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“Present and Future Challenges
in Environmental Sustainability”



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PREFACE

Sustainable development that meets the needs of the present without compromising the ability of future generations to meet their own needs should be implemented in all countries. The implementation is of importance especially with the presence of alarming local to global scale anthropogenic environmental problems and how the countries are connected through the earth's natural system. It is thus imperative that countries collaboratively working together to tackle and prevent the problems in order to warrant the successful implementation of sustainable development in the countries.

It is under the above mentioned spirit that the Environmental Technology and Management Conference (ETMC) was initiated. Held every 4 years since 1997 and with growing numbers of participant and expertise, the ETMC brings together policy makers, scientists, engineers, industries, and field expertise in environmental technology and management to discuss current and future local, regional, and global environmental issues. The ETMC is aimed to provide a forum to discuss and disseminate advances in research, technologies, and management, for improving the quality of the environment. Past participants of the conference include researchers, academic staffs, students, industries, public, and government officials.

With theme “Present and Future Challenges in Environmental Sustainability”, the 4th ETMC is a global momentum for sustainable development that will lead to practical applications of the engineering and science of sustainability. Participating industries, academics, and governmental bodies will acquire information on the state of the art in environmental technology and management.

Plenary sessions of the 4th ETMC include presentations by:

- **Prof. Toshihiro Kitada**
Toyohashi University of Technology, Japan
- **Prof. (Hon) Rachmat Witoelar**
President's Special Envoy for Climate Change Indonesia.

There are invited international distinguished speakers:

- **Prof. Yen Peng Ting**
National University of Singapore, Singapore
- **Prof. Rudy Sayoga**
Institut Teknologi Bandung, Indonesia
- **Prof. Naoyoki Funamizu**
Hokkaido University, Japan
- **Prof. Michael Sturm**
FH Köln, Germany
- **Prof. Kim Oanh**
Asian Institute of Technology, Thailand
- **Prof. Takeshi Fujiwara**
Okayama University, Japan



- **Ir. H. Mulyadi Afmar**
PT. Benefita, Indonesia
- **Moekti Handajani Soejachmoen**
Special Assistant to the President's Special Envoy for Climate Change Indonesia
- **Dr. Setiawan Wangsaatmadja**
Environmental Management Agency of West Java, Indonesia
- **Dr. Indra Budiman Syawmil**
Institut Teknologi Bandung, Indonesia

Contributed oral (114 contributions) and poster (26 contributions) presentations are divided into 6 major sessions:

- A. Eco-industries
- B. Natural Resources Management
- C. Water Resources Management
- D. Environmental Engineering and Technology
- E. Green Cities
- F. Climate Change and Air Pollution

Finally, the Organizing Committee wishes that this conference is able to provide beneficial scientific information to the participants and other concerned readers.

Bandung, November 2011

Ir. Edwan Kardena, PhD
Chair of Organizing Committee



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Preliminary Study of Noble Metal (Gold) Recovery Process from Electronic Waste (E-Waste) Components Conducted by The Informal Sector (Case Study: City of Bandung)

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Abstract Nowadays there are many informal sectors that started recycling business of computer waste which is in the form of used electronic equipment and components that have been damaged. Recycling locations are located in the area of Astana Anyar, Cicaheum, Ahmad Yani, Cileunyi and Banjaran. Recycling is done using the printed circuit board (PCB). On the PCB can be found integrated circuits (IC) containing various metals such as Ag, Au, Cr, Cu, Fe, Mn, Ni, Pb, Sb, and Zn. The main product of this recycling is gold, while the by-products are silver and copper. Gold recycling process is known as a gold smelting process. The stage of the process begins from the separation of IC through burning, milling, smelting, and refining. The materials used in the smelting process are borax, tin and nitric acids while the equipment used are basins, filters, koi, lisum, flat rock and solder. Residues resulting from the smelting process are either simply dumped into drainage channels or potentially recyclable. The waste that can be recycled is the waste in the process of smelting wastes (solid tin slake) by melting it back to get the gold remains and waste from the purification process to obtain silver with the addition of salt and smelting process.

Keywords: informal sector, integrated circuit, recovery

1 Introduction

One of the many types of wastes that is categorized as hazardous wastes is electronic wastes (e-waste). E-wastes generated in Indonesia come from not only domestic usage but also disposals from other countries. Although Indonesia is one of the countries which have ratified Basel Convention about hazardous wastes trans-boundary, in fact the export-import activities of e-product and e-waste still continues illegally.

The attempt of e-waste recycle can also cause problems because of its high risks toward the recycler and its potential of causing poisonous secondary products. Based on preliminary observation of e-waste path flow in Indonesia, the e-waste is not brought directly to the TPA or the centre of 3R, but being reused, recycled, or stripped down (cannibal) in order for their components to be used again ^[1]. The e-waste recycling in Indonesia occur pretty uniquely and the attention focuses on the e-waste product components is very high so that it will increase the life time, in other words, the end-of-life of the e-waste will be longer ^[2].

In addition to hazardous and toxic materials, e-waste also contain various kinds of materials that still have high economic value and have the potential to be recycled. Increasing emergence of e-waste encourage the informal sector to do the processing on that type of waste. However, informal sector activities that are carried out cannot be said legal. There are yet regulations governing the activities undertaken related to the informal sector to process the waste. One of the valuable materials that can be recovered from the e-waste is gold, the precious metal with a very high economic value. Currently, recovery activities are still carried out by the informal sector using conventional processes that may be found in a spontaneous process or unconsciously be a new discovery that has not been published.

In developing countries, including Indonesia, it is most likely that the activities required within processes of precious metal recovery, health and environmental problems are not of concern. Based on initial observations in the field, residues or waste generated from this process is directly discharged into water bodies or dumped in the environment (Damanhuri et al, 2008). One of the wastes generated is an acidic liquid waste in which various kinds of heavy metals are concentrated in it.

2 Methodology

Preliminary Study Of Noble Metal (Gold) Recovery

This research was conducted to obtain a picture recovery process (recycling) which is done conventionally by the melting e-waste within the city of Bandung. In this study the recovery process and the hazards of waste generated in these processes need to be identified so that wastes can be incorporated into the process to recycle more efficiently and environmentally sound. The survey, conducted as a preliminary survey to identify the e-waste recovery processes in terms of economics.

Preparation; Preparations are made prior to this final task, consisting of collecting data and obtaining information from scientific papers or previous studies about e-waste such as data components of e-waste, e-waste collectors and melting e-waste. **Preliminary survey;** Preliminary survey is taking directly findings obtained from both methods of data collection, which are through observations and interviews.

Location of e-waste recycling; Survey is conducted to identify locations estimated that there are business e-waste recycling in the city of Bandung. Based on the information on these locations we can see the number and location of e-waste buster to describe the process of recovery of precious metal (gold) of the components of electronic waste.

Identification recovery process; The Recovery processes is taking the economic value of activities of the components of a computer-waste component with a way to dismantle and then further processed to obtain useful metals like gold, copper, and silver thus become material that has more economic value. Thus the steps of recovery process need to be identified.

Waste and hazard identification; Recovery processes involves chemical reactions, so there is the possibility of residue generated as a result of these chemical reactions. These residues are not considered useful therefore they are disposed of as waste, and other components that still have potential economic values are further recycled. Thus it is necessary to identify the possibilities of recycling residues and handling recommendations. The process of recycling electronic waste is likely to have health implications for both the perpetrators and the communities around the location of smelting because of the use of chemicals in the smelting process which can react with water and air.

Laboratory scale testing; Laboratory-scale testing of precious metal recovery process from electronic waste components is aimed to discover whether there is any stage of the process that is not needed or there is any necessary stage skipped in the process. Laboratory-scale testing was also conducted to determine the ratio of raw materials to the products produced in each phase of the recovery process quantitatively.

Process cost; The Estimated costs of the process of conventionally performed smelting gold from electronic waste components is compared to the estimated costs of melting process in the mining gold. This is done by identifying the components or materials used in each process to determine which process is more economical. Costs incurred in the process of smelting gold from electronic waste component are further calculated through the calculation of cost and benefit.

3 Results and Discussion

A computer processing worker/buster is the person who recycles computer components that still has economic value and deemed appropriate for recycling. The first step to the recycling process is sorting out the components of which were deemed to have economic value; one of these components is IC (Integrated Circuit).

The locations of buster sites are still very difficult to be identified as the place of smelting process is hardly known to the public. Various constraints are often encountered; for instance, some busters whom have successfully been interviewed are reluctant to provide information about the process and sometimes the provided information does not correspond to the facts on the field. Only a few busters that are successfully met and willing to be interviewed by fears and suspicions of the leaking of how the melting process is done. They are also hesitant about what they do because of the awareness that these activities are illegal.

The number of busters successfully interviewed in the survey comes to as many as eight busters. These smelting locations in the city of Bandung consist of three points around the area Astana Anyar, one point located in the surrounding area Cicaheum, three points around the area Ahmad Yani and one point in the surrounding area Banjaran. In general, these agents have a family network so that in the smelting process they are all using the same method.

3.1 Stages of Gold Recovery Process of the Integrated Circuit by Informal Sector

Recovery process is the activity of taking the economic value of the computer-waste component by being dismantled and then further processed to obtain useful metals like gold, copper, and silver in order to become material that has more economic value. The recycling process conducted by informal sector is illustrated in the following diagram:

1) IC separation from PCB

The first preparation is to separate activities of key raw materials required in the process of recovery that was obtained from electronic waste components of IC (integrated circuit). This process is commonly called stripping down process. By the informal sector in the region who do business recovery of precious metal (gold) from waste electronic components, the process of stripping down IC contained in the components of the printed circuit board (PCB) is conducted by the buster by using a simple tool which is ax and conducted without the use of safety equipments such as gloves. This process is performed to obtain the raw materials of pure IC that will be necessary for the next stage. In the first stage of the preparing process Waste A is generated in the form of printed circuit boards.

2) IC combustion

Pure IC which has been obtained is subsequently burned. IC combustion process is performed using the container made of aluminum or zinc. Burning is done by using kerosene fuel or gasoline. The burning process is done approximately in 2-4 hours with a high temperature. The function of burning is to eliminate plastic contained in the IC in order to facilitate the crushing process.

3) IC crushing

IC that has been through the process of combustion is subsequently crushed. The process of crushing is done using Alung/coet and a flat stone. First alung (coet) is used to get the size of IC products to a sandy grain and then filtered using a filter for IC. The residue from the filter is then crushed again, this time using a flat stone to get the IC in the form of powder or fine grains. The function of milling process is to get products crushed. In the milling process waste B is generated in the form of copper.

4) IC Panning

Panning process is the process of getting metal with a large density, such as gold. In order to get products that will be melted, the product is Au, Ag, and other metal impurity. In this washing process the waste generated is waste C in

the form of liquid waste and sludge remaining from the panning process. Results from panning is then added borax.

5) Tin Melting

Solid tin is heated by burning using soldering equipment until become liquid and boiled.

6) Slake Removing

In the smelting process the tin that has been boiled in the form of liquid then mixed with the powder/fine grains from the panning process that has been added borax. Heating is done to melt metals in order for the metals to be mixed. Borax is added to eliminate metal impurities of Au and Ag which is commonly referred to as slake. Meanwhile, tin is used to absorb slake. The tin in this process lowers the melting point so it can accelerate the reaction with a perfect dissolution. The tin, being light in weight, can bring borax oxide to the top phase. In the fusion process, two phases will be formed, which is above and below the lowest phase of gold and silver and a bit of metal impurities. Phase formed on top of solid tin slake and subsequently disposed of little by little. This process is conducted approximately 2-4 hours depending on the number of products and accuracy in the process of smelting. In this melting process waste D is generated in the form of solid tin slake.

Reaction:



7) Gold and silver separation

Once the metals Au + Ag are formed, subsequent purification process is done using HNO₃ solution. The presence of HNO₃ dissolved silver and leaving granules of gold which was then melted again to get the form of solid gold. In this process waste E is generated in the form of acidic effluent waste.

Reaction:



8) Gold metal recovered

In the second smelting process, the result from the purification which is gold grains is then reheated to obtain solid gold with levels around 90%. The main product of the smelting process is a byproduct of gold and copper and silver were produced. The products are usually sold to dealers of metal, gold shops and trash artisans. The price of each metal can be seen in **Table 2**.

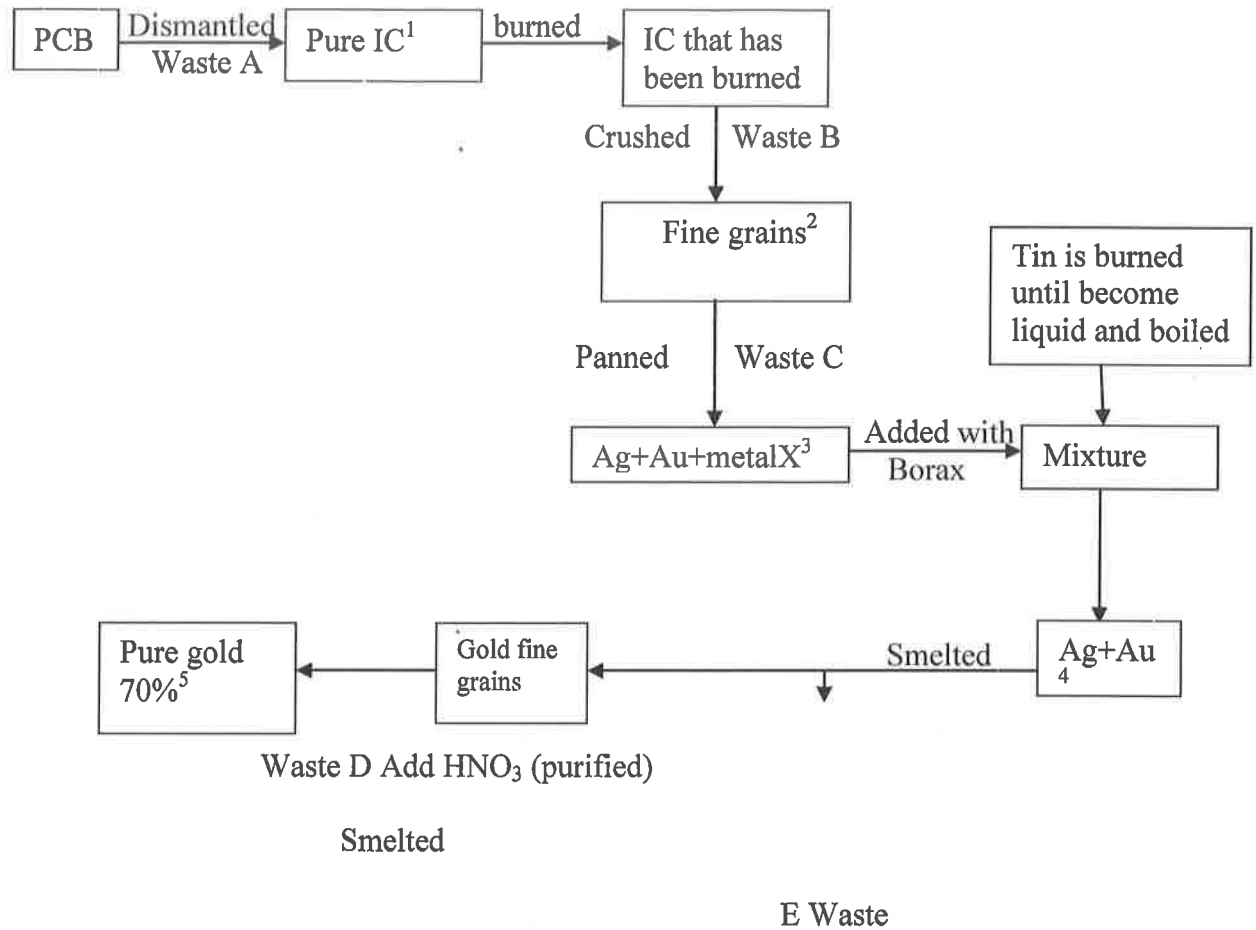


Figure 1 Gold recovery process from *Integrated Circuit* (IC)

Table 1 IC weight in each stage of the recovery process

Stage of Process	Recovered materials (gr)
1	1000
2	650
3	50
4	1,5
5	1

Table 2 Metal Sale Price

Metal	Price (rupiah)
Gold (Au) (per gram)	300,000 – 330,000
Silver (Ag) (per gram)	5,000 – 8,000
Copper (Cu) (per kilogram)	30,000 – 40,000

3.2 Characteristics of Waste Produced from Gold Recovery Process of the Integrated Circuit by Informal sector

In the smelting process carried out by the informal sector produced residues at each stage of the process. In this process five types of waste residues are yielded named wastes A, B, C, D, and E. Wastes are generated in the form of solid waste, wastewater and sediments. Handling of waste generated varies. There are wastes that still has the potential to be further recycled are disposed directly to the nearby drainage channel or river. Comparisons of the field activities is done based on the decision rules KABAPEDAL Number KEP-04/BAPEDAL/09/1995 and Sk.Gub. Jawa Barat No.6 Year 1999.

1) Board Circuit Waste (Waste A)

Waste A generated from the recycling process is in the form of IC circuit board which components have been taken. The waste is dumped near the recycling process and is not sought after for its lack of economic value.

2) Copper Waste (Waste B)

Waste B is in the form of copper pieces remained from the crushing process. Copper waste still has economic value therefore it can still be sold. Usually people who accommodate pieces of copper are scavengers and junkman who then sold them to the dealers of copper smelting.

3) Liquid Crushing Waste and Deposition (Waste C)

Waste C is the residual waste from the panning process. Waste C formed as a liquid waste containing grain remains of IC that is no longer considered useful. Habitually this waste is simply disposed to the drainage or river channel around the site of recycling process. This liquid waste containing sediments also contains heavy metals. The composition of waste C can be seen in **Table 3** and **Table 4**.

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Table 3 Heavy metal content in the liquid waste (Waste C)

No.	Parameter	Unit	Analysis Result	Sk.Gub. Jawa Barat.No.6Th.1999	
			Liquid	Group 1	Group 2
1	Arsen (As)	ppm	0.013	0.1	0.5
2	Barium (Ba)	ppm	0.43	2	3
3	Cadmium (Cd)	ppm	0.128	0.05	0.1
4	Chromium (Cr)	ppm	0.001	0.5	1
5	Copper (Cu)	ppm	62.9	2	3
6	Cobalt (Co)	ppm	2.325	0.4	0.6
7	Lead (Pb)	ppm	137	0.1	1
8	Mercury (Hg)	ppm	0.025	0.002	0.005
9	Molybdenum (Mo)	ppm	0.001	-	-
10	Nickel (Ni)	ppm	17.9	0.2	0.5
11	Tin (Sn)	ppm	0.013	2	3
12	Selenium (Se)	ppm	0.009	0.05	0.5
13	Silver (Si)	ppm	0.001	-	-
14	Zinc (Zn)	ppm	32.9	5	10

Table 4 Heavy metal content in the Deposition of IC crushing waste

No.	Parameter	Unit	Analysis Result	Decision of 04/Bapedal/09/1995	
			Deposition	Max. Content Column A	Max. Content Column B
1	Arsen (As)	mg/kg	4.223	300	30
2	Barium (Ba)	mg/kg	0.104	0	0
3	Cadmium (Cd)	mg/kg	0.012	50	5
4	Chromium (Cr)	mg/kg	0.051	2500	250
5	Copper (Cu)	mg/kg	14.555	1000	100
6	Cobalt (Co)	mg/kg	0.184	500	50
7	Lead (Pb)	mg/kg	16.329	3000	300
8	Mercury (Hg)	mg/kg	0.005	20	2
9	Molybdenum (Mo)	mg/kg	0.000	400	40
10	Nickel (Ni)	mg/kg	2.061	1000	100
11	Tin (Sn)	mg/kg	0.004	500	50
12	Selenium (Se)	mg/kg	0.002	100	10
13	Silver (Si)	mg/kg	0.027	0	0

14	Zinc (Zn)	mg/kg	1.940	5000	500
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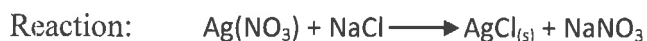
Table 3 shows some of the parameters exceed the stream standards thus they need to be chemically process before discarded. Whereas in the **table 4** wastes in the form of deposits are under grade levels of max A and max B so it can be included in category landfill 3.

4). Solid Tin Slake (Waste D)

There are parties who want to accommodate residues resulting from the smelting process in the form of solid tin slake (tin leftover and metal impurities) as large quantities of this waste can be recycled. For instance, there is still gold in these residues that can be futher recycled.

5). Acid Liquid Waste (Waste E)

Waste E generated from the gold purification process can be further recycled because they still contain silver in the waste. The process to get the silver is being done with the addition of salt as the settling process which then smelted to produce the form of silver metal.



In product AgCl of the reaction is then smelted



Meanwhile, the metal content in the wastewater that is discharged thoroughly to the drainage can be seen **Table 5**.

Table 5 Metal content of purification waste (waste E)

No.	Parameter	Unit	Analysis Result	Sk.Gub. Jawa Barat.No.6Th.1999	
				Group 1	Group 2
1	Arsen (As)	ppm	0.024	0.1	0.5
2	Barium (Ba)	ppm	0.25	2	3
3	Cadmium (Cd)	ppm	0.198	0.05	0.1
4	Chromium (Cr)	ppm	0.694	0.5	1

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5	Copper (Cu)	ppm	65.8	2	3
6	Cobalt (Co)	ppm	0.196	0.4	0.6
7	Lead (Pb)	ppm	32	0.1	1
8	Mercury (Hg)	ppm	0.023	0.002	0.005
9	Molybdenum (Mo)	ppm	0.001	-	-
10	Nickel (Ni)	ppm	2.439	0.2	0.5
11	Tin (Sn)	ppm	0.011	2	3
12	Selenium (Se)	ppm	0.003	0.05	0.5
13	Silver (Si)	ppm	1.058	-	-
14	Zinc (Zn)	ppm	2.97	5	10

In **Table 5**, it can be seen that some of the parameters exceed the stream standards thus they need to be chemically processed before disposal.

3.3 Cost and Benefit

Table 6 Cost of gold Recycling From E-waste

Material	Price per unit (Rp)	Need	Total Cost (Rp)
Pure IC	200,000	1 kg	200,000
Koi	2,500	1 piece	2,500
Borax	40	25 gram	1,000
Timah	1,000	5 piece	5,000
HNO ₃	12,000	1 liter	12,000
Bensin	4,500	1 liter	4,500
Total Cost			225,000

The products resulting from the recycling process consist of 1 kg IC 1 g Gold, Silver 4 g, 300 g Copper with revenues as follows:

Table 7 Provide of Gold Recycling From E-waste

Material	Weight	Total Cost (Rp)
Gold	1 gram	330,000
Silver	4 gram	20,000
Copper	0.3 kg	10,000
Total		350,000

The buster gains Rp 125,000 for every 1 kg IC recycling. Recycling will provide benefit increases if the process is done in large quantities.

3.4 Scale Testing Laboratory

Experiments carried out by two ways:

1. Same with the existing processes of informal sector
2. Replacing heating furnace had been soldered to 990 ° C

Experiments carried out by using the furnace cannot continue because a process that occurs in a state are closed and no air exchange occurs (oxidation-reduction reactions). Laboratory-scale experiments are done qualitatively and quantitatively and compared with the results of the recycling survey conducted by the informal sector. This comparison results can be seen in **Table 8**.

Table 8 IC weight in each stage of the laboratory-scale recovery

Stage of Process	Recovered Materials (gr)
1	500
2	350
3	30
4	0,7
5	0,4

$$\% \text{ recovery} = (0,4 \text{ mg} / 500 \text{ mg}) * 100\% = 0,08\%$$

4 CONCLUSION

The process of e-waste recycling by the informal sector has the potential to be developed, because the gold content and the recovery percentages are good. There are some of the waste from the recycling process which are potential to be further recycled, such as solid tin slake waste and acid liquid waste. Recycling activities conducted by the informal sector is economically feasible but not environmentally soundly. It can be seen from the results of laboratory-scale testing that the quality and quantity of product produced is almost the same as that done by the informal sector.

5 REFERENCES

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