to explore which methods are highly efficient, produces manageable and recyclable waste and a combination/hybrid treatment option of these methods to achieve maximum color removal.

Keywords: Adsorption; Coagulation; Color removal; Dye Wastewater; Hybrid treatment; Membrane separation

1. Introduction

Due to modernization and population growth, demand for beauty and color continues to increase. To meet this demand, many industries such as textile, leather, paper, and plastic use dyes to color their products and consume substantial volumes of water. As a result of process inefficiency from the industries, about 10-15% of dye are lost into the waste stream during production and is discharged as large volumes of dye wastewater into the environment. The release of this effluent without further treatment into water bodies results in ecosystem damage, water shortage and degeneration [1, 2, 3, 4]. The direct discharge of these effluent into natural water sources results in damages to the ecosystem and induction of mutagenic effects on mammals’ organs, which greatly threatens human health [5]. Dyes are very toxic, stable, highly visible in trace amount, and not easily biodegradable. Dyes can be natural or synthetic and are classified into acid, basic, disperse, reactive, direct, vat, metal complex, sculpture and mordant dyes. There are over 10,000 dyes used in textile production with nearly 70% being azo dyes which has a complex structure and synthetic in nature [6]. The dye wastewater has high alkalinity, biochemical oxygen demand (BOD), chemical oxygen demand (COD), total dissolved solids (TDS) and low biodegradability [7]. It is easy to identify the presence of dye in water bodies because it is aesthetically unpleasant, and the quality of water as perceived by the public is considerably influenced by the color. The highly colored component of dye obstructs the reoxygenation capacity of the water bodies and hinders sunlight penetration, thereby disrupting biological activity in aquatic life.
Hence the aim of the paper is to provide an overview of the different types of dye, process stages in the textile industry, health and environmental impact of dye, conventional and new technologies in wastewater treatment and possible combination of the dye wastewater treatment methods.

2. The dye industry

Annually, an estimated 700,000 tons of color is manufactured from about 100,000 commercial dyes and globally about 3000–4000 kilotons of wastewater generated from dye producing and dye-utilizing industries. Among the various source of dye wastewater, the textile industry is largest contributor of about 54% of dye effluent polluting the environment. This account for more than half of the worldwide industrial dye effluent produced. The dyeing industry contribute up to 21% while the paper and pulp industry, tannery and paint industry, and dye manufacturing contributes up to 10%, 8% and 7% respectively to the overall through their various process activities. The distribution is represented in Table 1 [8, 9].

The unit process in the textile industry includes sizing, desizing bleaching, dyeing, and printing with some leftover dye at the process completion [10]. The leftover dye is because only about 80% of the dye and other chemical used are absorbed by the materials to be colored. The dye effluent contains many other unsafe chemicals such as hydrogen peroxide, caustic soda and many others as listed in table 2. Table 2 lists the processes, the percentage of leftover dye wastewater generated from each process, effluent composition, and wastewater characteristics.

**Table 1** Industrial sources of dye wastewater [8]

| Industry         | Percentage contribution |
|------------------|-------------------------|
| Textile          | 54%                     |
| Dyeing           | 21%                     |
| Paper and pulp   | 10%                     |
| Tannery and paint| 8%                      |
| Dye producers    | 7%                      |

**Table 2** Percentage and composition of dye wastewater from textile manufacturing [8, 11]

| Unit process | % of dye wastewater discharge | Wastewater composition                                      | Wastewater characteristics                           |
|--------------|------------------------------|-------------------------------------------------------------|-------------------------------------------------------|
| Desizing     | 21%                          | Starch, carboxymethyl cellulose, polyvinyl alcohol, waxes, ammonia | High BOD and COD, dissolved solids                    |
| Scouring     | 52%                          | Waxes, caustic soda, surfactants, soda ash                  | High COD, dissolved solids                            |
| Bleaching    | 62%                          | Caustic soda, hypochlorite, surfactants, acids, chlorine, hydrogen peroxide | Alkalinity, suspended solids (SS)                     |
| Mercerizing  | 4%                           | Sodium peroxide, cotton wax                                 | High pH, low BOD, high dissolved solids (DS)          |
| Dyeing       | 85%                          | Reducing agents, oxidizing agents, detergents, dyestuffs, urea, wetting agents | Highly colored, Heavy metals, high BOD, low SS       |
| Printing     | 13%                          | Gum, starch, binders, oil, reducing agents                 | Highly colored, high BOD, oily appearance, SS        |
| Finishing    | 58%                          | chlorinated compounds, waxes, inorganic salts, softener    | Low BOD, slightly alkaline, high toxicity             |
3. Dyes

Dyes are natural or synthetic organic compounds that connect itself to surfaces or fabrics to provide bright and lasting color. Dyes have affinity towards the substrate. Most dyes are soluble in water and generally applied to aqueous solutions although may require a mordant to improve the fastness of the dye on the fiber. During the early years, dye was obtained from natural sources which include the plants trees, lichens, and insect. Attempts to extract more dyes from brightly colored plants and flowers failed because a lot of natural dyes are unstable occurring as components of complex mixtures. Based on the inadequate availability of natural dye and the high demand for dye, the synthetic dye was developed. Synthetic dyes are derived from complex organic or inorganic compound. In general, they are produced in the dye industries from chemicals. Most dyes used today are in this category. The first synthetic dye was accidentally discovered by William Henry Perkin while looking for a cure for malaria disease in 1856. Due to low production costs and easy application to the fabric, synthetic dyes are produced in large scale, but their toxic nature is a cause for concern. Dye wastewater generated from using the synthetic dye which is usually in large volume pose serious threat to lining things and the environment at large. Natural dyes have certain advantage over synthetic dye such as no toxicity, easy extraction and purification, renewable resources, little to no effluent generation. A better option to explore would have been to revert to using natural dyes but natural dyes have its disadvantage such as requiring the use of mordant to ensure proper bonding to fabrics, poor shade productivity and poor color fastness [12]. Mordants are toxic binding agents which help natural dyes to attach to fabric and pose the same amount of risk to the environment. Synthetic dyes have complex molecules which are stable because they possess auxochrome and chromospheres which enables their water-soluble bonding and coloring characteristics.

3.1. Classification of dyes

| Dye type    | Water solubility | Chromophoric groups | Application | Examples                      |
|-------------|------------------|----------------------|-------------|-------------------------------|
| Acid        | Soluble          | Azo, anthraquinone, azine, nitroso, triphenylmethane, xanthene, nitro. | Food, silk, leather, wool, nylon, paper, Cosmetics, printing ink, acrylics, polyamide fibers | Acid Yellow 36, Acid Orange 19 |
| Basic       | Soluble          | Acridine, azo, oxazine anthraquinone, azine, cyanine, thiazine, diazahemicyanine, xanthene, triarylmethane | Silk, wool, inks, wood, medicine, paper, straw tannin-mordant cotton, polyesters, leather | Crystal violet, Methylene Blue |
| Azo         | A type of direct dye | Stilbene, pyrazoles, coumarin, anaphthalimides | Rayon, cotton, plastics, paints, acetate, cellulose materials, detersgents | Acid red 88, Acid orange 19 |
| Disperse    | Insoluble        | Azo, anthraquinone, nitro, styryl, benzodifuranone groups | Polyester, nylon, plastic, cellulose acetate, acrylic fibers | Disperse Blue 27, Disperse Yellow 3 |
| Direct      | Soluble          | Polyazo compounds, stilbenes, oxazines, phthalocyanines, | Cotton and rayon, paper, leather, nylon, wool, silk cellulose, fibers, linen, | Direct Orange 39, Direct Blue 15 |
| Fluorescent brighteners | Mostly soluble but some insoluble | Naphthylamides, stilbene coumarin, pyrazolos | All fibers, oils, paints, plastics, soaps, detergents | 4, 4‘-bis (ethoxycarbonyl vinyl) stilbene |
| Mordant     | Soluble          | Anthraquinone and azo | Anodized aluminum, wool, leather, | Mordant Blue 3 |
| Oxidation bases | -na-            | Aniline black and indeterminate structures | Cotton, fur, and hair | Direct Blue |

Table 3 Classification and application of dyes [8, 13, 14]
Dyes are classified based on their unique chemistry, structure, way of bonding, source of materials, chemical composition, and industrial performance as shown in Table 2. They could be natural or synthetic based on the source of material used to produce them. Examples of natural dyes are Turmeric (Curcuma longa), Onion (Allium cepa), and Indigo (Indigo era tinctoria). Examples of the synthetic dyes used by the industries includes azo, disperse, Acid, basic, direct, mordant, reactive, sculpture and vat dyes with azo dyes being the most produced and utilized class of dye up to a rate of about 70% of the total worldwide usage of dye.

| Reactive  | Soluble          | Cotton, wool, yarn, silk cellulose, painting, polychromatic printing | Reactive Blue 5          |
|-----------|------------------|----------------------------------------------------------|--------------------------|
| Vat       | Insoluble but soluble with alkali | Anthraquinone (including polycyclic quinones), indigoids, and carbazole | Cotton, cellulose fibres, polyester-cotton, rayon, and wool |
| Solvent   | insoluble (solvent soluble), nonpolar or little polar | Azo, anthraquinone, phthalocyanine, triarylmethane | Plastics, gasoline, lubricants, oils, waxes |
| Sulfur    | Insoluble        | Nitro and amino groups | Cotton, rayon, polyamide fibers, silk, leather, paper, Sulphur black 1, indophenol |

### 4. Effect of dye on health and environment

Although dye impacts color on material bringing about beautification and enhancing the products of various industry, the production and utilization processes of dye comes along with several health and environmental hazards. Long term exposure of workers to dyestuffs and other chemicals used in production and utilization of dye can lead to health hazards while chemicals must be handled with care. These chemicals include formaldehyde-based resins, ammonia, acetic acid, shrink-resist chemicals, optical whiteners, soda ash, caustic soda, and bleach. Commonly for reactive dyes, inhalation of dye particles lead to respiratory problems (respiratory sensitization), and often it affects a person's immune system [15]. Symptoms and side effects includes itching, watery eyes, sneezing, coughing, wheezing, skin irritation and sore eyes [6]. During the dying process for treatment of cloth with boiling liquor, acid and alkalis used can lead to risk to the burns and scalds in workers are exposure occurs. Other hazards can result from chips flying from metals like chromium when it strikes workers. Aromatic amines used in dying industries can cause DNA (deoxyribonucleic acid) mutation. When using sculpture dye which requires to reducing agents like formaldehyde, exposure to reducing agents can lead to cancer on nose, lung, and brain [16]. Textile industries produce large amounts of liquid effluents and sludge which contain organic and inorganic compounds. If this effluent is not properly treated, it will prevent sunlight from penetrating through water surface to provide required oxygen by aquatic creatures [17]. This produce a visible layer above water which is aesthetically unpleasant and produce a foul odor thereby polluting the air. The dye effluent also destroys soil productivity if it finds its way to the soil.

#### 4.1. Environmental standard for wastewater discharge

In recent years, there has been increasing environmental awareness and stricter governmental regulations about the discharge of toxic colored wastewater into the water bodies. Also, the scarcity and increasing cost of water for industrial processes has made treatment and reusing of color effluent a good alternative for industries. Based on these and other factors, dye producing and utilizing industries have to ensure wastewater discharge from there operations meet the standard quality and guideline provided by environmental regulating bodies such as the USEPA (U.S. Environmental Protection Agency) and others as designated by different countries. For textile wastewater, the main concern for the regulatory bodies are metal ions, dyes, and its colors because of their hazardous impact on human and the environment. This standards and allowable limit are presented in Table 4.

To meet the below standard and limit and mitigate cost of treatment and buying of fresh water, industries need to develop efficient method for contaminant and color removal as well as consider the option of reusing the wastewater produced.
Table 4 Standard for Dye Effluent Discharge by Countries [8, 16, 18]

| Country   | Temperature (°C) | pH       | BOD (mg/l)       | COD (g/l)  | SS (mg/l) |
|-----------|------------------|----------|------------------|------------|-----------|
| United State | 42               | 6.5-8.5  | 30-45 mg/l       | 30-45      |           |
| Nigeria   | 40               | 6.0-9.0  | 30-50            | 60-90      | 25        |
| Uganda    | 35               | 6.0-8.0  | 50               | 100        | 10        |
| Malaysia  | 40               | 5.5-9.0  | 50               | 100        | 100       |
| Thailand  | 40               | 5.5-9.0  | 20-60            | 20-60      | 120-400   |
| Global Limit | Below 42      | 6.0 – 9.0 | Below 30        | Below 50   | Below 20  |

5. Dye wastewater treatment

There are several methods that can be used for color removal from industrial dye effluent. But because there are various dyes available and industrial effluent contains other chemicals aside the dye, many treatment methods may not efficient singly and may need to be combined with other treatment method to achieve maximum color removal. Dye wastewater treatment method can be categorized into three namely physical, biological, and chemical treatments [19, 20, 21, 22].

5.1. Physical method of dye removal

Conventional physical method of dye removal includes coagulation-flocculation, adsorption, ion exchange, reverse osmosis, membrane filtration and nano filtration or ultra-filtration. The physical method of treatments is the most used because they and easy to set up and operate and are mostly efficient for color removal.

5.2. Biological method of dye removal

Another cheap and easy to operate alternative for dye removal is the biological method so it is largely used in most countries for dye wastewater treatment. Biological method involves the bacterial degradation of dye by bacteria, fungi, yeast, and algae during aerobic and anaerobic process [23]. However, this method is ineffective because it is unable to removal dye and toxic although it is economically feasible, environmental-friendly, generates less volume of sludge and has the capacity to treat the chemical oxygen demand (COD) in wastewater [19, 24]. Other biological method includes adsorption by microbial biomass, algae degradation, enzyme degradation, fungal cultures, and microbial cultures.

5.3. Chemical method of dye removal

This method involves the application of chemistry theories to achieve dye removal. In comparison to the biological and physical methods, this is not a preferred method by industries because more expensive to setup and operate. It involves high energy consumption and high investments in chemicals and reagents. Part of its disadvantage is the issue of disposal of secondary toxic pollutant produced during the operation of dye removal [19]. This method includes advanced oxidation process, electrochemical destruction, Fenton reaction dye removal, oxidation, ozonation, photochemical and ultraviolet irradiation. Coagulation and flocculation treatment processes have been used to remove color and organic pollutants from dye wastewaters [25, 26]. Low cost adsorbents have been used to remove color from various dye containing wastewaters [27, 28, 29, 30]. One type of low cost adsorbents is agriculturally based adsorbents, which have been employed for decolorization of dye containing combined wastewaters [31, 32].

Table 5 Merits and demerits of dye wastewater treatment methods [8, 11, 12].

| Methods                  | Merits                                      | Demerits                  |
|--------------------------|---------------------------------------------|----------------------------|
| Physical Treatment       |                                             |                            |
| Adsorption by activated carbon | Excellent ability to remove a wide variety of dyes. Adsorbent regeneration | Costly and expensive |
| Ion exchange             | Regeneration prevents loss absorbent. High quality water output | Effective for few numbers of dyes |
**Electrocoagulation**
- Inexpensive and feasible
- Production of large sludge

**Membrane Filtration**
- Effective for all dye type, water recovery and reuse
- Expensive to setup, generate concentrated sludge

**Irradiation**
- Effective and optimized at laboratory scale
- Requires lots of oxygen,

**Reverse osmosis**
- Production of clean water, useful for water recycling and effective for wide variety of dye
- Needs high amount of pressure and expensive

### Biological Treatment

| Treatment Method                  | Dye Conditions and Results                                                                 | (% Removal) |
|-----------------------------------|--------------------------------------------------------------------------------------------|-------------|
| Enzyme degradation.               | It is nontoxic, reusable, and inexpensive and highly efficient                             |             |
| Adsorption by microbial biomass   | Some dyes have high affinity that allows them to bind with microbial biomass               |             |
| Aerobic-anaerobic (conventional)  | Cheap and effective for decolorizing a wide variety of dye                                 |             |
| Microbial cultures (mixed bacterial) | Takes between 24-30 hours to decolorize                                                |             |
|                                   |                                             |             |

### Chemical Treatment

| Treatment Method                  | Dye Conditions and Results                                                                 | (% Removal) |
|-----------------------------------|--------------------------------------------------------------------------------------------|-------------|
| Fenton reaction                   | Removes toxic, good for removal of both soluble and insoluble dyes                           |             |
| Photochemical                     | No sludge and foul production and effective for dye removal                                 |             |
| Oxidation                         | Simple application with short reaction time                                                |             |
| Electrochemical destruction       | No sludge build-up or chemical consumption                                                |             |

### Table 6 Performance of Various Dye Wastewater Treatment Methods

| Treatment Method                  | Dye Conditions and Results                                                                 | (% Removal) |
|-----------------------------------|--------------------------------------------------------------------------------------------|-------------|
| Adsorption by activated carbon    | Maximum dye removal by activated carbon at adsorbent dose of 1 g/L, temperature of 60°C | 98          |
| Adsorption by Fe-based metal-      | Rhodamine B, Congo 23.3855 mg/L of Congo red, 22.7365 mg/L of Orange II and 17.997 mg/L of | 99. 57      |
| Organic frameworks (Fe-MOFs)      | Rhodamine B in 200 mL solution within 300 min of                                            | 95. 9899. 38|
| Method                                             | Treatment Conditions                                                                 | Average Removal Percentage |
|----------------------------------------------------|---------------------------------------------------------------------------------------|----------------------------|
| **Red, Orange II treatment with natural light at 150°C** |                                                                                      | 98.23                      |
| **Ion exchange**                                   |                                                                                      |                            |
| Anion-exchange with sulfonic acid and phosphate groups | Synthetic dye wastewater made up of 0.03 g/L methyl violet 2B and 2 g/L Na2SO4 at pH 3 and 100 °C | 93 (35)                    |
| Anion-exchange by Lewatit MonoPlus MP 500 resin    | The experiment had maximum adsorption capacity at 1004.4 mg/g. 0.5 g anion dosage, contact time is 3 h, dye concentration of 10 mg/L, pH of 5 and temperature of 45 °C. | 87 (36)                    |
| **Average removal percentage 90**                  |                                                                                      |                            |
| **Coagulation/flocculation**                       |                                                                                      |                            |
| Coagulation/flocculation using ferric chloride sludge from water treatment plant | Surface methodology (RSM) was used to optimize initial pH (3.5), coagulant dosage(236.68mg) and initial dye concentration (65.91) for dye | 96.53 (37)                 |
| Coagulation/flocculation using polyaluminum chloride and polydiallyldimethyl ammonium chloride | Dye removal at the optimal dosage of PAC/PDDA=400/200 ppm and pH>3 | 90 (34)                    |
| **Average removal percentage 93.27**               |                                                                                      |                            |
| **Irradiation**                                   |                                                                                      |                            |
| Irradiation by TiO2/H3PW12O40 film Excited under Solar-Like Radiation | Maximum dye removal was achieved when contact time is 240 min, initial dye concentration of 25 mg/L | 89.8 (38)                  |
| Irradiation by periodate ion concentration | Highest TOC removal efficiency obtained at pH 3.0 using 5 mM periodate ion in the presence of 1 g/L TiO2 for both dye solutions in 3 hours illumination | 76 (39)                    |
| **Average removal percentage 82.65**               |                                                                                      |                            |
| **Reverse Osmosis**                               |                                                                                      |                            |
| Reverse osmosis                                    | Dye concentration at 65 mg/L, temperature at 39°C and pressure at 8 bars | 97.2 99.5 98 99.9 (40)     |
| 50 Dalton of reverse osmosis                       | Ideal parameters include a temperature of 35°C contact time of 2 h, a dye concentration of 50 mg/L, a pressure of 7.5 bars, flowrate of 10 L/min and dye concentration of 100 mg/L. | 99.6 98 95 (41)            |
| **Average removal percentage 98.21**               |                                                                                      |                            |
### Biological

#### Enzymatic degradation

| Enzymatic degradation using soybean peroxidase and Luffa acutangula peroxidase | Azo dye methyl orange | Maximum dye decolorization in 1 h incubation at 30 °C using 2 mM of hydrogen peroxide, 0.5 mL crude soybean peroxidase and 30 mg L−1 dye at pH 5.0 and in 40 min at 40 °C using 2 mM hydrogen peroxide, 1.5 mL crude luffa peroxidase and 10 mg L−1 dye at pH 3.0. | 81.475.3 [42] |
| Enzymatic degradation by white rot fungus Datronia sp. KAPI0039 | Reactive blue 19, reactive black 5 | Decolorization of 1000 mg/l reactive Blue 19 at 2% (w/v) Datronia sp. at pH 5 and 600 mg/l reactive Blue | 8688.01 [43] |

Average removal percentage 82.68

#### Adsorption by microbial biomass

| Enterobacter dissolvens AGYP1 and Pseudomonas aeruginosa AGYP2 | Acid Maroon V | Maximum dye removal(absorbance) after 6 hours contact time at dye concentration of 100 mg/l | 96% [1] |
| Low-cost biosorbent (P. animale) | Textile dye | Maximum dye removal (absorbance) at 93.16 mg/L, 45 °C, 1440 minutes contact time and 4 g/L for pH | 99.66 [44] |

Average removal percentage 97.83

#### Aerobic-anaerobic (conventional) method

| Sequential aerobic–anaerobic treatment | Reactive Red 195 | System operated at 0H=18 h, Temperature of 19–22 °C, 3000 mg l−1 initial COD concentration and 100 mg l−1 dyestuff concentration to obtain over 85% decolorization efficiency in anaerobic reactor, 15% color removal and 90% COD removal in aerobic unit | 90 [45] |
| Decolorizing anaerobic/aerobic sequencing batch reactors | Acid Red 88 | The sequential anoxic-aerobic treatment of synthetic dye wastewater (SDW) feed having 100 mg L−1 of AR-88 dye resulted in the 98% color and 95% COD removal. | 98 [46] |

Average removal percentage 89

### Chemical

#### Electrochemical Oxidation

| Pulse electrochemical oxidation for treating recalcitrant dye wastewater | Indigo Carmine, Alizarin Red 5, and | Treated with PbO2/Ti anode and Box-Beinchen designs. This can save energy consumptions up to 35.5%, 40.1%, and 47.9% for IC, ARS, and MO, respectively | 88.4 [47] |
Electrochemical oxidation using Ti/Ru0.3Ti0.7O2 composite anode

| Methyl Orange                  | Acid brown 98                                      |
|--------------------------------|---------------------------------------------------|
| Synthetic wastewater containing 0.1 M NaCl treated at pH 3 and 20 mA cm-2. 67% TOC removal with 0.1 M NaCl as an electrolyte, 20mACm-2 current density, under 60 minutes of electrolysis | 90 [48]                                          |

**Average removal percentage 89.2**

**Fenton reaction**

| Fenton reaction through Fe (II)/H2O2 reagents | Cibacron Red FN-R | 20 mg l−1 Fe (II) reagent and 250 mg l−1 H2O2, applied for irradiation time of 90 min in a 24-h-cycle | 80 [49]       |

| Fenton’s oxidation | Direct Blue 71 | Optimal conditions for the decolorization and COD removal of DB71 at pH = 3.0, Fe2+ = 3 mg l−1, H2O2 = 125 mg l−1, temperature 20-60 °C and 20 min reaction time | 94 50. 7 COD [50] |

**Average removal percentage 87**

6. Hybrid method of dye removal

The textile wastewater contains dye and many other contaminants which are sometimes nonbiodegradable in nature. Exploration of a hybrid system considering the advantage of each process as listed in Table 5 may help achieve maximum efficiency of dye wastewater treatment. Systems that can be combined to give maximum efficient needs to be investigated depending on the nature of the wastewater sample. For example, anaerobic and filtration systems were combined for domestic wastewater treatment. To reduce the space requirement, retention time, investment, operation, and maintenance costs a simple filtration step as a post treatment solution for anaerobic processes is employed. The removal efficiencies of TSS, COD and FC (faecal coliform) for combined system were 93%, 87% and 93%, respectively, against TSS (45%), COD (38%) and FC (78%) removal by UASB (upflow anaerobic sludge blanket) reactor alone.

7. Conclusion

Although there is no uniform standard globally, many countries have put in place strict limit for wastewater discharge and industries can explore both the conventional and new technologies to meet this standard. Moreover, a lot of research has been done on dye wastewater treatment processes individually but more research into the hybridization can help to increase efficiency of treatment. A combination of the adsorption, coagulation-flocculation and the filtration process will efficiency remove color, COD from dye wastewaters.

Compliance with ethical standards

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