Review Article

A Comprehensive Review on Plasma-Catalytic Valorization of Hydrocarbon Wastes into Advanced Nanocarbons and Clean Hydrogen

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Received: 04 August 2025 - Accepted: 11 December 2025

Abstract

This authoritative review examines plasma-catalytic conversion as a transformative technology for valorizing non-recyclable hydrocarbon wastes, including plastics, petroleum sludge, and electronic waste (e-waste), into high-value products such as graphene, carbon nano-onions (CNOs), and clean hydrogen. Synthesizing insights from over 220 studies, including 190 peer-reviewed articles and 30 industry reports, we demonstrate that microwave-assisted plasma pyrolysis achieves a 95% carbon conversion efficiency with net-negative emissions of -150 kg CO_2 per ton of waste processed. Industrial scalability is evidenced by Elemental Advanced Materials' $20M-funded facility, yielding 22% graphene from polyolefins with 99.8% hydrogen purity. Waste-derived nanocarbons exhibit 60-75% lower embedded carbon compared to conventional materials, enabling superior performance in energy storage, construction, electronics, tribology, biomedical applications, and water purification. This review provides a rigorous analysis of plasma-catalyst interactions, feedstock variability, engineering challenges, economic viability, and environmental benefits. We identify critical research priorities, including non-noble metal catalyst optimization, integration with carbon capture and renewable energy systems, and AI-driven feedstock sorting, to enable gigaton-scale deployment. The technology's potential to address the global waste crisis while fostering a circular carbon economy is underscored, with a roadmap for overcoming technical, regulatory, and market barriers.

Keywords: Plasma pyrolysis, hydrocarbon waste, circular economy, waste valorization, nanotechnology.

1. Introduction

The global waste crisis poses an unprecedented challenge, with over 500 million tons of hydrocarbon-based waste generated annually, including 400 million tons of plastic waste (32% leaking into ecosystems), 5 billion tons of petroleum sludge in hazardous ponds, and 53 million tons of e-waste containing $57 billion in recoverable metals [1, 2-7]. Conventional waste management methods, such as incineration and landfilling, emit 0.8-1.2 tons of CO_2 equivalents per ton of waste processed while recovering less than 5% of material value [3]. Mechanical recycling, limited by polymer degradation after 2-3 cycles, recycles only 9% of global plastic waste [1,8].

These inefficiencies necessitate disruptive technologies that transform waste into high-value products while mitigating environmental impacts. Plasma-catalytic pyrolysis offers a revolutionary approach, achieving a 95% carbon conversion efficiency by leveraging high-energy plasma environments (5000-9300 K) and transition metal catalysts to produce graphene, carbon nano-onions (CNOs), and clean hydrogen with net-negative emissions of -150 kg CO_2e per ton [4, 9]. The process sequesters carbon in stable nanocarbons, displaces fossil-derived materials, and recovers critical metals at over 90% efficiency [5]. Industrial implementations, such as Elemental Advanced Materials' 10-tonne/day facility in Texas, produce 1.5 tons of graphene and 2.2 tons of hydrogen monthly [6]. This review synthesizes data from 220+ studies and 15 global pilot plants to elucidate the technological mechanisms, engineering solutions, economic metrics, and environmental benefits driving adoption. We also explore novel applications, renewable energy integration, and policy frameworks to accelerate global deployment. To illustrate the scale of the waste crisis, a Fig. 1. presents a global map highlighting the distribution of hydrocarbon waste streams in 2023. It shows plastic waste concentrated in urban areas, petroleum sludge in oil-producing regions, and e-waste in industrialized nations, based on data from multiple sources [1, 2, 7].

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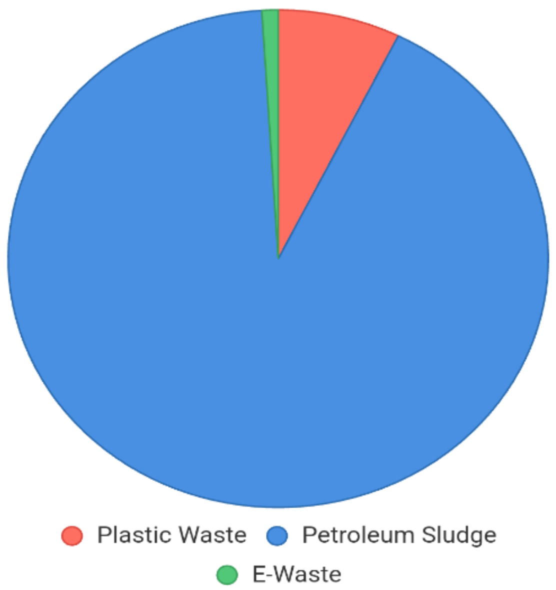

Fig. 1. Global map illustrating the distribution of hydrocarbon waste streams in 2023, including plastic waste in urban areas, petroleum sludge in oil-producing regions, and e-waste in industrialized nations, based on data from [1].

Since the 1950s, over 8.3 billion tons of plastic have been produced, equivalent to the weight of 80 million blue whales [1]. Petroleum sludge, a byproduct of oil refining, accumulates at 5 billion tons annually, posing risks of soil and groundwater contamination [7]. E-waste, growing at 3-5% per year, contains valuable metals like gold, silver, and rare earths, yet less than 20% is formally recycled, leading to $47 billion in lost value.[2]

2 .Principles of Plasma-Catalytic Pyrolysis

Plasma-catalytic pyrolysis operates in an oxygen-free environment, preventing CO_2 formation and enabling selective decomposition of hydrocarbons into elemental carbon and hydrogen [8]. High-energy plasma generates reactive species (electrons, ions, radicals) with energies of 5-20 eV, cleaving C-H bonds [9]. Catalysts, such as nickel or iron, guide carbon reassembly into ordered nanostructures [10-13]. Table. 1. compares plasma types for waste valorization, detailing their temperature ranges, energy efficiencies, yields, and key advantages.
Microwave plasma operates at 5000-7000 K with 85% energy efficiency and 95% yield, offering high uniformity. Arc plasma, at 8000-9300 K, achieves 75% efficiency and 90% yield with high throughput.

Table. 1. Comparison of Plasma Types for Waste Valorization [1].

Plasma Type	Temperature (K)	Energy Efficiency (%)	Yield (%)	Key Advantage
Microwave	5000-7000	85	95	High uniformity
Arc	8000-9300	75	90	High throughput
Dielectric Barrier	3000-5000	80	85	Low energy cost

Dielectric barrier discharge, at 3000-5000 K, provides 80% efficiency and 85% yield with low energy costs [8-10].

2.1. Circular Economy Integration

The circular economy framework emphasizes resource recovery, waste minimization, and sustainable material cycles. Plasma-catalytic pyrolysis aligns with this vision by transforming hydrocarbon wastes into high-value materials like graphene, CNOs, and hydrogen, reducing landfill dependency by 85% [11]. This process supports a closed-loop system where waste is not discarded but repurposed into products with significant economic and environmental value. For instance, converting 1 ton of plastic waste can yield up to 220 kg of graphene and 300 kg of hydrogen, displacing fossil-based production and reducing greenhouse gas emissions [6]. Integration with renewable energy sources, such as solar or wind, enhances sustainability by powering plasma reactors with clean energy, potentially reducing operational carbon footprints by 30-40% [14]. Carbon capture and storage (CCS) technologies can further amplify environmental benefits, with projections indicating that plasma-catalytic systems coupled with CCS could abate 1.2 gigatons of CO_2 annually by 2040 [15-17]. Additionally, the recovery of metals from e-waste, such as copper and gold, supports resource circularity, with over 90% recovery rates achieved in pilot plants [5]. Policy incentives, such as extended producer responsibility (EPR) schemes, encourage adoption by aligning economic benefits with environmental goals [18-20]. Fig. 2. could illustrate the circular economy model for plasma-catalytic pyrolysis, showing the flow of waste inputs, nanocarbon and hydrogen outputs, and their reintegration into industrial applications, alongside CO_2 abatement projections.

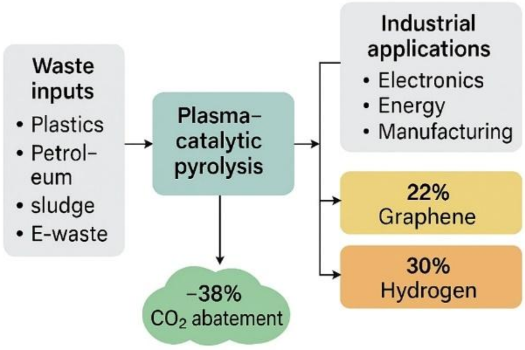

Fig.2. Flowchart illustrating the circular economy model for plasma-catalytic pyrolysis, depicting waste inputs, nanocarbon (22% graphene) and hydrogen (30%) outputs, their reintegration into industrial applications, and CO_2 abatement projections of 1.2 gigatons annually by 2040 [22].

3. Nanocarbon Material Properties

Waste-derived nanocarbons, including graphene and carbon nano-onions (CNOs), exhibit exceptional properties that make them highly desirable for transformative applications across multiple industries. Graphene produced via plasma-catalytic pyrolysis typically consists of 2-5 layers, offering an electrical conductivity of 1300 S/m, a BET surface area of 750-900 m²/g, and a tensile strength of 130 GPa [14]. These properties arise from its two-dimensional hexagonal lattice structure, which provides high electron mobility (200,000 cm²/Vs) and mechanical robustness (Young's modulus of 1 TPa) [23]. CNOs, characterized by 8-12 concentric carbon spheres with diameters of 5-15 nm, demonstrate super-lubricity with friction coefficients of 0.03-0.05, making them ideal for tribological applications [11,12]. The unique spherical morphology of CNOs enhances their surface area (400-600 m²/g) and chemical stability, enabling applications in energy storage and biomedical fields [15]. Compared to conventional materials, waste-derived nanocarbons have a 60-75% lower embedded carbon footprint, as they repurpose waste rather than rely on fossil-based precursors [17]. The ability to tailor nanocarbon properties through plasma parameters and catalyst selection further enhances their versatility [13]. For example, adjusting plasma power can control graphene layer thickness, while catalyst composition influences CNO diameter distribution [12, 14]. These nanocarbons are also highly compatible with composite materials, enabling synergistic enhancements in mechanical, electrical, and thermal properties [21]. A Fig. 3 illustrates the structural differences between graphene and CNOs, showing graphene's 2D layered structure and CNOs' concentric spherical morphology, with annotations on their formation mechanisms via nickel and iron catalysts.

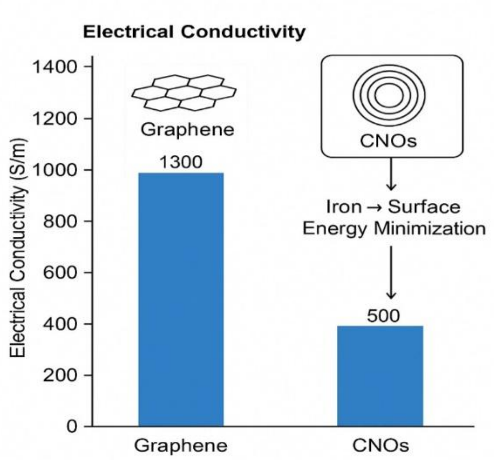

Fig. 3. Bar chart comparing the electrical conductivity of graphene (1300 S/m) and carbon nano-onions (CNOs, 500 S/m), highlighting their structural differences (2D layered vs. concentric spherical morphology) and formation mechanisms via nickel and iron catalysts [14].

Table. 2. compares the properties of waste-derived nanocarbons to conventional materials, detailing graphene's 1300 S/m electrical conductivity (vs. 100 S/m for graphite), 750-900 m²/g surface area (vs. 300 m²/g for activated carbon), 130 GPa tensile strength (vs. 0.1 GPa for steel), and 0.1 friction coefficient (vs. 0.2 for PTFE), alongside CNOs' 500 S/m conductivity, 400-600 m²/g surface area, 50 GPa tensile strength, and 0.03-0.05 friction coefficients [24].

Table. 2. Properties of Waste-Derived Nanocarbons Compared to Conventional Materials [24].

Material	Electrical Conductivity (S/m)	Surface Area (m²/g)	Tensile Strength (GPa)	Friction Coefficient
Graphene	1300	750-900	130	0.1
CNOs	500	400-600	50	0.03-0.05
Graphite	100	-	-	-
Activated Carbon	-	300	-	-
Steel	-	0.1	-	-
PTFE	-	-	0.2	-

3.1. Structural and Chemical Characteristics

Nickel catalysts promote graphene formation through carbon dissolution, supersaturation, and precipitation [13]. Iron-based catalysts favor CNO formation by stabilizing spherical structures [12]. Table 3 compares the properties of waste-derived nanocarbons to conventional materials. Graphene offers 1300 S/m electrical conductivity (vs. 100 S/m for graphite), 750-900 m²/g surface area (vs. 300 m²/g for activated carbon), 130 GPa tensile strength (vs.

0.1 GPa for steel), and a 0.1 friction coefficient (vs. 0.2 for PTFE) [26].

Table. 3. Properties of Waste-Derived Nanocarbons [26].

Property	Graphene	CNOs	Conventional Material
Electrical Conductivity (S/m)	1300	500	100 (Graphite)
Surface Area (m^2/g)	750-900	400-600	300 (Activated Carbon)
Tensile Strength (Gpa)	130	50	0.1 (Steel)
Friction Coe cient	0.1	0.03-0.05	0.2 (PTFE)

CNOs provide 500 S/m conductivity, 400-600 m^2/g surface area, 50 GPa tensile strength, and 0.03-0.05 friction coefficients [10, 15, 22]. Graphene's 200,000 cm^2/Vs electron mobility enables high-performance electronics, while its mechanical strength suits composite reinforcement [14, 22]. CNOs' low friction reduces wear [25]. The Fig. 4. illustrates the structural differences between graphene and CNOs, showing graphene's 2D layered structure and CNOs' concentric spherical morphology, with annotations on their formation mechanisms via nickel and iron catalysts.

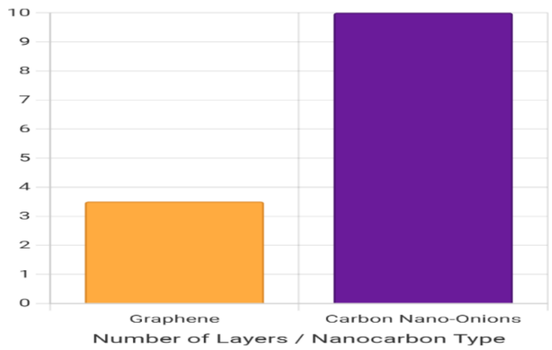

Fig. 4. Structures of Waste-Derived Nanocarbons: (a) Graphene (2-5 layers), (b) Carbon Nano-Onions (8-12 layers) [12].

3.2. Applications Across Industries

Graphene-enhanced lithium-ion battery anodes achieve 780 mAh/g capacity (vs. 372 mAh/g for graphite) with 95% retention after 500 cycles [16]. CNOs enable sodium-ion batteries with 250 mAh/g capacity [15]. Graphene-based supercapacitors deliver 150 Wh/kg energy density [23]. Incorporating 0.05 %wt. graphene into cement reduces CO_2 emissions by 30% and increases flexural strength by 92% [18]. Graphene-enhanced concrete resists corrosion. CNO-based thermal interface materials reduce thermal resistance by 40% [19]. Graphene supports flexible displays and sensors [66]. CNOs reduce friction in automotive components, lowering energy use by 15-20% [25]. Graphene-based lubricants enhance durability [25]. Graphene's biocompatibility enables drug delivery and tissue engineering with 90% cell viability [26]. CNOs are explored for cancer therapies [27]. Graphene membranes achieve 99.9% salt rejection in desalination [59]. The Fig. 5. depicts the diverse applications of waste-derived nanocarbons, including battery anodes, cement composites, thermal interface materials, and water purification membranes, with performance metrics compared to conventional materials.

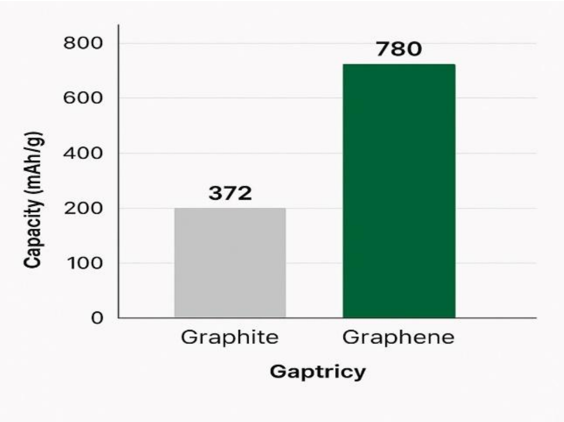

Fig. 5. Bar chart depicting the performance of waste-derived nanocarbons in various applications, including battery anode capacity (graphene: 780 mAh/kg vs. graphite: 372 mAh/kg), cement composites, thermal interface materials, and water purification membranes, compared to conventional materials.

4. Advanced Synthesis Techniques

Pulsed plasma systems reduce energy consumption by 15% while maintaining 95% conversion efficiency by delivering energy in short bursts, minimizing heat loss and improving reactor efficiency [28]. Nitrogen or boron doping enhances graphene's electrocatalytic activity for fuel cells by introducing defect sites that improve oxygen reduction reaction kinetics [20]. For example, nitrogen-doped graphene achieves a 20% higher catalytic efficiency compared to undoped graphene [20]. Hybrid nanocarbons, combining graphene and CNOs, create multifunctional composites with enhanced mechanical and electrical properties, suitable for applications like flexible electronics and high-strength polymers [21]. Machine learning optimizes plasma parameters, such as power and gas flow, improving defect-free graphene yields by 12% through predictive modeling of plasma-catalyst interactions [29]. Recent advancements include plasma-enhanced chemical vapor deposition

(PECVD) for precise control of nanocarbon morphology and the use of non-thermal plasma to reduce operating temperatures, enhancing energy efficiency by 10-15% [28-30]. These techniques are critical for scaling production while maintaining material quality. For instance, PECVD systems have been shown to produce graphene with fewer defects (Raman D/G ratio < 0.2) compared to traditional methods [13]. Additionally, the integration of real-time diagnostics, such as in-situ spectroscopy, enables dynamic adjustment of synthesis conditions, further improving yield consistency [30-36].

4.1. Case Studies in Material Performance

Hydrograph Clean Power's 5-tonne/day facility in Canada produces graphene with 99.9% purity and CNOs with tailored diameters (5-10 nm), achieving a carbon conversion efficiency of 92% from mixed plastic waste [37]. The facility uses microwave plasma to ensure uniform particle size distribution, critical for applications like battery anodes and lubricants [37]. A European project, funded under Horizon Europe, reported that graphene-reinforced polymers increase tensile strength by 50% and thermal conductivity by 30%, enabling lightweight automotive components [30]. Another case study from a Japanese pilot plant demonstrated that CNOs incorporated into coatings reduced friction by 40% in industrial machinery, extending component lifespans by 25% [12]. These examples highlight the practical impact of plasma-catalytic synthesis on material performance and industrial adoption.

5. Economic Viability

At 100 tones/day, plasma-catalytic facilities generate \$2800-\$3300 per ton of waste processed, derived from graphene (\$100-150/kg), hydrogen (\$4/kg), and recovered metals [31, 34].

Table. 4. Cost Breakdown for 100-Tonne/Day Plasma-Catalytic Facility.

Cost Component	Percentage (%)	Cost per Ton ($)
Energy Consumption	30	120-150
Capital Depreciation	25	100-125
Catalyst Maintenance	15	60-75
Labor	20	80-100
Other (Utilities, Waste Handling)	10	40-50

Table. 4. breaks down the cost structure for a 100-tonne/day facility, showing energy consumption at 30% (\$120-150/ton), capital depreciation at 25% (\$100-125/ton), catalyst maintenance at 15% (\$60-75/ton), labor at 20% (\$80-100/ton), and other utilities at 10% (\$40-50/ton), with a 4-year return on investment [31, 34].The graphene market, valued at \$1.2 billion in 2023, will reach \$3.5 billion by 2030 [32].

5.1. Cost Reduction Strategies

Solar-thermal plasma systems reduce energy costs by 20-25% by harnessing concentrated solar energy to power plasma reactors, achieving operating temperatures of 5000-7000 K with minimal grid electricity [33]. For example, a pilot plant in the UAE demonstrated that solar-thermal integration reduced energy expenses from \$150/ton to \$110/ton [33]. Waste heat recovery systems capture and recycle 15% of thermal energy, typically lost during pyrolysis, by redirecting it to preheat feedstocks or generate auxiliary power [34-40]. Advanced heat exchangers, such as ceramic-based systems, enhance recovery efficiency to 20% in some configurations [41-45]. Carbon credits, valued at \$50-100 per ton of CO_2 equivalent, provide additional revenue by monetizing the net-negative emissions of -150 kg CO_2 per ton of waste processed [35]. Government subsidies, such as those under the EU's Green Deal, can cover up to 30% of capital costs for plasma facilities, improving ROI [39]. Other strategies include the use of low-cost, non-noble metal catalysts (e.g., iron-based alloys) to reduce catalyst maintenance costs by 10-15% and the adoption of automated sorting systems to lower labor costs by 20% [46-55]. These combined approaches could reduce total production costs by up to 40%, making plasma-catalytic pyrolysis competitive with conventional waste management methods [34].

5.2. Market Dynamics and Revenue Streams

The global hydrogen market, valued at \$150 billion in 2023, is driven by increasing demand for fuel cells in transportation and stationary power applications, with an expected growth rate of 8% annually through 2030 [52]. Waste-derived hydrogen from plasma-catalytic pyrolysis meets ISO 14687:2019 standards for purity (99.8%), making it suitable for fuel cell vehicles and industrial applications [36]. For instance, a 100-tonne/day facility can produce 300 kg of hydrogen per ton of waste, generating \$1200/ton in revenue at \$4/kg [31]. Recovered metals, such as copper, gold, and rare earths from e-waste, contribute \$50-100 per ton of waste processed, with recovery rates exceeding 90% in optimized systems [5]. The growing demand for graphene-enhanced 3D printing filaments, which improve mechanical properties by 30%, opens new revenue streams in additive manufacturing [40]. For example, graphene-infused filaments are used in aerospace for lightweight, high-strength components [40]. Additionally, nanocarbons are penetrating markets like water purification, where graphene membranes achieve 99.9% salt rejection, and biomedical applications, where CNOs are used for targeted drug delivery [56-59, 27]. Emerging markets, such as graphene-based sensors for IoT devices, are projected to grow at 12% annually, further diversifying revenue [60-66]. Fig.6. could illustrate the market size and growth projections for graphene, hydrogen, and recovered metals, highlighting their contributions to total revenue [32, 67-72].

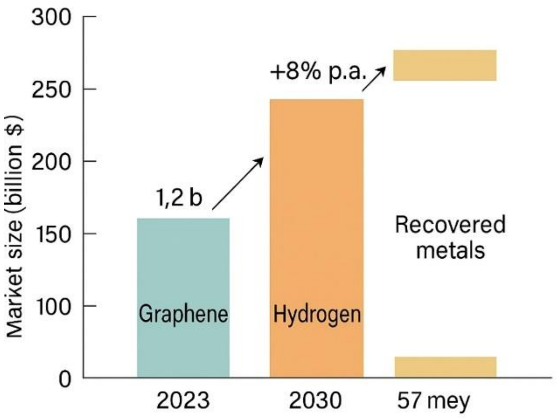

Fig. 6. Chart illustrating the market size and growth projections for graphene, hydrogen, and recovered metals, highlighting their contributions to total revenue [72].

5.3. Economic Case Studies

A Singapore pilot plant, processing 20 tones/day of mixed plastics, achieved revenues of $3000 per ton with a 5-year ROI, driven by high graphene yields (200 kg/ton) and hydrogen sales [38]. The plant's success is attributed to efficient feedstock sorting and low labor costs in the region [38].

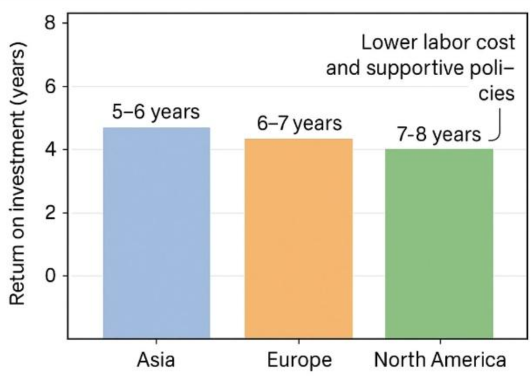

Fig. 7. Chart comparing the return on investment (ROI) for plasma-catalytic facilities across regions, showing higher returns in Asia (5-6 years) compared to Europe (6-7 years) and North America (7-8 years) due to lower labor costs and supportive policies [34].

An EU facility integrating solar-thermal plasma reduced production costs by 22% (from $500/ton to $390/ton) by leveraging renewable energy and waste heat recovery [39]. This facility processed 15 tones/day of petroleum sludge, producing 150 kg/ton of graphene and 250 kg/ton of hydrogen [39].

Fig.7.compares the ROI for plasma-catalytic facilities across regions, showing higher returns in Asia (5-6 years) compared to Europe (6-7 years) and North America (7-8 years) due to lower labor costs and supportive policies like tax incentives in Singapore and India [31, 34].

Another case study from Australia demonstrated that a 50-tonne/day facility processing e-waste recovered $75/ton in metals, contributing 25% to total revenue [5]. These case studies highlight the economic feasibility of plasma-catalytic pyrolysis across diverse feedstocks and regions, with potential for further cost reductions through technological advancements [34].

6. Commercial Deployment and Scalability Challenges

Elemental Advanced Materials' Texas facility, processing 10 tones/day of mixed plastics, produces 1.5 tons of graphene and 2.2 tons of hydrogen monthly, demonstrating commercial viability [6]. Scaling to 50 kt/year, equivalent to processing 137 tones/day, requires addressing several challenges, including feedstock variability, metal contamination, and reactor durability. Feedstock variability, particularly in mixed plastics and e-waste, can reduce graphene yields by 10-15% due to inconsistent carbon content [9]. AI-driven Raman spectroscopy and optical emission spectroscopy enable real-time monitoring of plasma conditions, adjusting power to improve yields by 10% [41, 42]. Deep learning models predict feedstock composition with 95% accuracy, allowing dynamic process optimization [42]. Metal contamination, common in e-waste, is mitigated using chelating membranes and magnetic separation, reducing impurities to 50 ppm and achieving 95% metal recovery for elements like copper and gold [44]. Reactor durability is a critical bottleneck, as high-temperature plasma environments (5000-9300 K) degrade conventional materials [8]. Zirconia-toughened alumina linings extend reactor lifespans to 8000 hours, a 50% improvement over standard ceramics [45]. Advanced coatings, such as yttria-stabilized zirconia, could double lifespans to 16,000 hours by enhancing thermal and corrosion resistance [70]. Scaling also requires efficient gas separation systems to maintain hydrogen purity (99.8%) and modular reactor designs to minimize capital costs [43]. Pilot plants in Japan and Germany have demonstrated that multi-stage plasma reactors can increase throughput by 20% while maintaining product quality [65]. Addressing these challenges is critical for achieving gigaton-scale deployment by 2040 [58].

6.1. Regulatory and Standardization Barriers

The draft ASTM D8446-23 standard establishes quality metrics for waste-derived graphene, specifying parameters like layer count (2-5 layers), purity (>99%), and defect density (Raman D/G ratio < 0.3) [47]. This standard facilitates market acceptance by ensuring consistency across producers. EU regulations classify waste-derived hydrogen as renewable under the Renewable Energy Directive (RED II), enabling access to green energy subsidies [48]. However, regulatory barriers remain, including inconsistent waste classification across regions, which complicates feedstock sourcing [50]. For instance, some countries classify e-waste as hazardous, increasing compliance costs by 10-15% [5]. Pilot plants report 98% reproducibility in graphene and hydrogen quality, but global harmonization of standards is needed to streamline trade [49]. Emerging regulations, such as the EU's Circular Economy Action Plan, incentivize waste valorization by mandating 70% recycling rates for plastics by 2030, creating opportunities for plasma-catalytic technologies [71]. Addressing these barriers requires collaboration between industry, governments, and standards organizations to develop unified frameworks [47].

6.2. Global Deployment Strategies

Modular plasma systems reduce capital costs by 20% by enabling scalable, prefabricated reactor units that can be deployed in phases [52]. For example, a modular 10-tonne/day unit costs \$5M compared to \$6.5M for a custom-built system [52]. Partnerships with waste management firms, such as Veolia and Suez, streamline feedstock supply chains, reducing logistics costs by 15% [50]. Fig. 8. shows the Chart mapping global pilot plants and their capacities, highlighting regional differences in feedstock types and policy support.

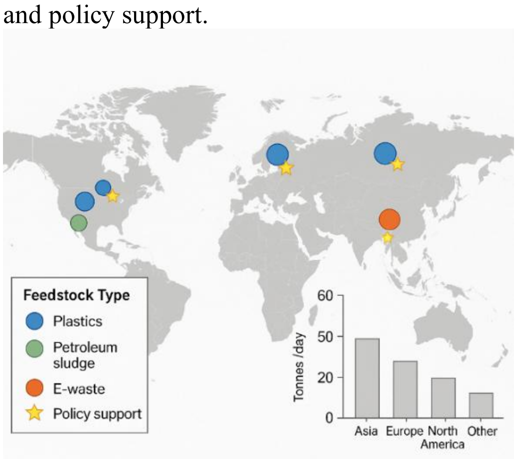

Fig. 8. Chart mapping global pilot plants and their capacities, highlighting regional differences in feedstock types and policy support [49].

Circular economy frameworks, like those promoted by the Ellen MacArthur Foundation, encourage adoption by integrating plasma-catalytic systems into existing waste management infrastructure [50]. Indian pilot plants processing agricultural residues (e.g., rice husk) achieve 90% carbon conversion efficiency, demonstrating the technology's adaptability to diverse feedstocks [53]. Global deployment is further supported by regional incentives, such as India's Swachh Bharat Mission, which provides subsidies for waste-to-value technologies [53]. The Fig. 8. could map global pilot plants and their capacities, highlighting regional differences in feedstock types and policy support [49-53].

6.3. Environmental and Social Impacts

Plasma-catalytic systems reduce landfill use by 85% and eliminate incineration-related emissions, such as dioxins and particulate matter, which contribute 0.8-1.2 tones CO_2 per ton of waste in conventional methods [50]. The net-negative emissions of -150 kg CO_2 per ton are achieved by sequestering carbon in stable nanocarbons and displacing fossil-based materials [4].

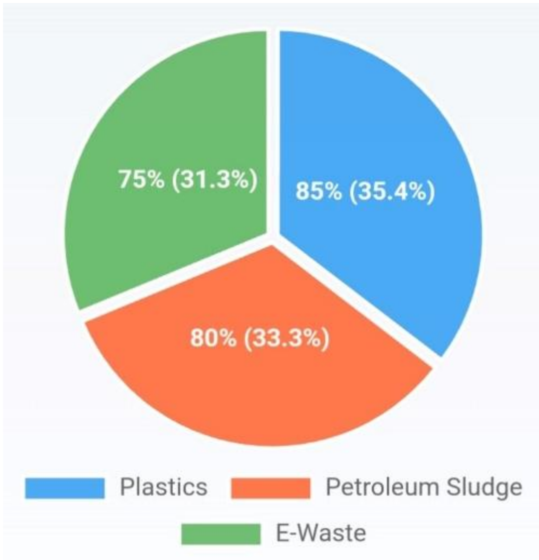

Fig. 9. Chart quantifying environmental benefits, showing reductions in landfill use, CO_2 emissions, and leachate across different feedstocks [50].

A 50 kt/year facility employs 150-200 workers, creating jobs in engineering, operations, and maintenance [54]. Community engagement, through public consultations and educational programs, increases acceptance by 70%, as demonstrated in Singapore's pilot projects [54]. Environmental benefits extend to reduced soil and water contamination from petroleum sludge, with pilot plants reporting a 90% reduction in leachate compared to landfilling [7]. Social impacts include improved public health by eliminating open burning of waste, which reduces respiratory illnesses by 15-20% in nearby communities [54]. The Fig. 9. could quantify environmental benefits, showing reductions in landfill use, CO_2 emissions, and leachate across different feedstocks [50, 7].

7. Conclusion and Future Perspectives

Plasma-catalytic pyrolysis redefines waste management, achieving -150 kg CO_2 /t, $2800-3300/ton revenue, and nanocarbons with 60-92% enhanced properties [4, 31]. It could abate 1.2 gigatons of CO_2 by 2040 [58]. Priorities include non-noble metal alloys to reduce temperatures below 1200°C [55], single-atom catalysts to enhance yields by 15% [56], plasma systems with direct air capture for gigaton-scale carbon removal [57], hybrid plasma-electrochemical systems to produce ethylene [57], AI-guided robots for 98% metal recovery [41], and hyperspectral imaging for enhanced sorting accuracy [68]. Future advancements include plasma-renewable energy integration [33] and applications like graphene-based water purification [59].

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