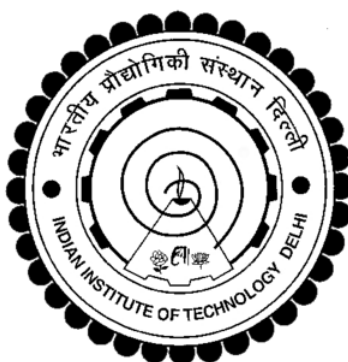


MULTI-CRITERIA FRAMEWORK FOR REMEDIATION OF CHROMITE ORE PROCESSING RESIDUE (COPR) OVERBURDEN AT CONTAMINATED SITES

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MAY 2024

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CHROMITE ORE PROCESSING RESIDUE (COPR)
OVERBURDEN AT CONTAMINATED SITES**

by

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Submitted

In the fulfilment of the requirements of the degree of Doctor of Philosophy

to the



INDIAN INSTITUTE OF TECHNOLOGY DELHI

MAY 2024

Dedicated to my parents and to
all the people who supported me
throughout my education.

कर्मण्येवाधिकारस्ते मा फलेषु कदाचन।
मा कर्मफलहेतुर्भूर्मा ते सङ्गोऽस्त्वकर्मणि॥
(Bhagavad Gita, Chapter 2, Verse: 47)

CERTIFICATE

This is to certify that the thesis entitled “**Multi-Criteria Framework for Remediation of Chromite Ore Processing Residue (COPR) Overburden at Contaminated Sites**” is being submitted by **Mr. Gummadivalli Shiva Kumar** to the **Indian Institute of Technology Delhi** for the award of the degree of ‘**Doctor of Philosophy**’ in Department of Civil Engineering and is a record of the bonafide research work carried out by him under my supervision. He has fulfilled the requirements of the Indian Institute of Technology Delhi for the submission of this thesis, which to the best of my knowledge has reached the requisite standard.

The research material and results contained in the thesis have not been submitted in part or full to any other University or Institute for the award of any other degree or diploma.

(Prof. Arvind K. Nema)

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ACKNOWLEDGEMENTS

The journey undertaken to build this thesis has been onerous, yet a majestic one. A Ph.D. thesis is never ‘completed in full’ only by one single individual, as it demands constructive perseverance and beneficial input from many. The success of this endeavor owes much to the invaluable support by a remarkable group of individuals, who will remain significant in my heart and life. This is a declaration of appreciation to everyone who provided me the succor during this undertaking.

I feel honored and grateful for the continual support and scholarly counsel provided to me by my respected supervisor, Prof. Arvind K. Nema. His thoughtful perceptions and persistent backing guided me on the right road throughout this thesis and sculpted me as a researcher. I owe him a profound thanks for the numerous insightful discussions, brainstorming sessions, and constructive criticism that have helped me refine my ideas and methodology. I would like to credit him for providing a conducive research environment and resources that have been crucial for the successful completion of this work. I express my deepest gratitude for teaching the importance of systematic thinking, decision-making skills, and the habit of meeting deadlines. I am truly indebted to him for believing in my potential, pushing me to overcome challenges, and inspiring me to pursue excellence. I am privileged to have had the opportunity to work under his expert supervision, and I will forever be appreciative of his contributions to my academic and professional growth.

My sincerest thanks and admiration to the members of my student research committee, Prof. D. R. Kaushal (Chairman), Prof. Manoj Datta (Expert from the Civil Engineering Department), and Prof. Kamal K. Pant (Expert from outside the Department) for purveying me with the best reviews and comments at every stage of my research. Their constructive inputs and utilitarian feedback helped in shaping the direction of this thesis and ensuring its academic quality. A special note of gratitude to Prof. B J Alappat, Prof. Sovik Das, and Prof. Sri Harsha Kota for patiently discussing various academic projects and research problems. I would like to thank the teachers and management of the Department of Civil Engineering, IITD for their support and assistance throughout my tenure.

I am thankful to Dr. Sanjay Kumar Gupta (Environment Engineering Lab, IITD) for his constant encouragement and professional support in facilitating the successful execution of the experimental studies. My sincere appreciation lies with Mr. Rajiv Sharma (Surveying Lab, IITD) for his steady support in providing a pleasant work environment. I appreciate the help provided by

Ms. Debasmita Mallik and Mr. Deepak Singh (Environment Engineering Lab, IITD). I am thankful to the Central Research Facility (CRF-IITD) for their help in sample analysis.

I take this opportunity to thank my closest friend group at IIT Delhi (Mr. Khammametti Venkatesh, Mrs. Pratibha Anand, Mr. Yalavarthi Amarnath, Mr. Kangari Narender Reddy, Mr. Aqueeb Sohail Shaik, and Mr. Dhulipala Eswar). Their presence has been invaluable throughout my Ph.D. journey, uplifting me during the toughest times. I reserve a thanks to my friend, Dr. Aparna Sharma for her immense help with my PhD work. I would like to call out to my lab mates and good friends (Dr. Komal Shukla, Dr. Shubham Sharma, Mr. Sasi Kumar N, Dr. Mohit Somani, Mr. Abhishek Narayana Shrivastava, Mr. Gandham Phani Kumar, Ms. Thirunagari Baby Keerthi, Mr. Parmar Pareshbhai Dineshbhai, Mrs. Archana Chawla), without whom PhD life would not have been easy for me here. Special mention goes to Mr. Durga Prasad Tripathi for his positive motivation as well as for accompanying me to the sampling sites. I am glad for all the support from various research scholars working with Prof. Nema (Mrs. Sheelu Verghese, Mrs. Chaitra Devoor, Mr. Maneesh Jaiswal, and Mrs. Kharishma Bhatnagar). I extend my thanks to all my friends (Dr. Sumanth Chinthala, Mr. Arpit Katiyar, Mrs. Swati Rani, Dr. Tanushree Parsai, Mr. Sachin Dhawan, Mr. Vishwanath Velamuri, Mr. Saif Khan, Ms. Garima Gupta, Mr. Akshay Kumar Tamrakar, Mr. Diljit Nayak, Dr. Shraddha Shahane, Ms. Samriddhi Rana, Mr. Tribhuvan Singh Bisht, and Ms. Jagriti Suneja) for their assistance and best wishes. I remind my close friends (Mr. D Uday Kumar, Mr. V Sai Teja, Mr. Juwel Bharadwaj, Mrs. Nivedita Nayak, Mr. Moyya Appala Swamy, Ms. Sonam Tantuvoy, Mr. S Sankeerth, Mr. D Srikanth Reddy, Mr. Gudla Charan, Mrs. Pusuluri Anusha, Ms. Ashwini Gajbhiye, Mr. Chikkam Balaji, Mrs. Meera, Mr. Sachin Singh) for keeping faith in me.

There are many unnamed here but as the saying goes, "The *whole* is reflected in each of its *parts*". I wish to extend my sincere appreciation for their valuable assistance, which may have been subtle or unspoken but has had a significant impact on my endeavors.

My heartfelt gratitude to my beloved parents, Mr. G. Prasad and Mrs. G. Shoba Rani, for their unwavering support. Special thanks to my sister, Mrs. Kunda Swetha, and my cousins for their constant encouragement. Their invaluable love and backing have been pivotal to both my personal and professional journey.

(GUMMADIVALLI SHIVA KUMAR)

ABSTRACT

Chromite ore processing residue (COPR) is a hazardous industrial waste derived from the chromate (CrO_4^{2-}) extraction roasting process. It is one of the major sources of environmental contamination as it contains high amounts of chromium (Cr) in, both, the hexavalent $[\text{Cr}(\text{VI})]$ and the trivalent $[\text{Cr}(\text{III})]$ valence states. COPR has been disposed of in unregulated surface (unlined) landfills in several nations across the world, including India, without consideration to its (eco)toxicological potential. It is among the most environmentally hazardous industrial chromium wastes, posing a threat to both human health and the environment. The leaching of $\text{Cr}(\text{VI})$, resulting in the contamination of groundwater, is a key environmental risk arising from these COPR dumps. Therefore, the remediation of COPR is of utmost importance, especially at contaminated sites where it was disposed of in an unscientific manner.

COPR from two of the legacy waste-contaminated sites [Ranipet (TCCL, Tamil Nadu, India) and Rania (near Khan Chandpur village, Kanpur Dehat, Uttar Pradesh, India)] are collected and characterized. Metal content analysis and TCLP-based leaching analysis were performed to arrive at detailed waste properties. In addition to the physicochemical characterization of COPR waste from both sites, the mineralogical composition was also evaluated. The complexity of chromium chemistry, the high exposure risk potential posed by COPR, coupled with the quantity of wastes at these sites advocate for an urgent need to remediate them, and demands the development of a remediation framework that can address the difficulties posed when handling multiple criteria.

National-level clean-up standards (or remediation targets or intervention values or guidelines) associated with Cr-contaminated sites are established only for a few countries. Upon detailed literature review, two sets of standards (Canadian and Dutch) were considered. Considering the two selected COPR sites and two remediation standards, four combinative cases were formulated.

The most appropriate technology alternative for COPR remediation in each of these four cases would be estimated using a multi-criteria framework.

Various aspects regarding the remediation of Cr-contaminated sites that have COPR as the major source of Cr are studied in existing academic literature and databases. A panel of experts (with 4 stakeholder groups) was queried in a 3-phase (4-stage) Delphi process about such aspects of COPR remediation that were not gathered in the literature survey. Their opinions are used to — ascertain and shortlist relevant criteria, create a ‘pair-wise comparison matrix’ among selected criteria, identify candidate treatment technologies for COPR remediation, and generate an ‘information evaluation matrix’ between remediation technology and criteria.

A novel resourceful multicriteria analysis framework, PROSPER-COPR [Prioritization of Remedial Options through Systematic Parametric Evaluation and Ranking for contaminated sites having Chromium Ore Processing Residue (COPR) overburden], was developed to arrive at the weights for finalized criteria and to determine the ranking between alternative technologies. Though POSPER can be applied to any remediation of any waste-contaminated site, PROSPER-COPR is directed towards addressing legacy COPR overburden at contaminated sites. As part of the PROSPER-COPR framework, a variety of multicriteria decision-making (MCDM) methods and weighting methods were employed to calculate criteria weights (both, weights applicable to any site and case-specific weights), as well as to evaluate the rankings between the considered remediation technology alternatives. Fuzzy-AHP, Entropy, and CRITIC methods were used for the calculation of weights; and, TOPSIS and PROMETHEE-II were applied to determine the ranks among various shortlisted remediation technologies. Upon arriving at the case-specific optimal solutions, a novel ‘Technology Improvement Need Analysis (TINA)’ framework has been developed to perform the efficiency analysis of all the remediation technology alternatives or

decision-making units (DMUs) for all cases. The aim of measuring the efficiency of DMUs is to quantify the magnitude by which each of the suboptimal alternatives must be improved for every criterion in order for them to become the optimal candidate of choice.

To measure the efficiency of DMUs, two non-parametric deterministic mathematical multi-objective decision-making (MODM) tools — the Data Envelopment Analysis (DEA) method and the Free Disposal Hull (FDH) method, are used. Two well-known basic DEA models i.e., Charnes, Cooper, and Rhodes (CCR) model and Banker, Charnes, and Cooper (BCC) model, are considered, both, with input orientation. Appropriate solutions are proposed for physically improving the criteria-wise performance of the technologies before their field implementations. The research outcomes are expected to provide an all-inclusive framework to decision-makers across the world for effective remediation of COPR at existing sites, which can be easily replicable to any toxic and hazardous waste.

Keywords: Heavy metal contamination, Chromite Ore Processing Residue, COPR, Contaminated sites, Remediation, Delphi method, MCDA.

सारांश

क्रोमाइट अयस्क प्रसंस्करण अवशेष (COPR) क्रोमेट (CrO_4^{2-}) निष्कर्षण रोस्टिंग प्रक्रिया से प्राप्त एक विषाक्त औद्योगिक अपशिष्ट है। यह पर्यावरण प्रदूषण के प्रमुख स्रोतों में से एक है क्योंकि इसमें हेक्सावैलेंट $[\text{Cr(VI)}]$ और ट्राईवैलेंट $[\text{Cr(III)}]$ वैलेंस अवस्थाओं दोनों में क्रोमियम (Cr) की उच्च मात्रा होती है। सीओपीआर को भारत सहित दुनिया भर के कई देशों में अनियमित सतह (अरेखित) लैंडफिल में इसकी (पर्यावरण) विषैली क्षमता पर विचार किए बिना निपटाया गया है। यह पर्यावरण की दृष्टि से सबसे खतरनाक औद्योगिक क्रोमियम कचरे में से एक है, जो मानव स्वास्थ्य और पर्यावरण दोनों के लिए खतरा पैदा करता है। सीआर(VI) का रिसाव, जिसके परिणामस्वरूप भूजल प्रदूषित होता है, इन COPR डंपों से उत्पन्न होने वाला एक प्रमुख पर्यावरणीय जोखिम है। इसलिए, सीओपीआर का निवारण अत्यंत महत्वपूर्ण है, विशेषकर दूषित स्थलों पर जहां इसका अवैज्ञानिक तरीके से निपटान किया गया था।

दो विरासती अपशिष्ट दूषित स्थलों [रानीपेट (टीसीसीएल, तमिलनाडु, भारत) और रानिया (खान चांदपुर गांव के पास, कानपुर देहात, उत्तर प्रदेश, भारत)] से सीओपीआर एकत्र किया गया है और भौतिक-रासायनिक स्वभाव बताया गया है। विस्तृत अपशिष्ट गुणों पर पहुंचने के लिए धातु सामग्री विश्लेषण और टीसीएलपी-आधारित लीचिंग विश्लेषण किया गया। दोनों स्थलों से सीओपीआर अपशिष्ट के भौतिक-रासायनिक लक्षण वर्णन के अलावा, खनिज संरचना का भी मूल्यांकन किया गया था। क्रोमियम रसायन विज्ञान की जटिलता, सीओपीआर द्वारा उत्पन्न उच्च ऐक्सपोजर रिस्क क्षमता, इन साइटों पर कचरे की मात्रा के साथ मिलकर उन्हें ठीक करने की तत्काल आवश्यकता की वकालत करती है, और एक उपचार ढांचे के विकास की मांग करती है जो कई मानदंडों को संभालने के दौरान उत्पन्न होने वाली कठिनाइयों का समाधान कर सके।

Cr-दूषित साइटों से जुड़े राष्ट्रीय स्तर के सफाई मानक (या उपचार लक्ष्य या हस्तक्षेप मूल्य या दिशानिर्देश) केवल कुछ देशों के लिए स्थापित किए गए हैं। विस्तृत साहित्य समीक्षा के बाद, मानकों के दो सेट (कनाडाई और डच) पर विचार किया गया। दो चयनित सीओपीआर साइटों और दो उपचार मानकों को ध्यान में रखते हुए, चार संयोजन मामले तैयार किए गए थे। इन चार मामलों में से प्रत्येक में सीओपीआर निवारण के लिए सबसे उपयुक्त प्रौद्योगिकी विकल्प का अनुमान बहु-मानदंड ढांचे का उपयोग करके लगाया जाएगा।

Cr-दूषित साइटों के निवारण के संबंध में विभिन्न पहलुओं, जिनमें सीओपीआर, सीआर का प्रमुख स्रोत है, का मौजूदा शैक्षणिक साहित्य और डेटाबेस में अध्ययन किया गया है। सीओपीआर उपचार के ऐसे पहलुओं के बारे में 3-अवस्था (4-चरण) वाली डेल्फ्री प्रक्रिया में विशेषज्ञों के एक पैनल (4 विशेषज्ञ समूहों के साथ) से पूछताछ की गई जो साहित्य सर्वेक्षण में एकत्र नहीं किए गए थे। उनकी राय का उपयोग प्रासंगिक मानदंडों का पता लगाने और शॉर्टलिस्ट करने, चयनित मानदंडों के बीच 'जोड़ी-अनुसार तुलना मैट्रिक्स' बनाने, सीओपीआर उपचार के लिए उम्मीदवार उपचार प्रौद्योगिकियों की पहचान करने, उपचार प्रौद्योगिकी और मानदंडों के बीच 'सूचना मूल्यांकन मैट्रिक्स' उत्पन्न करने के लिए किया जाता है।

अंतिम मानदंडों के लिए वजन पर पहुंचने और वैकल्पिक प्रौद्योगिकियों के बीच रैंकिंग निर्धारित करने के लिए एक नया संसाधनपूर्ण बहुमानदंड विश्लेषण ढांचा, PROSPER-COPR [क्रोमियम अयस्क प्रसंस्करण अवशेष (सीओपीआर) ओवरबर्डन वाले दूषित साइटों के लिए व्यवस्थित पैरामीट्रिक मूल्यांकन और रैंकिंग के माध्यम से उपचारात्मक विकल्पों को प्राथमिकता देना] विकसित किया गया था। हालाँकि PROSPER को किसी भी अपशिष्ट-दूषित साइट के उपचार के लिए लागू किया जा सकता है, PROSPER-COPR का उद्देश्य दूषित साइटों पर पुराने COPR ओवरबर्डन को संबोधित करना है। प्रॉस्पर-सीओपीआर ढांचे के हिस्से के रूप में, मानदंड भार (दोनों, किसी भी साइट पर लागू वजन और केस-विशिष्ट वजन) की गणना करने के लिए, साथ ही विचार किए गए उपचारात्मक प्रौद्योगिकी विकल्पों के बीच रैंकिंग का मूल्यांकन करने के लिए

विभिन्न प्रकार के बहुमानदंड निर्णय लेने (एमसीडीएम) के तरीकों और वजन तरीकों को नियोजित किया गया था। वज़न की गणना के लिए फ़ज़ी-एएचपी, एन्ट्रॉपी और क्रिटिक विधियों का उपयोग किया गया था; और, TOPSIS और PROMETHEE-II को विभिन्न शॉर्टलिस्टेड उपचार प्रौद्योगिकियों के बीच रैंक निर्धारित करने के लिए लागू किया गया है। मामले-विशिष्ट इष्टतम समाधानों पर पहुंचने पर, सभी मामलों के लिए सभी उपचारात्मक प्रौद्योगिकी विकल्पों या निर्णय लेने वाली इकाइयों (डीएमयू) की दक्षता विश्लेषण करने के लिए एक नवीन 'प्रौद्योगिकी सुधार आवश्यकता विश्लेषण (TINA)' विकसित किया गया है। डीएमयू की दक्षता को मापने का उद्देश्य उस परिमाण को मापना है जिसके द्वारा प्रत्येक मानदंड के लिए प्रत्येक उप-इष्टतम विकल्पों में सुधार किया जाना चाहिए ताकि वे पसंद के इष्टतम उम्मीदवार बन सकें।

डीएमयू की दक्षता को मापने के लिए, दो गैर-पैरामीट्रिक नियतात्मक गणितीय बहुउद्देश्यीय निर्णय लेने (एमओडीएम) के उपकरण - डेटा एनवेलपमेंट विश्लेषण (डीईए) विधि और फ्री डिस्पोजल हल (एफडीएच) विधि का उपयोग किया जाता है। दो प्रसिद्ध बुनियादी डीईए मॉडल यानी, चार्नेस, कूपर और रोड्स (सीसीआर) मॉडल और बैंकर, चेम्स और कूपर (बीसीसी) मॉडल, दोनों को इनपुट ओरिएंटेशन के साथ माना जाता है। प्रौद्योगिकियों के क्षेत्र में कार्यान्वयन से पहले उनके मानदंड- अनुसार प्रदर्शन को भौतिक रूप से सुधारने के लिए उचित समाधान प्रस्तावित हैं। शोध के परिणामों से मौजूदा साइटों पर सीओपीआर के प्रभावी निवारण के लिए निर्णय निर्माताओं को एक सर्व-समावेशी ढांचा प्रदान करने की उम्मीद है, जिसे आसानी से किसी भी रासायनिक कचरे के लिए दोहराया जा सकता है।

कीवर्ड: भारी धातु संदूषण, क्रोमाइट अयस्क प्रसंस्करण अवशेष, सीओपीआर, दूषित साइट, उपचार, डेल्फ्री विधि, एमसीडीएम।

Table of Contents

Certificate	i
Acknowledgments	ii
Abstract	iv
सारांश	vii
Table of contents	x
List of Tables	xii
List of Figures	xiii
List of Abbreviations and Acronyms	xv
 Chapter 1 Introduction	 1
1.1 Chromium: Sources and Toxicity	3
1.2 Soil-Chromium Contamination	7
1.3 Chromite Ore Processing Residue (COPR)	13
1.4 Motivation for the Study	14
1.5 Organization of the Thesis	16
 Chapter 2 Literature Review	 18
2.1 Chromite Ore Processing Residue (COPR) contamination	18
2.1.1 COPR: Sources, Composition, and Characteristics	19
2.1.2 COPR: Impacts on the Environment	24
2.1.3 Current Status Across the World	26
2.2 Current Remediation Practices	28
2.2.1 Remediation Practices on COPR	34
2.3 Remediation Criteria: Comparison	41
2.4 Decision-Making for Remediation of Contaminated Sites	53
2.5 Research Gaps and Need for the Current Study	67
2.6 Objectives and Scope of the Study	69
2.6.1 Objectives	69
2.6.2 Scope	72
 Chapter 3 COPR characterization and selection of technologies	 74
3.1 Characterization of Selected COPR Contaminated Sites	75
3.1.1 Study Area	75
3.1.2 Methodology	83
3.1.3 Results	85
3.2 Selection of Remediation Technologies and SWOT Analysis	92
3.3 Application of the Delphi method for Identification of Criteria and Technologies	95

3.3.1	Inputs for the Delphi methodology	101
3.3.2	The Expert Panel and Agenda for Decisioning	104
3.3.3	Delphi results: Criteria finalization and Technology information matrix	112
Chapter 4	Development and Application of Multi-Criteria Assessment Framework	129
4.1	Development of a Multi-Criteria Assessment (MCA) framework	131
4.1.1	PROSPER-COPR: Introduction	134
4.1.2	Hybrid Approach for Generation of Combined Criteria Weights	138
4.1.3	Prioritized Ranking using MCDA	143
4.2	Application of the Proposed Framework	144
4.2.1	Generation of Information Evaluation Matrices for all cases	147
4.2.2	Generation of Criteria Weights	153
4.2.3	Determination of Ranking between Alternative Technologies	162
4.3	Discussions	165
Chapter 5	Technology Improvement Need Analysis (TINA)	168
5.1	Development of the TINA Framework	171
5.2	Application of the TINA Framework	173
5.3	Solutions to Improve the Remediation Performance	176
Chapter 6	Summary, Conclusions, and Suggestions for future work	180
6.1	Summary	180
6.2	Conclusions	182
6.3	Suggestions for future work	184
References		187
Appendix A		210
Appendix B		261
Appendix C		263
Appendix D		265
Curriculum Vitae		271

List of Tables

Table 1.1	Properties of prevalent chromium species	9
Table 2.1	Mineralogical composition of COPR using XRD	24
Table 2.2	Classification of Contaminant Remediation Technologies by Process	31
Table 2.3	Lines of Evidence to Verify Remediation and Typical Timescales	32
Table 2.4	Assessment and Chemical Treatment of Chromium in COPR	42
Table 2.5	Assessment and Biological Treatment of Chromium in COPR	48
Table 2.6	Elements for consideration during selection of remediation options	54
Table 3.1	Characteristics of COPR samples at Ranipet site, TN	87
Table 3.2	Characteristics of COPR samples at Rania site, UP	89
Table 3.3	Technologies that are involved in the management of COPR	92
Table 3.4	Widely used clean-up target limits for Cr-contaminated sites across the world	100
Table 3.5	Various Inputs provided to the Delphi expert panel	101
Table 3.6	Criteria Relevant for Remediation of Cr-Contaminated Sites	103
Table 3.7	Technology alternatives selected in Delphi application	115
Table 3.8	The pair-wise comparison matrix between selected remediation criteria	116
Table 3.9	Shortlisted criteria and rating scale	118
Table 3.10	Case-wise Technology Information Evaluation Matrices	119
Table 4.1	Steps of an MCDA process	133
Table 4.2	Technology alternatives selected and their effectiveness	149
Table 4.3	Completed case-wise Technology Information Evaluation Matrices	151
Table 4.4	Criteria weights calculated using the pair-wise comparison matrix	155
Table 4.5	Case-specific objective criteria weights calculated using the IMs	158
Table 4.6	Case-specific combined criteria weights	160
Table 5.1	The results of the efficiency analysis	177

List of Figures

Figure 1.1	Reduction potential diagram of chromium	4
Figure 1.2	Use of Chromium in Different Industries	5
Figure 1.3	Visual depiction of all the impacts caused by chromium exposure	6
Figure 1.4	Impacts of Cr(VI) plant uptake	8
Figure 1.5	Processes affecting the migration, transformation, and chemical state of chromium	10
Figure 1.6	The natural chromium cycle in the environment	12
Figure 1.7	The Eh-pH diagram for the system Cr-O ₂ -H ₂ O	13
Figure 2.1	Simplified Schematic of Industrial Production of Chromate	21
Figure 2.2	Illustrative flowsheet of the traditional production process	23
Figure 2.3	A conceptual model of COPR contaminated site showing Cr pathways	25
Figure 2.4	Some of the major COPR contaminated sites in the world	28
Figure 2.5	Treatment strategies based on how and where the remediation method is applied	35
Figure 2.6	Pyrolytic Reduction of Cr ⁺⁶ in the presence of Organic Carbon	41
Figure 3.1	Steps to identify the optimal remediation treatment alternative at contaminated sites. (A) The USEPA (1988) guide framework for conducting remedial investigations, (B) Various aspects to be considered while performing different segments of the framework	74
Figure 3.2	Location of study areas (Black locator points: Major contaminated sites; Yellow dots: Major contaminated sites with Cr as a contaminant of concern; Red circles: Current study sites)	76
Figure 3.3	Sample collection from, both, Ranipet (A, C, D, H) and Rania (B, E, F, G) sites	78
Figure 3.4	Schematic layout of sampling locations at the TCCL site, Ranipet, Vellore, TN, India	81
Figure 3.5	Demarcation of COPR site at Rania, Kanpur Dehat, UP, India showing sampling points	82
Figure 3.6	Flow diagram of COPR metal content analysis	85
Figure 3.7	HB COPR (D1:0-30cm depth) and GB COPR (D2:30-60 cm depth) at the S1 location	86
Figure 3.8	Leaching of Cr(VI) (mg/L) from COPR using TCLP for Ranipet, TN site (30-60 cm)	88
Figure 3.9	Leaching of Cr(III) (mg/L) from COPR using TCLP for Ranipet, TN site (30-60 cm)	88
Figure 3.10	Leaching of Cr(VI) (mg/L) from COPR using TCLP for Rania, UP site (30-60 cm)	90
Figure 3.11	Leaching of Cr(III) (mg/L) from COPR using TCLP for Rania, UP site (30-60 cm)	90
Figure 3.12	XRD of COPR sample (S2) from Rania, UP site (A: 0-30 cm, and B: 30-60 cm)	91
Figure 3.13	Combinative cases between considered COPR sites and standards selected	100

Figure 3.14	Stakeholders for remediation of heavy metal contaminated sites	108
Figure 3.15	Expert groups consulted for responses during the Delphi application	109
Figure 3.16	Delphi phases and involved workflow	110
Figure 3.17	Stages, steps, and information flow during Delphi process	111
Figure 3.18	Entire flow sequence depicting various rounds and stages of Delphi implementation	113
Figure 3.19	Evaluation criteria shortlisted during the Delphi process	114
Figure 3.20	Experts' rating of various technologies for case-1 (during Delphi stage-3) in terms of their costs and ease of implementation	122
Figure 3.21	Experts' rating of various technologies for case-1 (during Delphi stage-3) in terms of their post-remediation performance (long-term- and short-term performance)	123
Figure 3.22	Experts' rating of various technologies for case-1 (during Delphi stage-3) in terms of their post-remediation performance (Toxicity reduction and Aesthetics+Future use of site)	124
Figure 3.23	Radar plots representing the experts' assessment for comparisons marked between selected remediation technologies and criteria for case-1	125
Figure 3.24	Radar plots representing the experts' assessment for comparisons marked between selected remediation technologies and criteria for case -2	126
Figure 3.25	Radar plots representing the experts' assessment for comparisons marked between selected remediation technologies and criteria for case-3	127
Figure 3.26	Radar plots representing the experts' assessment for comparisons marked between selected remediation technologies and criteria for case-4	128
Figure 4.1	Overview of the MCDA process	132
Figure 4.2	MCDA decision tree to remediate contaminated sites containing COPR	137
Figure 4.3	PROSPER-COPR framework developed to determine the most appropriate remediation technology for any contaminated site containing COPR	145
Figure 4.4	Application of developed PROSPER-COPR framework to determine the most appropriate remediation technology for COPR remediation for four considered cases	146
Figure 4.5	Various methods considered for calculating criteria weights.	154
Figure 4.6	Check for weights via checking pair-wise comparison matrix	156
Figure 4.7	Generation of criteria weights	157
Figure 4.8	Various criteria weighting methods and applicability of different weight sets	158
Figure 4.9	Generation of rankings among alternatives	164
Figure 4.10	Methods (Green) considered for ranking the COPR remedial technology alternatives	163
Figure 4.11	Rankings obtained after applying MCDM for all cases.	166
Figure 5.1	Methods (Red) considered for performing efficiency analysis of DMUs	172
Figure 5.2	Development of a novel TINA framework	174
Figure 5.3	Application of the proposed TINA framework	175
Figure 5.4	The target and existing values for E+ONS2 for case-2	178

List of Abbreviations and Acronyms

ARAS	Additive RAtio Assessment
A+F	Aesthetics + Future use of the site (Post Remediation)
APHA	American Public Health Association
ASTM	American Standard Test Methods
AHP	Analytic Hierarchy Process
ANP	Analytic Network Process
AHP-AM	Analytical Hierarchy Process Arithmetic Mean Method
AHP-GM	Analytical Hierarchy Process Geometric Mean Method
BCC	Banker, Charnes and Cooper model
BCS	Basic Chromium Sulphate
BDL	Below Detection Limit
Be	Beneficial
HCrO_4^{2-}	Bichromate
B	Brownmillerite
Br	Brucite
C'	Calcite
Ca	Calcium
CAC	Calcium Aluminum Chromium Oxide Hydrate
CLRI	Central Leather Research Institute
CPCB	Central Pollution Control Board
CCR	Charnes, Cooper and Rhodes model
CrO_4^{2-}	Chromate
Cr_2O_3	Chromic Oxide
COPR	Chromite Ore Processing Residue
Cr(0)	Chromium element
$\text{Cr}(\text{OH})_3$	Chromium Hydroxide
COPRAS	COmplex PROportional ASsessment
CR	Consistency Ratio
C	Cost
CSIR	Council of Scientific and Industrial Research
CW-III	Criteria Weights (Combined)
CW-I	Criteria Weights (For any site)
CW-II	Criteria Weights (Site-specific)
DEA	Data Envelopment Analysis
DSS	Decision Support Systems
DEMATEL	DEcision-MAking TRIal and Evaluation Laboratory
DMUs	Decision-Making Units
DPR	Detailed Project Report
Ph.D.	Doctor of Philosophy
D-models	Dynamic Models
EI	Ease of Implementation (Post Remediation)

ELECTRE	ÉLimination Et Choix Traduisant la REalité (ELimination Et Choice Translating REality)
EPA	Environmental Protection Agency
ER/R	Environmental Risk (Post Remediation)
EEC	Estimated environmental contaminant concentration
E+OFS1	Excavation + Off-site Treatment-1
E+OFS2	Excavation + Off-site Treatment-2
E+ONS1	Excavation + On-site Treatment-1
E+ONS2	Excavation + On-site Treatment-2
E-R	Exposure-Risk
SW-E	Ex-situ soil washing
FeSO ₄	Ferrous Sulphate
FDH	Free Disposal Hull model
F-AHP	Fuzzy Arithmetic Hierarchy Process
GA	Genetic Algorithm
GM	Geometric Mean
GP	Goal Programming
GB COPR	Grey Black COPR
G	Grimaldiite
GW	Ground water
GJ	Gujarat
HB COPR	Hard Brown COPR
HQ	Hazard Quotient
Cr(VI)	Hexavalent Chromium
HPSO	Hybrid Particle Swarm Optimization
IIT	Indian Institute of Technology
IITR	Indian Institute of Toxicology Research
ICP-MS	Inductively Coupled Plasma Mass Spectrometer
IM	Information Matrix
SW-I	In-situ soil washing
Fe	Iron
K	Katoite
L	Larnite
LP	Linear Programming
LP	Long-term Performance (Post Remediation)
Cr	Magnesiochromite
Mg	Magnesium
Mn	Manganese
M.Tech	Master of Technology
MLT	Membrane Layer Treatment
MIP	Mixed Integer Programming
MDL	Modified Digital Logic
MODM	Multi Objective Decision-Making

MADM	Multi-Attribute Decision Making
MAV(UT)	Multi-Attribute Value (Utility) Theory
MCDA	Multi-Criteria Decision Analysis
MCDM	Multi-Criteria Decision-Making
MOORA	Multi-Objective Optimization on the basis of Ratio Analysis
NEERI	National Environmental Engineering Research Institute
NIT	National Institute of Technology
NPL	National Priorities List
NILP	New Iterative Linear Programming
NJ	New Jersey
NA	No Action
NOAEL	NO Adverse Effects Level
NBe	Non-beneficial
NSGA	Non-dominated Sorting Genetic Algorithm
NGO	Non-Governmental Organization
K _d	Partition Coefficient
P	Periclase
Pt	Portlandite
PROMETHEE	Preference Ranking Organization METHod for Enrichment Evaluation
QFD	Quality Function Deployment
Q	Quartz
R&D	Research and Development
SP	Short-term Performance (Post Remediation)
SAW	Simple Additive Weighting
SA	Simulated Annealing
SODM	Single Objective Decision-Making
S	Sjogrenite
SA	Social acceptance and impacts
Na ₂ CrO ₄	Sodium Chromate
Na ₂ Cr ₂ O ₇	Sodium Dichromate
SC	Soil Cover
SIPCOT	State Industries Promotion Corporation Of Tamil Nadu
SPCB	State Pollution Control Board
SWARA	Stepwise Weight Assessment Ratio Analysis
SU	Sustainability during the implementation of the remediation technology
TS	Tabu Search
TN	Tamil Nadu
TCCL	Tamil Nadu Chromates and Chemicals Limited
TNPCB	Tamil Nadu Pollution Control Board
TSP	Technical success potential of the remediation technology
TOPSIS	Technique for Order Performance by Similarity to Ideal Solution
TINA	Technology Improvement Need Analysis
T	Time needed to implement the remediation technology

TCLP	Toxicity Characteristic Leaching Procedure
TR	Toxicity reduction (Post Remediation)
Cr(III)	Trivalent Chromium
US EPA	United States Environment Protection Agency
USA	United States of America
UP	Uttar Pradesh
UPPCB	Uttar Pradesh Pollution Control Board
VIKOR	Vise Kriterijumska Optimizacija I Kompromisno Resenje (Multi-criteria optimization and compromise solution)
V	Voltaite
WB	West Bengal
XRD	X-Ray Diffraction
PROSPER	Prioritization of Remedial Options through Systematic Parametric Evaluation and Ranking for contaminated sites having Chromium Ore Processing Residue (COPR) overburden
MAUT	Multi-Attribute Utility Theory
MAVT	Multi-Attribute Value Theory
MACBETH	Measuring Attractiveness by a Categorical-Based Evaluation Technique
CODAS	COMbinative Distance-based ASsessment
MCA	Multi-Criteria Assessment