

**EFFECT OF OPERATIONAL PARAMETERS ON  
TREATMENT OF TEXTILE WASTEWATER BY  
ELECTROCOAGULATION PROCESS USING  
DIFFERENT ELECTRODE MATERIALS**

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**2018**

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OF TEXTILE WASTEWATER BY ELECTROCOAGULATION  
PROCESS USING DIFFERENT ELECTRODE MATERIALS**

**by**

**MARWA ALI ELAJEL**

**Thesis Submitted in Fulfilment of the  
Requirements for the Degree of  
Master of Science**

**July 2018**

## **ACKNOWLEDGEMENT**

First of all, all praise to the Almighty Allah for completing this thesis. I am deeply thankful, that this M.Sc. research is finally completed, “Thanks Allah”.

I would like to express my deepest gratitude to my supervisor, Prof. Dr. Ahmad Zuhairi Abdullah for support, valuable advice, patience, guidance and helping me throughout my study.

My sincere appreciation extended to all technical staff and my friends in the School of Chemical Engineering for their assistance and technical advice during experimental work.

I am very grateful to my family for their continuous support and encouragement throughout my study.

## TABLE OF CONTENTS

	<b>Page</b>	
<b>ACKNOWLEDGMENT</b>	ii	
<b>TABLE OF CONTENTS</b>	iii	
<b>LIST OF TABLES</b>	ix	
<b>LIST OF FIGURES</b>	x	
<b>LIST OF PLATES</b>	xiii	
<b>LIST OF ABBREVIATIONS</b>	xiv	
<b>LIST OF SYMBOLS</b>	xvi	
<b>ABSTRAK</b>	xviii	
<b>ABSTRACT</b>	xx	
<b>CHAPTER ONE: INTRODUCTION</b>		
1.1	Problems of Textile Effluent	1
1.2	Treatment of Textile Wastewater	4
1.3	Problem Statement	6
1.4	Research Objectives	9
1.5	Scopes of the Study	10
1.6	Thesis Organization	11
<b>CHAPTER TWO: LITERATURE REVIEW</b>		
2.1	Textile Industry	12
2.2	Textile Dyeing and Printing Process	14
2.3	Dyes used in Textile industry	15
	2.3.1 Reactive Dyes	16
2.4	Textile Wastewater problems	18
	2.4.1 Colors in Textile Wastewater	18
	2.4.2 Dissolved solids in Textile Wastewater	18
	2.4.3 Toxic Metals in Textile Wastewater	19

2.4.4	Residual Chlorine in Textile Wastewater	19
2.4.5	Other Pollutants	19
2.5	Characteristics of Textile Wastewater	20
2.6	Characteristics of Wastewater from Reactive Dyeing Process	20
2.7	Wastewater Treatment Techniques	21
2.8	Electrocoagulation	24
2.8.1	Advantages of the EC Process	27
2.8.2	Concept in the EC process	27
2.8.2(a)	Mechanism of the EC process	28
2.8.2(b)	Electrochemical Reactions at Electrodes	29
2.9	Operating Parameters Affecting the EC Process	33
2.9.1	Electrodes	33
2.9.1(a)	Electrodes Material	33
2.9.1(b)	Electrode Connection Mode	35
2.9.1(c)	Distance between Electrodes	36
2.9.1(d)	Number of Electrodes	37
2.9.2	Initial pH of the Solution	38
2.9.3	Current Density	42
2.9.4	Initial Dye Concentration	43
2.9.5	Stirring Speed	44
2.9.6	Electrical Conductivity	45
2.9.7	Operating Time	45
2.9.8	Temperature of the Solution	46
2.10	Problems with Using Aluminum in Treating of Real Textile Wastewater	47

2.10.1	High Corrosion Rate of Aluminum Electrode	47
2.10.2	Reducing Removal Efficiency of Aluminum Electrode	48
2.11	Improvement of the EC Process for Treatment of Real Textile Wastewater Using Alternative Electrode Materials	50
2.12	Knowledge Gap	51
 <b>CHAPTER THREE: MATERIALS AND METHODS</b>		
3.1	Materials	55
3.1.1	Chemicals and Reagents	55
3.1.2	Reactive Blue 261 Dye	55
3.1.3	Equipment	56
3.2	Wastewater Sample	56
3.2.1	Synthetic Textile Wastewater	56
3.2.2	Real Textile Wastewater (effluent)	57
3.3	Experimental Set-up	57
3.4	Experimental procedure	59
3.5	Dye Removal of Reactive Blue 261 Dye Using EC Process under Various Operating Parameters	60
3.5.1	Effect of Electrode Material	60
3.5.2	Effect of Current Density on Dye Removal	61
3.5.3	Effect of Initial pH of Wastewater Sample	62
3.5.4	Effect of Initial Concentration of the Dye	62
3.5.5	Effect of Operating Time	62
3.6	Analysis of Treated Sample	63
3.6.1	Measurement of Dye Concentration	63
3.6.1(a)	Synthetic Textile Wastewater	63

3.6.1(b)	Real Textile Wastewater	63
3.6.2	Measurement of Chemical Oxygen Demand	64
3.6.3	Measurement of Turbidity	64
3.6.4	Electrode Consumption (Weight loss test)	65
3.6.5	Electrical Energy Consumption	66
3.7	Characterization of Electrode Surface using Scanning Electron Microscope (SEM)	66

## **CHAPTER FOUR: RESULTS AND DISCUSSION**

4.1	Characteristics of Textile Wastewater	68
4.2	Treatment of Synthetic Textile Wastewater by EC Process (Preliminary Study)	68
4.2.1	Aluminum Electrode	69
4.2.1(a)	Effect of Current Density on Dye Removal of Synthetic Textile Wastewater Using Aluminum Electrode	69
4.2.1(b)	Effect of Initial pH on Dye Removal Efficiency of Synthetic Textile Wastewater Using Aluminum Electrode	70
4.2.1(c)	Effect of Initial Dye Concentration on Dye Removal Efficiency of Synthetic Textile Wastewater Using Aluminum Electrode	73
4.2.2	Stainless Steel Electrode	74
4.2.2(a)	Effect of Current Density on Dye Removal Efficiency of Synthetic Textile Wastewater Using Stainless Steel Electrode	74
4.2.2(b)	Effect of Initial pH on Dye Removal Efficiency of Synthetic Textile Wastewater Using Stainless Steel Electrode	75
4.2.2(c)	Effect of Initial Dye Concentration on Dye Removal Efficiency of Synthetic Textile Wastewater Using Stainless Steel Electrode	77
4.2.3	Zinc Electrode	79

4.2.3(a)	Effect of Current Density on Dye Removal Efficiency of Synthetic Textile Wastewater Using Zinc Electrode	79
4.2.3(b)	Effect of Initial pH on Dye Removal Efficiency of Synthetic Textile Wastewater Using Zinc Electrode	80
4.2.3(c)	Effect of Initial Dye Concentration on Dye Removal Efficiency of Synthetic Textile Wastewater Using Zinc Electrode	81
4.3	The Best Operating Conditions for Treatment of Synthetic Textile Wastewater	83
4.4	Complete Investigation of Treated Synthetic Textile Wastewater (Dye Removal, COD and Turbidity Removal, Electrode Weight Loss and Energy Consumption)	84
4.4.1	Dye Removal, COD and Turbidity Removal Efficiencies of Synthetic Textile Wastewater Using Aluminum Electrode	85
4.4.2	Dye Removal, COD and Turbidity Removal Efficiencies of Synthetic Textile Wastewater Using Stainless Steel Electrode	87
4.4.3	Dye Removal, COD and Turbidity Removal Efficiencies of Synthetic Textile Wastewater Using Zinc Electrode	88
4.4.4	Energy Consumption during Treatment of Synthetic Textile Wastewater	90
4.4.5	Electrode Weight Loss Calculations during Treatment of Synthetic Textile Wastewater	92
4.5	Treatment of Real Textile Wastewater by EC Process	93
4.5.1	Dye Removal, COD and Turbidity Removal Efficiencies of Real Textile Wastewater Using Different Electrode Materials	94
4.5.2	Energy Consumption during Treatment of Real Textile Wastewater	98
4.5.3	Electrode Weight Loss Calculations during Treatment of Real Textile Wastewater	99



4.5.4	Comparison between Electrode Materials for Treatment of Real Textile Wastewater in Terms of Dye Removal, Energy Consumption and Electrode Weight Loss	102
4.6	Characterization of Electrode Surface by using Scanning Electron Microscopy (SEM)	103
4.7	Comparisons between Treatment of Synthetic and Real Textile Wastewater Using Different Electrode Materials	105
4.8	Operating Cost Estimate for Treatment of Textile Wastewater Using EC Process with Different Electrode Materials	106

## **CHAPTER FIVE: CONCLUSIONS AND RECOMMENDATION**

5.1	Conclusions	108
5.2	Recommendations	111

<b>REFERENCES</b>		112
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## **APPENDICES**

Appendix A:	Calibration curve for reactive blue 261 dye
Appendix B:	Results of dye removal, COD and turbidity removal efficiencies of synthetic textile wastewater under the best operating conditions (pH =7) using aluminum electrode
Appendix C:	Results of dye removal, COD and turbidity removal efficiencies of real textile wastewater under the best operating conditions (pH of real textile wastewater was adjusted from 9 to 7) using aluminum electrode
Appendix D:	Electrode weight loss and energy consumption during EC process for treatment of textile wastewater under the best operating conditions (pH =7) using aluminum electrode
Appendix E:	Cost estimation for treatment of real textile wastewater using the EC process under the best operating conditions (pH of real textile wastewater was adjusted from 9 to 7) using aluminum electrode

## **LIST OF PUBLICATIONS**

## LIST OF TABLES

		<b>Page</b>
Table 1.1	Typical characteristics of a real textile wastewater from dyeing process	7
Table 2.1	Chemicals used in various stages of textile manufacturing process	14
Table 2.2	A common dyestuff used in dyeing of fibers	15
Table 2.3	A common reactive dye groups	17
Table 2.4	Pollutants at various textile processes	20
Table 2.5	Methods used for wastewater treatment	24
Table 2.6	Studies on treatment of textile wastewater containing reactive dyes	26
Table 3.1	List of Chemicals and Reagents	55
Table 3.2	Physical and Chemical Properties of Reactive Blue 261 Dye	55
Table 3.3	List of Equipment and Apparatus	56
Table 4.1	Characteristics of Real Textile Wastewater	68
Table 4.2	The best operating conditions for each electrode material	83
Table 4.3	Weight loss of electrodes during the EC treatment of synthetic textile wastewater under the best operating time of 10 min	92
Table 4.4	Dye removal, COD and turbidity removal for each electrode material	94
Table 4.5	Malaysia regulations for discharge wastewater	98
Table 4.6	Comparison between electrode materials	102
Table 4.7	Cost estimation for treatment of real textile wastewater using the EC process under the best operating conditions	107

## LIST OF FIGURES

		<b>Page</b>
Figure 1.1	Characterization of textile effluent at various stages of textile manufacturing Process	2
Figure 1.2	Electro-coagulation/flotation process for wastewater treatment	5
Figure 2.1	Flow diagram of cotton processing stages	13
Figure 2.2	Electrocoagulation mechanism	29
Figure 2.3	Electrode mode connection a) monopolar and b) bipolar mode	36
Figure 2.4	Aluminum solubility diagram	39
Figure 2.5	Iron solubility diagram	40
Figure 2.6	Predominance-zone diagrams for Fe(III) chemical species in aqueous solution	40
Figure 2.7	Zinc purbaix diagram	41
Figure 2.8	SEM micrograph of typical surface morphology of aluminum cathode after EC process	48
Figure 3.1	Overall Research Methodology Flow Chart	54
Figure 3.2	Sketch of experimental set-up used for treating textile wastewater	58
Figure 4.1	Dye removal of synthetic textile wastewater at various current density using aluminum electrode (pH = 6.8, concentration = 50 mg/L and time = 60 min)	70
Figure 4.2	Dye removal of synthetic textile wastewater at different pH using aluminum electrode (current density = 4 mA/cm <sup>2</sup> , concentration = 50 mg/L and time = 60 min)	72
Figure 4.3	Dye removal of synthetic textile wastewater at various concentrations using aluminum electrode (current density = 4 mA/cm <sup>2</sup> , pH = 7 and time = 60 min)	73
Figure 4.4	Dye removal of synthetic textile wastewater at various current density using stainless steel electrode (pH = 6.8, concentration = 50 mg/L and time = 60 min)	75

Figure 4.5	Dye removal of synthetic textile wastewater at different pH using stainless steel electrode (current density = 4 mA/cm <sup>2</sup> , concentration = 50 mg/L and time = 60 min)	76
Figure 4.6	Dye removal of synthetic textile wastewater at various concentrations using stainless steel electrode (current density = 4 mA/cm <sup>2</sup> , pH = 9 and time = 60 min)	78
Figure 4.7	Dye removal of synthetic textile wastewater at various current density using zinc electrode (pH = 6.8, concentration = 50 mg/L and time = 60 min)	80
Figure 4.8	Dye removal of synthetic textile wastewater at different pH using zinc electrode (current density = 4 mA/cm <sup>2</sup> , concentration = 50 mg/L and time = 60 min)	81
Figure 4.9	Dye removal of synthetic textile wastewater at various concentration using zinc electrode (current density = 4 mA/cm <sup>2</sup> , pH = 9 and time = 60 min)	82
Figure 4.10	Dye removal, COD and turbidity removals of synthetic textile wastewater using aluminum electrode under operating conditions (current density = 4 mA/cm <sup>2</sup> , initial pH = 7, initial dye concentration 50 mg/L and time = 60 min)	85
Figure 4.11	Dye removal, COD and turbidity removals of synthetic textile wastewater using stainless steel electrode under operating conditions (current density = 4 mA/cm <sup>2</sup> , initial pH = 9, initial dye concentration = 100 mg/L and time = 60 min)	87
Figure 4.12	Dye removal, COD and turbidity removals of synthetic textile wastewater using zinc electrode under operating conditions (current density = 4 mA/cm <sup>2</sup> , initial pH = 9, initial dye concentration = 100 mg/L and time = 60 min)	89
Figure 4.13	Energy consumption during the treatment of synthetic textile wastewater using aluminum, stainless steel and zinc electrodes under the best of current density and initial dye concentration and at initial pH of 9 for each electrode (time = 10 min)	91
Figure 4.14	Weight loss during the treatment of synthetic textile wastewater using aluminum, stainless steel and zinc electrodes under the best of current density and initial dye concentration and at pH of 9 for each electrode (time = 10 min)	93

Figure 4.15	Dye removal, COD and turbidity removals of real textile wastewater using aluminum electrode under operating conditions (current density = 4 mA/cm <sup>2</sup> , initial pH = 9, initial dye concentration = 50 mg/L and time = 60 min)	95
Figure 4.16	Dye removal, COD and turbidity removals of real textile wastewater using stainless steel electrode under operating conditions (current density = 4 mA/cm <sup>2</sup> , initial pH = 9, initial dye concentration = 100 mg/L and time = 60 min)	96
Figure 4.17	Dye removal, COD and turbidity removals of real textile wastewater using zinc electrode under operating conditions (current density = 4 mA/cm <sup>2</sup> , initial pH = 9, initial dye concentration = 100 mg/L and time = 60 min)	97
Figure 4.18	Energy consumption during the treatment of real textile wastewater using aluminum, stainless steel and zinc electrodes under the best of current density and initial dye concentration and at initial pH of 9 for each electrode (time = 10 min)	99
Figure 4.19	Weight loss during the treatment of real textile wastewater using aluminum, stainless steel and zinc electrodes under the best of current density and initial dye concentration and at initial pH of 9 for each electrode (time = 10 min)	100
Figure 4.20	SEM micrograph of aluminum cathode surface after treatment of real textile wastewater under the best of current density and initial dye concentration and at pH of 9 (time = 10 min)	101
Figure 4.21	SEM images for aluminum anode (a) and (b) before and after the treatment respectively, zinc anode (c) and (d) before and after the treatment respectively and stainless steel anode (e) and (f) before and after the treatment respectively	104
Figure 4.22	Comparisons between treatment of synthetic and real textile wastewater using aluminum, stainless steel and zinc electrodes under the best of current density and initial dye concentration and at initial pH of 9 for each electrode (time = 10 min)	106

## LIST OF PLATES

		<b>Page</b>
Plate 3.1	Photo of experimental set-up used in this study	59
Plate 4.1	Change in the color during the EC treatment of synthetic textile wastewater using aluminum electrode	86
Plate 4.2	Change in the color during the EC treatment of synthetic textile wastewater using stainless steel electrode	88
Plate 4.3	Change in the color during the EC treatment of synthetic textile wastewater using zinc electrode	89

## LIST OF ABBREVIATIONS

Abs	Absorbance of wastewater after treatment at time t (min)
Abs <sub>0</sub>	Initial absorbance of wastewater
Al	Aluminum
Al <sup>3+</sup>	Aluminum ions
ANOVA	Analysis of variance
BOD	Biochemical oxygen demand
CCD	Central composite design
CD	Current density
CO <sub>2</sub>	Carbon dioxide
COD	Chemical oxygen demand
DC	Direct current
EC	Electrocoagulation
Fe	Iron
Fe (OH) <sub>2</sub>	Ferrous hydroxide
Fe (OH) <sub>3</sub>	Ferric hydroxide
Fe <sup>2+</sup>	Ferrous ions
Fe <sup>3+</sup>	Ferric ions
H <sub>2</sub> O	Water
H <sub>2</sub> O <sub>2</sub>	Hydrogen peroxide
H <sub>2</sub> SO <sub>4</sub>	Sulfuric acid
HCl	Hydrochloric acid
MYR	Malaysian Ringgit
NaCl	Sodium chloride

NaOH	Sodium hydroxide
NTU	Nephelometric turbidity unit
O <sub>2</sub>	Oxygen
OFAT	One- factor- at-a time
OH <sup>-</sup>	Hydroxide ions
RPM	Revolutions per minute
SEM	Scanning Electronic Microscopy
SS	Suspended solids
SS	Stainless steel
TDS	Total dissolved solids
USEPA	United State Environmental Protection Agency
UV-Vis	Visible and Ultraviolet Spectrophotometer
Zn	Zinc
Zn(OH) <sub>2</sub>	Zinc hydroxide
Zn <sup>2+</sup>	Zinc ions



## LIST OF SYMBOLS

Symbol	Description	Unit
$\lambda$	Wavelength	nm
E	Amount of energy consumed during EC process	KWh
M	Anode material	
I	Applied current	mA
C	Final concentration of dye	mg/L
cm	Centimeter	
$C_o$	Initial concentration of dye	mg/L
$^{\circ}\text{C}$	Degree celsius	
Q	Electric charge passed through the electrode material	coulomb
$e^-$	Electron	
F	Faraday constant	C mole <sup>-1</sup>
kwh	Kilowatt	
L	Liter	
$\Delta m$	Mass of the substance liberated at an electrode surface	gram
m	Meter	
mA	Milliampere	
mg	Milligram	
mm	Millimeter	
$\text{ms}^{-1}$	Millisiemens	
M	Molar mass of the substance	
nm	Nanometer	

n	Number	
Z	Number of electrons transferred during the anodic reaction	
U	Operating voltage	Volt
ppm	Part per million	
T	Temperature	°C
A	The submerged effective surface area of anodes	cm <sup>2</sup>
t	Time	min
Y <sub>o</sub>	Turbidity value of the sample before treatment	NTU
Y	Turbidity value of treated sample	NTU
%ΔW	% Weight loss of electrode material	
W <sub>2</sub>	Weight of the electrode after EC treatment	gram
W <sub>1</sub>	Weight of the electrode before EC treatment	gram

**KESAN PARAMETER OPERASI KE ATAS RAWATAN AIR SISA TEKSTIL  
MENERUSI PROSES ELEKTRO PENGGUMPALAN MENGGUNAKAN  
BAHAN ELEKTROD YANG BERBEZA**

**ABSTRAK**

Proses elektro penggumpalan telah digunakan untuk mengatasi masalah yang dihadapi oleh proses fiziko kimia konvensional dalam rawatan air sisa tekstil. Air sisa tekstil sebenar mengandungi pencelup reaktif selalunya bersifat alkali. Bahan-bahan elektrod yang berbeza seperti zink dan keluli tahan karat boleh digunakan bagi mengatasi prestasi lemah elektrod aluminium dalam medium beralkali untuk rawatan air sisa tekstil sebenar. Prestasi proses elektro penggumpalan untuk rawatan air sisa tekstil sintetik (disediakan menggunakan pencelup biru reaktif 261) dan air buangan tekstil sebenar telah disiasat. Tiga jenis bahan elektrod iaitu aluminium, zink dan keluli tahan karat telah digunakan dalam kajian ini. Parameter operasi terlibat dalam kajian ini ialah ketumpatan arus ( $2-8 \text{ mA/cm}^2$ ), kepekatan pewarna awal ( $20-100 \text{ mg/L}$ ) dan nilai pH awal ( $5-9$ ). Kajian permulaan telah dijalankan menggunakan air buangan tekstil sintetik untuk menentukan keadaan operasi optimum yang memberikan penyingkiran pencelup yang tinggi untuk setiap bahan elektrod. Keadaan-keadaan optimum yang diperolehi ialah ketumpatan arus ( $4 \text{ mA/cm}^2$  untuk semua elektrod-elektrod), kepekatan awal pencelup ( $50 \text{ mg/L}$  untuk elektrod aluminium dan  $100 \text{ mg/L}$  untuk elektrod zink dan keluli tahan karat) dan nilai awal pH ( $7$  untuk elektrod aluminium dan  $9$  untuk elektrod zink dan keluli tahan karat). Satu penyiasatan yang menyeluruh dari segi penyingkiran pencelup, COD, kekeruhan, kehilangan berat elektrod, dan penggunaan tenaga dijalankan di bawah keadaan optimum (ketumpatan arus dan kepekatan pewarna yang awal) manakala nilai pH awal telah ditetapkan pada

9 bagi mewakili keadaan air sisa tekstil sebenar yang digunakan dalam kajian ini. Penyingkiran pencelup, kehilangan berat elektrod, dan penggunaan kuasa telah direkodkan sebagai 99.8%, 0.66 kWh/m<sup>3</sup> dan 0.039% untuk elektrod zink, 99.1%, 0.70 kWh/m<sup>3</sup> dan 0.066% untuk elektrod keluli tahan karat dan 75.8%, 0.50 kWh/m<sup>3</sup> dan 0.41% untuk elektrod aluminium masing-masing. Rawatan air sisa tekstil yang sebenar di bawah keadaan operasi optimum (ketumpatan arus dan kepekatan pewarna yang awal) dan pada nilai pH semula jadi air sisa tekstil menunjukkan bahawa elektrod zink memberikan penyingkiran pencelup yang tertinggi (83.7%), kehilangan berat elektrod yang terendah (0.043%) dan penggunaan tenaga yang munasabah (0.69 kWh/m<sup>3</sup>). Kos operasi duga dianggarkan lebih rendah untuk elektrod zink (MYR 3.93 setiap 1 m<sup>3</sup> air sisa terawat tekstil selama 10 minit) berbanding dengan elektrod aluminium dan keluli tahan karat. Oleh itu, elektrod zink dianggap sebagai bahan elektrod paling berkesan untuk rawatan air sisa tekstil yang mengandungi pencelup reaktif.

# **EFFECT OF OPERATIONAL PARAMETERS ON TREATMENT OF TEXTILE WASTEWATER BY ELECTROCOAGULATION PROCESS USING DIFFERENT ELECTRODE MATERIALS**

## **ABSTRACT**

Electrocoagulation process (EC) has been used to overcome the problems related to the use of conventional physico-chemical process in treatment of textile wastewater. Real textile wastewaters containing reactive dyes are often characterized by their alkalinity. Different electrode materials such as zinc and stainless steel could be used to tackle the low performance of aluminum electrode in alkaline medium for treatment of a real textile wastewater. The performance of electrocoagulation process for treatment of a synthetic textile wastewater (prepared using reactive blue 261 dye) and a real textile wastewater was investigated. Three types of electrode material namely aluminum, zinc and stainless steel were used in this study. The operating parameters involved in this study were current density (2-8 mA/cm<sup>2</sup>), initial dye concentration (20-100 mg/L) and initial pH (5-9). The preliminary study was conducted using synthetic textile wastewater to determine the best operating conditions that would lead to high dye removal for each electrode material. The best conditions were current density (4 mA/cm<sup>2</sup> for all electrodes), initial dye concentration (50 mg/L for aluminum electrode and 100 mg/L for zinc and stainless steel electrode) and initial pH (7 for aluminum electrode and 9 for zinc and stainless steel electrode). A thorough investigation in terms of dye removal, COD, turbidity, energy consumption and electrode weight loss was conducted under the best conditions (current density and initial dye concentration) while the initial pH value was kept at 9 to represent the real textile wastewater condition as used in this study. Dye removal,

power consumption and electrode weight loss were found at 99.8%, 0.66 kWh/m<sup>3</sup> and 0.039% for zinc electrode, 99.1%, 0.70 kWh/m<sup>3</sup> and 0.066% for stainless steel electrode and 75.8%, 0.50 kWh/m<sup>3</sup> and 0.41% for aluminum electrode, respectively. The treated real textile wastewater under the best operating conditions (current density and initial dye concentration) and at original pH of textile wastewater demonstrated that zinc electrode showed the highest dye removal (83.7%), lowest electrode weight loss (0.043%) and reasonable energy consumption (0.69 kWh/m<sup>3</sup>). The estimated operating cost of the EC process was lower for zinc electrode (MYR 3.9 per 1 m<sup>3</sup> of treated textile wastewater for 10 minutes) compared with aluminum and stainless steel electrodes. Thus, zinc electrode could be an effective electrode material for treatment of textile wastewater containing reactive dye.

## **CHAPTER ONE**

### **INTRODUCTION**

Water pollution is a major environmental problem due to its effects on human life, plants, organisms and other life forms. The problem occurs when wastes are directly or indirectly discharged into waterways (lakes, river, sea, ocean and groundwater) without necessary treatment. The Malaysia Environment Quality Report (2006-2010) indicated that 203 of rivers were slight polluted while 74 rivers were completely polluted in the year 2010. This was due to the increasing number of manufacturing factories as well as high waste dumping from housing and farming areas (Pang and Abdullah, 2013). Industrial sector remains the main source of water pollution due to its high discharge quantity and diversities. Several industries (textile, paper, leather, food and pharmaceutical industries) generate wastewaters containing dyes, which are considered serious environmental pollutants. This study is focused on the treatment of wastewaters produced by textile industry.

#### **1.1 Problems of Textile Effluent**

Textile industry is one of the industries that generate large amount of wastewater that presents a significant environmental pollution problem. It usually has high level of pollutants as characterized by high chemical oxygen demand (COD), high suspended solid, strong color, and high biotoxicity. In general, Figure 1.1 summarizes the main characterization of textile effluent at various stages of textile manufacturing process (cotton based textile production processes). Each textile factory has its own manufacturing and treatment processes which are different from another.

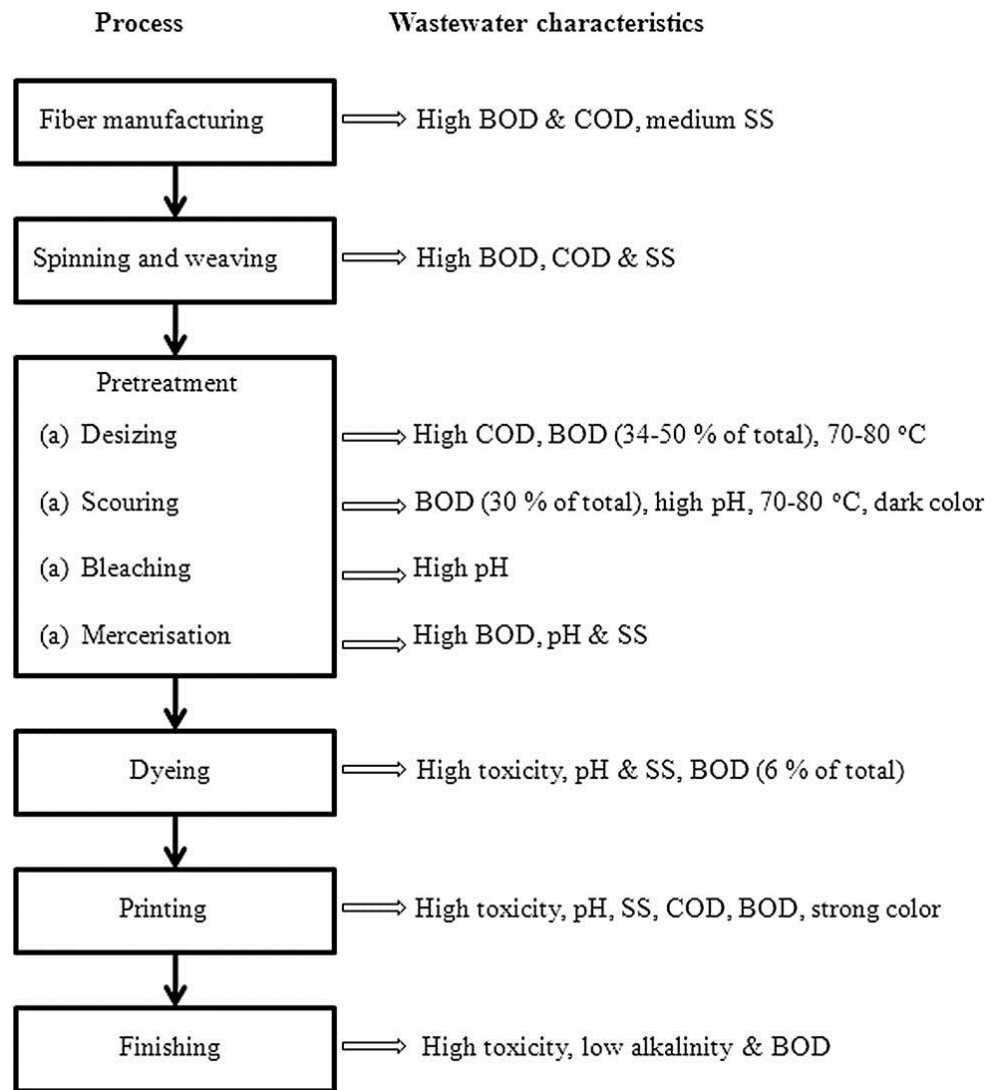


Figure 1.1: Characterization of textile effluent at various stages of textile manufacturing process (Pang and Abdullah, 2013).

Textile industry utilizes 10,000 types of pigments and dyes and many of them are toxic to human and the environment (Essadki et al., 2008). Textile effluents do not only impart color to water ways but also cause environmental damage to living organisms by stopping the reoxyenation capacity of water as well as blocking sunlight, thereby, disturbing the natural growth activity of aquatic life (Rahtinam et al., 2015).

Textile industry uses chemicals and dyes in various fabrication processes (dyeing and finishing process) where large portion of these dyes (up to 50%) is lost in wastewater. Most of pollution problems caused by textile industry have been reported