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## **NEW BIOENERGY PRODUCTION FOR SUNFLY AND WASTE FOR BIOENERGY PRODUCTION**

The preservation of biodiversity and its mainstreaming requires reconciling conservation objectives with economic and social aspects. In this direction, one new concept that is gaining momentum is the bioeconomy. Bioeconomy refers to economic sectors and activities that apply biological processes and principles to create new products, services, and renewable raw materials (Biber-Freudenberger et al., 2020; Dietz et al., 2018). Biodiversity could be a central part of the bioeconomy because of the potential to find new products in areas such as pharmaceuticals, cosmetics, and food and new molecules that are fundamental for developing biotechnology. Biodiversity can also be studied to inspire solutions in areas such as architecture, design, and engineering. Finally, bioeconomy strategies can support the development of services linked to biodiversity, such as ecotourism and payment for ecosystem and environmental services. Such a bioeconomy based on biodiversity needs to be based on scientific research and bioprospecting to generate new products, services, concepts, and technologies. Valuing the knowledge and work of indigenous peoples, traditional communities, and family farmers is equally crucial, not only to enable economic, scientific, and technological advances but also to ensure equity and social inclusion.

Use of crop production waste for bioenergy production for Agricultural waste mainly consists of cereal straw and residues of sunflower and corn processing. It is believed that one ton of harvested grain accounts for approximately one ton of straw. According to specialists' calculations, thanks to the use of this potential in energy production, 13-15% of the state's primary energy needs can be met in the near future.

The advantages of using plant residues for the production of solid biofuel with subsequent burning to obtain thermal energy are: efficiency, environmental cleanliness of burning; convenience and long shelf life; a wide range of raw materials for production; complete readiness for use; the process can be fully automated and require a minimum of manual labor. Anaerobic fermentation with the production of biogas is another energy direction of using crop production waste. In practice, a mixture of crop and livestock waste is more often used in order to increase the yield of biogas [1].

In Ukraine, biomass energy resources are under-utilized, in particular, about 1 million tonnes of conventional fuel is produced, and the fuel potential of heat supply is equivalent to 25-27 million tonnes of fuel. The Bioenergy Association of Ukraine has developed a concept

[1, 2], according to which in 2030 it is expected to produce 9.2 million tons of energy from energy crops. According to statistics [1, 3], 3-4 million ha of agricultural land are not used in Ukraine every year. This land can be partially used for growing fast-growing energy crops, including 1.5 million hectares under the energy willow (*Salix*), poplar (*Populus*), miscanthus and others. [2].

The use of sugar beet for the production of various types of biofuel, because sugar beet is a universal bioenergy crop. Both bioethanol and biogas can be obtained from sugar beet raw materials, as well as used in combination with animal manure.

The culture is characterized by high growth rates, in particular the length of the stem - 3-5 cm / day, an average of 1.5 m / year [3, 4]. Willow is divided into the following types: rod, white, ash, brittle, goat, eared, three-leaved, purple, etc. The willow (*Salix Viminalis*) is usually grown for energy purposes. The seedlings of 0.18-0.25 m in length are planted in March by the number of 13-18 thousand pieces / ha rows at a distance of 0.70-0.75 m to a depth of about 90% of the length of the bar. Willow mass at a moisture content of about 50% is collected in the winter after 3-4 years with self-propelled forage harvesters or special machines.

One-step method of harvesting is cutting and shredding willows up to 50-70 mm and loading the chips into the vehicle. Combines with a capacity of up to 30 t / h are used by Claas firms (HS2 adapter for Jaguar 820-900), New Holland (130 FB adapter), Krone (WoodCut 1500 adapter), as well as energy harvesting machines with modified cutting machines.

A byproduct of sugar production is pulp. When processing 1 ton of sugar beets, you can get 800 kg of raw pulp or 238 kg of pressed pulp. According to calculations, if the average daily processing of beets at 1 sugar factory is 3,866 tons, then the factory can obtain 920.1 tons of pressed pulp per day. The yield of biogas (with a methane content of 70%) from 1 ton of pressed pulp is 100 m<sup>3</sup>. So, a biogas plant based on sugar factories can produce 92,010 m<sup>3</sup> of biogas per day, and 33,583,650 m<sup>3</sup> per year. Such installations can provide the electricity needs of the plant itself and be used for local heat networks.

Ukrteplo company grows energy willow on the area of 2.2 thousand hectares in Ivankiv district of Kyiv region, plans to expand the area to 17 thousand hectares.

LLC "Agrarian Commonwealth" implements the project with *Salix Vinalis* for 2 thousand hectares and production of fuel pellets at the plant with an annual capacity of 24 thousand tons / year.

Two-stage assembly consists of two process phases. During the first phase the plants are cut off, during the second phase they are crushed. In some technologies, harvesting consists of cutting and pressing plants into packs.

The ecological advantages of the energy use of commercial sunflower waste are obvious. Nowadays, ecology sets before humanity the task of stabilizing the climate or mitigating the consequences of its change. Using commercial sunflower waste for energy purposes is one of the ways to reduce CO<sub>2</sub> emissions into the atmosphere. This waste, like

biomass in general, is a CO<sub>2</sub>-neutral fuel (the consumption of CO<sub>2</sub> from the atmosphere during the growth of cereal crops corresponds to CO<sub>2</sub> emissions into the atmosphere during biomass burning. Taking into account additional CO<sub>2</sub> emissions during collection, transportation, primary processing, preparation for burning, reduction of CO<sub>2</sub> emissions when coal is replaced by biomass is about 90%, the effective use of primary processing waste of commercial sunflower reduces methane emissions when they are decomposed in landfills. The sulfur content in sunflower waste is low. Emissions of carbon dioxide and carbon monoxide gases into the atmosphere during the burning of such waste are much lower, than when using, for example, coal or fuel oil.

Another environmental advantage of using solid biofuel from sunflower waste is the low risk of explosions, accidents, and fuel leaks compared to fossil fuels.

So, the advantages of sunflower as a raw material are low cost, a small amount of CO<sub>2</sub> emissions into the environment, maximum safety, a large amount of raw materials.

In order to collect sunflower waste as much as possible during threshing, the specialists of the Agrarian University suggested to the farm to reduce the speed of the cleaning fan. Thus, losses of seeds behind the thresher are reduced, and the amount of waste in the hopper, which will be used for the production of fuel briquettes during primary seed processing, increases.

"After threshing, we were left with tons of sunflower waste. And when before we simply left them in the fields, now we took them to the kagatas and stored them. The machine for the production of briquettes was made by our engineers according to the principle of operation of a shock-mechanical press. All this pile under the action of a powerful press turned into such cylinders. Their form could be varied." Three types of briquettes can be made from sunflower.

"Pini-kei" have a high density, which is equivalent to 1,200 kg/m<sup>2</sup>. This is 2.5 times higher than the corresponding parameters of wood. Only 3% of ashes remain after their combustion. This is one of the lowest indicators.

"Nestro" fuel briquettes already have a much lower density than "pini-kei", so they are afraid of moisture. They are usually cylindrical in shape and may have a hole in the middle. The length of the briquette is 250 mm. "Ruf" briquettes have the shape of a brick, low density (up to 1 kg/dm<sup>3</sup>), which makes them crumble during transportation. They are distinguished by the shortest (of all types of briquettes) burning time, they cannot be stored for a long time without sealed packaging. In short, RUF briquettes have the lowest consumer properties and the lowest price.

"The proposed waste briquetting technology "nestro" makes it possible to obtain high-quality fuel briquettes from a wide variety of vegetable waste. Briquettes are produced without chemical fixatives under high pressure. Sunflower waste, pre-dried to the required moisture content, enters the receiving hopper and is then fed evenly by a dosing screw into the pressing chamber, where compression and simultaneous heating take place.

The development of biodiesel production is also stopped by the presence of a by-product — glycerin, which is difficult to dispose of. Another important factor is that biodiesel on the market is supported by legislation.

"Unrefined sunflower oil in the store today costs UAH 82/l, and 1 liter of diesel at the gas station costs UAH 55. That is, we can say that the cost of oil is already 50% more expensive than diesel. During the period when biodiesel was developing in our country, the ratio was profitable. This has not been the case in recent years," says the expert.

According to him, currently the only prospect of biodiesel in Ukraine is its production in small quantities by farmers for their own consumption, especially now, when there is a problem with both the export of raw materials and the import of petroleum products.

Market participants point out that if a norm regarding the mandatory share of biofuel in the total volume of liquid motor fuel is adopted at the legislative level, there will be a stable demand for such fuel. It will become economically feasible to produce biofuel not only as a reserve for your farm, but also for sale on the market.

In order for the processing industry to develop, it is necessary to implement certain legislative initiatives. In particular, allow the addition of bioethanol to motor fuels. The corresponding draft law is being prepared for the second reading in the Verkhovna Rada. The addition of bioethanol to motor fuels will help reduce the load on grain logistics and ensure the sustainability of energy as a whole.

According to the Ukrainian Association of Bioethanol, 77,000 tons of bioethanol were produced in 2021. Bioethanol is an interesting idea for Ukraine, if it is produced from corn. In general, it is possible to focus on securing a 10% share of the European bioethanol market, which is 1.8 million tons of corn. Yes, this is only 10% of the total supply of corn in Ukraine, but it will provide added value and additional stability to domestic prices.

"The only question is where to produce bioethanol. With the capacities we have, we are able to process 0.5 million grains. But these plants produce alcohol, not bioethanol. In order for alcohol to become bioethanol, it is necessary to increase its concentration to at least 99.3%. Not every plant can produce ethyl alcohol of such a concentration." In Ukraine, there are enough capacities for bioethanol processing, and there is a trend towards their growth. In particular, thanks to the privatization of distilleries.

A high-tech enterprise in the Lviv region will process agricultural waste. The company "AB AGRO PROJECT GROUP" is designing a modern bioethanol plant, the construction of which will begin at the end of 2023. The first such plant will be built in the Odesa region, and three more are planned to be built in different regions of Ukraine, in particular in the Lviv region.

The first plant will be built for the Gaztransit energy company. The estimated amount of investments in the project is 30-35 million euros. "The potential of our economy is 30 plants for deep processing (bioprocessing) of agricultural raw materials in different regions of the country. In particular, the option of such an enterprise is being considered in the Lviv

region. A short logistics arm with export markets will make it possible to obtain a more profitable enterprise. Enterprises for deep processing are immediately built by our company, export-oriented." In the future, we are talking about deep processing of agricultural waste, in which microorganisms are used. At the first stage, it is planned to process wheat, later - molasses (waste from sugar beet processing), cellulose, etc.

"The bioethanol plant is a high-tech enterprise. Bioethanol has a high added value. Locating the enterprise in Lviv Oblast will simplify product export to EU countries. It is economically beneficial. Also, such placement is a security issue of the investment project," there are no large bioethanol production plants in Ukraine. However, there are small ones that produce bioethanol from molasses - for example, in the Volyn region.

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**НАЦІОНАЛЬНИЙ УНІВЕРСИТЕТ БІОРЕСУРСІВ  
І ПРИРОДОКОРИСТУВАННЯ УКРАЇНИ  
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**РОЗВИТОК БІОЕНЕРГЕТИЧНОГО  
ПОТЕНЦІАЛУ В СІЛЬСЬКОМУ  
ГОСПОДАРСТВІ**

**07 - 08 березня 2025 р.**

**м. Київ**

УДК 620.9:63

**Розвиток біоенергетичного потенціалу в сільському господарстві: матеріали доповідей Міжнародної науково-практичної конференції (м. Київ., 07-08 березня 2025 р.). – К.: Видавництво «Наукова столиця», 2025 – 172 с.**

Відповідальний за випуск д. е. н., професор **М. П. Талавира**

**Відповідальність за достовірність матеріалів несуть автори.**

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природокористування України, 2025