



HAL
open science

Yttrium speciation variability in bauxite residues of various origins, ages and storage conditions

Julien Couturier, Pierre Tamba Oularé, Blanche Collin, Claire Lallemand, Isabelle Kieffer, Julien Longerey, Perrine Chaurand, Jérôme Rose, Daniel Borschneck, Bernard Angeletti, et al.

► To cite this version:

Julien Couturier, Pierre Tamba Oularé, Blanche Collin, Claire Lallemand, Isabelle Kieffer, et al.. Yttrium speciation variability in bauxite residues of various origins, ages and storage conditions. 2023. hal-04290788v1

HAL Id: hal-04290788

<https://hal.science/hal-04290788v1>

Preprint submitted on 17 Nov 2023 (v1), last revised 17 Nov 2023 (v3)

HAL is a multi-disciplinary open access archive for the deposit and dissemination of scientific research documents, whether they are published or not. The documents may come from teaching and research institutions in France or abroad, or from public or private research centers.

L'archive ouverte pluridisciplinaire **HAL**, est destinée au dépôt et à la diffusion de documents scientifiques de niveau recherche, publiés ou non, émanant des établissements d'enseignement et de recherche français ou étrangers, des laboratoires publics ou privés.

1 Yttrium speciation variability in bauxite
2 residues of various origins, ages and
3 storage conditions

4

5 **Julien COUTURIER**^{1*}, Pierre Tamba Oularé^{1,2}, Blanche Collin¹, Claire Lallemand¹, Isabelle
6 Kieffer³, Julien Longerey¹, Perrine Chaurand¹, Jérôme Rose¹, Daniel Borschneck¹, Bernard
7 Angeletti¹, Stéven Criquet⁴, Renaud Podor⁵, Hamed Pourkhorsandi⁶, Guilhem Arrachart⁵, Clément
8 Levard^{1**}

9 ¹Aix-Marseille Univ, CNRS, IRD, INRAE, CEREGE, 13545 Aix-en-Provence, France

10 ²ISMGB, BP 84 Boké, République de Guinée

11 ³OSUG, Université Grenoble-Alpes, CNRS, Grenoble, France

12 ⁴Aix-Marseille Univ, Avignon Université, CNRS, IRD, IMBE, Marseille, France

13 ⁵ICSM, Univ Montpellier, CEA, CNRS, ENSCM, Marcoule, France

14 ⁶Laboratoire G-Time, Université Libre de Bruxelles, CP 160/02, 50, Av. F.D. Roosevelt, 1050,
15 Brussels, Belgium

16

17 *couturier@cerege.fr

18 **levard@cerege.fr

19 **Abstract**

20

21 Bauxite residues (BRs) are highly alkaline wastes generated during alumina production from
22 bauxite ore. Billions of tons have been accumulating worldwide for more than 100 years, they are stored
23 in various forms, and pose environmental and societal issues. At the same time, BRs are promising
24 secondary sources for the production of critical metals including rare earth elements (REEs). However,
25 knowledge on REE speciation is lacking, and is consequently an obstacle to the development of large-
26 scale extraction process.

27 This study analyses the influence of origin of the bauxite ore (lateritic or karstic), the storage
28 conditions and storage time on the properties of ten BR samples, with a particular focus on the speciation
29 of yttrium, which is used as a proxy to identify the behaviour of heavy REE.

30 A multi-scale approach linked yttrium speciation and the origin of the bauxite ore whereas no major
31 variation was observed as a function of storage conditions or ageing of the BRs. Yttrium is mainly found
32 in the form of xenotime phosphate particles in BRs of lateritic origin, while in karstic BRs, the majority
33 of yttrium is probably adsorbed or incorporated into other minerals including iron oxyhydroxide and
34 hydroxyapatite minerals.

35 1. Introduction

36

37 The global demand for metals is constantly increasing, both in terms of quantity and diversity
38 (OECD, 2019; Zepf et al., 2014). This increase is linked to the growth of the world's population and
39 also to the emergence of new societal needs, which consume large quantities of these resources. This is
40 particularly true for sectors such as defense and the digital and environmental transition which makes
41 some metals with specific physico-chemical properties highly strategic (European Commission, 2020;
42 International Energy Agency, 2021) or even “critical” for a number of non-producing countries (British
43 Geological Survey, 2015; Grohol & Veeh, 2023; Hatayama & Tahara, 2014; U.S. Geological Survey,
44 2022).

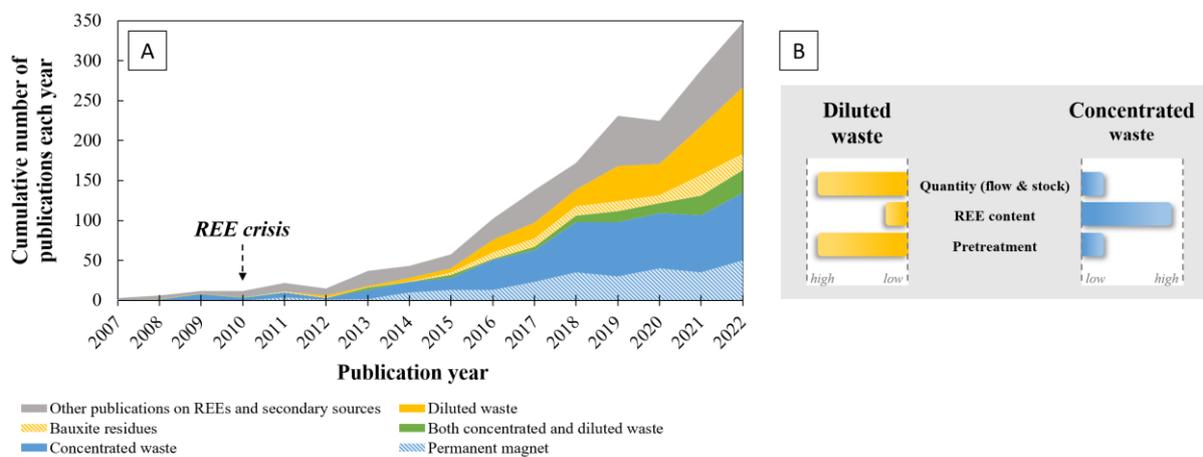
45 Rare earth elements (REEs), considered as one of the most critical elements according to European and
46 American agencies (Grohol & Veeh, 2023; U.S. Geological Survey, 2022), are the focus of particular
47 attention. The REE group includes metals from the lanthanide family ($Z = 57 - 71$), as well as yttrium
48 (Y, $Z = 39$) and scandium (Sc, $Z = 21$) due to their similar physico-chemical properties. REEs are usually
49 subdivided into two subgroups, light rare earth elements (LREEs), comprising lanthanides from
50 lanthanum (La, $Z = 57$) to europium (Eu, $Z = 63$) and heavy rare earth elements (HREEs), including Y
51 and lanthanides from gadolinium (Gd, $Z = 64$) to lutetium (Lu, $Z = 71$). This arbitrary distinction has no
52 scientific basis because there is no clear physico-chemical separation between these groups, rather a
53 progressive change in properties and behaviours, including in ionic radii (Gschneidner, 1990). Their
54 particular electronic configuration gives them specific electromagnetic properties, making them
55 essential for many applications in electronics, manufacturing, medicine, and renewable energy, among
56 others (Balaram, 2019). China controls almost the entire REE value chain (Gauß Roland et al., 2021),
57 making the supply of REEs worldwide extremely vulnerable, as revealed in 2010, when China's quota
58 policy causes a “REE crisis” in Europe and the US (Chen & Zheng, 2019).

59 Beyond these economic and geopolitical considerations, primary extraction also poses often neglected
60 environmental and social problems (Eheliyagoda et al., 2020), due to the huge quantities of energy
61 required and of waste generated (Adewuyi et al., 2020; Farjana et al., 2019), as well as social conflicts
62 and accidents (Goodland, 2012; Scheidel et al., 2020). All these impacts are further amplified by the
63 general decline in ore grades (Prior et al., 2012).

64 Faced with the ever-increasing demand for critical metals, the depletion of resources and the
65 environmental and social crises associated with their extraction, a paradigm shift is urgently needed for
66 the sustainable production of these metals. In particular, in the context of circular economy, there is a
67 need to develop processes for extracting metals from secondary sources.

68 Since 2010 and the “REE crisis”, the search for secondary sources of REEs has become a hot research
69 topic with almost 350 papers published in 2022 whereas before 2010, fewer than 10 papers were
70 published on this topic per year (**Figure 1 A**). This vast literature can be divided into two main

71 categories. First, papers related to concentrated wastes (i.e. that contain REE concentrations above 1
 72 wt%), which consist mainly in end-of-life products or product manufacturing scraps, and account for
 73 the majority of publications. In this category, permanent magnets are the most widely studied followed
 74 by waste from electrical and electronic equipment (WEEE), batteries, phosphors, catalysts or polishing
 75 powders (Belfqueh et al., 2022; Ramprasad et al., 2022; Yang et al., 2013). Second, diluted wastes (i.e.
 76 that contain REE concentration below 1 wt%) are usually more complex matrices (Binnemans et al.,
 77 2015) that are potentially more difficult to exploit given the low concentrations of REEs but which also
 78 attract considerable attention. This category includes mining and industrial wastes such as bauxite
 79 residues (BRs), phosphogypsum, coal fly ash, acid mine drainage, mine tailings or wastewater
 80 (Binnemans et al., 2015; Dupont & Binnemans, 2015; Hermassi et al., 2022; Peiravi et al., 2021). In this
 81 category, BRs are one of the most frequently cited and studied as a potential source for REEs (20-35%
 82 of identified papers in the last five years).



93 **Figure 1:** (A) Evolution of cumulative number of scientific papers containing “rare earth elements” and “secondary
 94 sources” keywords, from 2007 and 2022, separated into several categories (source Web of Science). The “Concentrated
 95 waste” category contains the keywords: “magnet”, “WEEE”, “phosphor”, “battery”, “catalyst”, “polishing waste”. The
 96 “Diluted waste” category contains the keywords: “Bauxite residues”, “phosphogypsum”, “coal fly ash”, “mine drainage”,
 97 “mine tailings”, “wastewater”. (B) Conceptual scheme of the difference in properties in diluted and concentrated waste.

100 Bauxite residues (BRs), also known as “red mud” when hydrated, are wastes generated during the
 101 production of alumina using the Bayer process. During this process, the primary bauxite ore, rich in
 102 aluminium (Al), is digested with concentrated soda under pressure, leaving a highly alkaline and sodic
 103 residue at the end of the process. BRs are mainly composed of iron oxide but also contain a cocktail of
 104 toxic and critical metals (Borra et al., 2016; Smith, 2009). REEs, which are naturally present in bauxite
 105 ore, are concentrated in BRs as a result of the Bayer process and can reach more than 2500 mg/kg (2500
 106 ppm) (Qu & Lian, 2013; Rayzman, 1998; Wagh & Pinnock, 1987), which makes BRs a potentially
 107 good secondary source (Deady et al., 2014) with many advantages over concentrated waste (**Figure 1**
 108 B). First, BRs represent a huge potential reserve of REEs: for every ton of alumina produced, between

109 1 and 2 tons of BRs are generated (Borra et al., 2016). Today, it is estimated that approximately 170 Mt
110 of BRs are generated each year, i.e. producing a global stockpile exceeding 4 billion tons (Evans, 2016;
111 International Aluminium Institute, 2023). These stocks are generally easily accessible, as they are
112 located in storage sites close to alumina plants. Moreover, with their very fine granulometry (Gräfe et
113 al., 2011), BRs require little grinding pre-treatment, which is often described as the most energy-
114 consuming stage of the primary extraction processes (Adewuyi et al., 2020).

115 However, although this residue appears to be an interesting alternative for the production of REEs, the
116 variability of the physico-chemical properties of these residues is an obstacle to the development of a
117 universal process of REE extraction. Several parameters may cause physico-chemical variations in the
118 stocks of BRs available worldwide. First, essentially two types of bauxite ores are used as inputs in the
119 Bayer process: lateritic bauxites, which account for 90% of the mineable reserves, and karstic (or karst)
120 bauxites (Freyssinet et al., 2005). Both derive from similar processes of alteration and sedimentation
121 (weathering, transportation and deposition), leading to the formation of an Al-rich ore. The difference
122 lies in their bedrock lithology: lateritic bauxite deposits overlie aluminosilicate rocks while karstic
123 deposits overlie carbonate rocks (Bardossy, 1982). Second, differences in the efficiency of the Bayer
124 process due to different Al mineralogy depending on the type or quality of the bauxite ore and variability
125 in the implementation of the Bayer process, may result in variable amounts of Al remaining in the mine
126 tailings. The conditions and time of storage of the residues may also affect their physico-chemical
127 properties. When not directly discharged into the seas and oceans, BRs are stored in different ways
128 ranging from dry storage in the open air to storage in the form of sludge in retention ponds (Evans, 2016;
129 Fourrier, 2020; Power et al., 2011). Aging of BRs can also induce physico-chemical variability since
130 some residue deposits may be more than 100 years old: the Bayer process was invented at the end of the
131 19th century (Borra et al., 2016). Consequently, treatment or remediation attempts (cover layers, organic
132 or inorganic amendment, etc.) have been undertaken at many sites sometimes leading to revegetation of
133 the site despite particularly hostile conditions for life (Di Carlo et al., 2019).

134 This variability also results in marked differences in chemical composition and mineralogy as reported
135 in the literature (Borra et al., 2016; Evans, 2016; Ma et al., 2022; Xue et al., 2016). Although the
136 chemical and mineralogical variability is fairly well documented for major elements such as Fe and Al,
137 very little information is available on REE speciation (i.e., the chemical environment) in BRs. Also,
138 most studies that do address REE speciation are based on a microscopic approach (using electron probe
139 microanalyses (EPMA) or scanning electron microscopy coupled with energy dispersive X-ray
140 spectrometry (SEM/EDS)) and rely on elemental co-localization to identify REE bearing phases, which
141 are based on assumptions, rather than on direct speciation analyses (Gentzmann et al., 2021;
142 Ochsenkiihn-Petropulu et al., 1996; Rivera et al., 2019; Vind et al., 2018). In addition, existing studies
143 rarely investigate the influence of origin of the bauxite ore, or the time and conditions of storage of BRs.
144 Indeed, detecting low concentration phases and elements in such complex matrices is far from easy, plus
145 detailed characterisation of REEs in BRs requires state of the art facilities such as synchrotron sources.

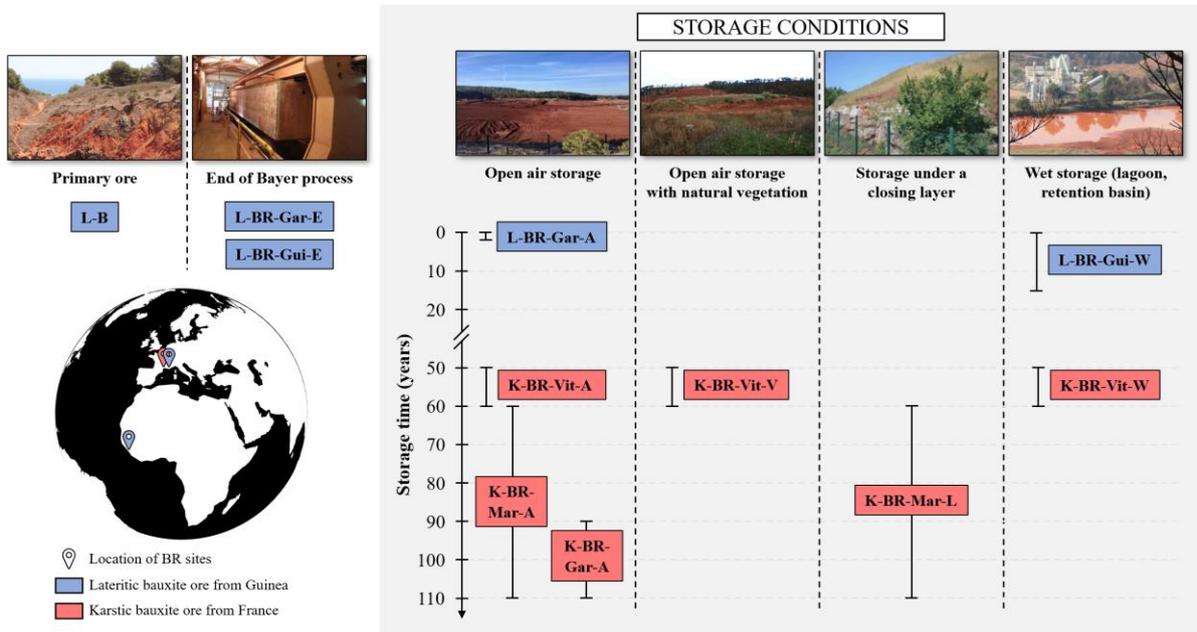
146 In the present study, the physico-chemical properties, chemical composition, mineralogy and yttrium
147 speciation of ten BR samples with different origins, ages and storage conditions were characterised.
148 Yttrium was used as a proxy for HREEs thanks to its similar physico-chemical behaviour (Borst et al.,
149 2020; Lallemand et al., 2022; Pingitore et al., 2014). Improving knowledge of the REE speciation in
150 BRs and the factors that influence it will pave the way for the development of extraction processes that
151 account for the specificity of the targeted BRs in terms of origin, storage conditions and time (Deady et
152 al., 2014). Such perspectives are discussed in light of our results.

153

154 **2. Materials and methods**

155 **2.1. Materials and sampling**

156
157
158
159
160
161
162
163
164
165
166
167



168 *Sample nomenclature :*
 169 L/K: lateritic/karstic origin
 170 B/BR: Bauxite ore/Bauxite residue
 171 Gar/Gui/Mar/Vit: abbreviations for Gardanne/Guinea/Marseille/Vitrolles collection site
 172 E/A/V/L/W: end of process/open air storage/open air with vegetation/storage under closing layer/wet storage

170 **Figure 2:** Presentation of the study samples according to the origin of the ore, age, storage conditions and associated
 171 nomenclature

172

173 The sample bauxite residues were categorized in two types: those generated from a lateritic-type
 174 bauxite ore located in Guinea (Boké region), and those generated from a karstic-type bauxite ore located
 175 in the south of France (Provence region), hereafter referred to respectively as “lateritic BRs” and “karstic
 176 BRs” for the sake of simplicity. These ten residues were collected from four different tailing sites: three
 177 in France (Gardanne “Gar”, Vitrolles “Vit”, Marseille “Mar”) and one site in Guinea “Gui” (Fria plant
 178 site) from three alumina production plants which use the Bayer process. Samples were collected at
 179 several places: (i) directly at the end of the alumina extraction process (E suffix), after the filter press
 180 (L-BR-Gar-E) or the last scrubber (L-BR-Gui-E), (ii) from open-air storage sites (A suffix) at the surface
 181 (maximum 30 cm depth) of the deposits (L-BR-Gar-A, K-BR-Vit-A, K-BR-Mar-A, K-BR-Gar-A), one
 182 of which in a heavily vegetated area (suffix V) (K-BR-Vit-V), (iii) from a storage site under a vegetated
 183 capping layer (suffix L), at a depth of 1 m below the surface (K-BR-Mar-L) and (iv) from wet storage
 184 sites (suffix W) as lagoon or retention basin (L-BR-Gui-W, K-BR-Vit-W). The storage conditions and
 185 aging times (from 0 to 100 years) of the residues are detailed in **Table 1** and **Figure 2**.

186 The initial lateritic bauxite ore (L-B) sample was supplied by Alteo company, a producer of alumina at
 187 the Gardanne site which, at that time, used lateritic bauxite ores imported from Guinea. No bauxite ore
 188 of karstic origin representative of the studied karstic BR samples was used in the present study because

189 either the plant concerned had closed down or the supply had been switched to lateritic bauxite ores, as
190 was the case in Gardanne between the 1970s and 1990s (Arnaud & Guillon, 1989).
191 Before the experiments began, all the samples were dried at between 60-70 °C then manually ground to
192 < 125 µm using an agate mortar and homogenized. The resulting dry materials were stored at ambient
193 pressure and temperature.

Table 1: Detailed description of the samples cited in this article

Name of sample	Type of sample	Origin of bauxite	Plant	Sampling location	Storage conditions	Some known detailed conditions	Storage time
L-B	Bauxite ore	Lateritic (Guinea)	/	*	/	/	/
L-BR-Gui-E	Bauxite residue	Lateritic (Guinea)	Fria plant (Guinea)	At the plant (end of process)	End of Bayer process (after the last scrubber)	/	/
L-BR-Gui-W	Bauxite residue	Lateritic (Guinea)	Fria plant (Guinea)	Dote dam, Guinea	Wet storage (Tropical climate)	/	~0-15 years***
L-BR-Gar-E	Bauxite residue	Lateritic (Guinea)	Gardanne plant (France)	At the plant (end of process)	End of Bayer process (after the filter press)	/	/
L-BR-Gar-A	Bauxite residue	Lateritic (Guinea)	Gardanne plant (France)	Gardanne tailing site (Mange-Garri)	Storage in the open air (Mediterranean climate)	Occasional watering / BR was mixed with compost at this location	~1 year
K-BR-Gar-A	Bauxite residue	Karstic (France)	Gardanne plant (France)	Gardanne tailing site (Mange-Garri)	Storage in the open air (Mediterranean climate)	Occasional watering / soil amendment in the 1960's / light vegetation cover	~ 90 -110 years**
K-BR-Mar-A	Bauxite residue	Karstic (France)	Saint-Louis-les-Aygalades plant (France)	Marseille tailing site (La Delorme)	Storage in the open air (Mediterranean climate)	/	~ 60 -110 years**
K-BR-Mar-L	Bauxite residue	Karstic (France)	Saint-Louis-les-Aygalades plant (France)	Marseille tailing site (La Delorme)	Storage under closing layer (Mediterranean climate)	Backfill layer and vegetation (capping layer)	~ 60 -110 years**
K-BR-Vit-A	Bauxite residue	Karstic (France)	Saint-Louis-les-Aygalades plant (France)	Vitrolles tailing site (Griffon)	Storage in the open air (Mediterranean climate)	Presumed landfill (sewage sludge spreading)	~ 50 -60 years**
K-BR-Vit-V	Bauxite residue	Karstic (France)	Saint-Louis-les-Aygalades plant (France)	Vitrolles tailing site (Griffon)	Storage in a heavily vegetated area (Mediterranean climate)	Vegetation cover / backfills presence / presumed landfill	~ 50 -60 years**
K-BR-Vit-W	Bauxite residue	Karstic (France)	Saint-Louis-les-Aygalades plant (France)	Vitrolles tailing site (Griffon)	Wet storage, in a retention basin (Mediterranean climate)	Presumed landfill and backfills presence	~ 50 -60 years**

* Supplied by Alteo, the company that currently manages the Gardanne plant.

** Uncertainty concerning the time of use of the storage site. Dry samples collected on the surface and therefore considered to be young (in **bold** in the table).

*** Difficult to determine the exact age of storage of liquid samples in the dam because of potential transfer between young and old residues. Liquid samples collected on the surface can be considered to be relatively young (0-15 years) compared to the age of the dam (40 years).

2.2. Characterisation of the samples

2.2.1. *pH and conductivity*

For pH and electrical conductivity measurements, aqueous suspensions with a 1/5 solid/liquid ratio (1 g of material in 5 mL of distilled water) were prepared according to ISO 10390:2021. Measurements were made at 20 °C with two replicates after 2 h of stirring and 24 h of decantation.

2.2.2. *Chemical composition*

Preparation and bulk chemical analyses were conducted at CEREGE (France). The samples were digested by alkaline fusion using 100 mg of sample mixed with 500 mg of previously dried flux (49.5% lithium tetraborate, 49.5% lithium metaborate, 1% LiBr) and placed in an oven (Malvern Panalytical Claisse LeNeo) to undergo specific high refractory material digestion (up to 1050 °C for 22 min). The resulting fusion pearl was immediately dissolved in 40 mL of nitric acid (3-4 wt%). After appropriate dilution in distilled water, trace elements (<1000 µg/L) were analysed by inductively coupled plasma mass spectrometry (ICP-MS, Perkin Elmer 300X quadrupole) and major elements (>1000 µg/L) were analysed by inductively coupled plasma optical emission spectroscopy (ICP-OES Perkin Elmer Optima 4300 DV).

Three replicates were made of each analysis, and the results (concentration in mg/kg dry weight) are expressed along with the average and the standard deviation of the three samples.

2.2.3. *Mineralogy*

Mineralogy was performed by X-ray diffraction (XRD) at 40 kV and 40 mA on a PANalytical X'Pert Pro (Malvern Panalytical, UK) diffractometer equipped with a rear monochromator and a cobalt anticathode ($\lambda = 1.79 \text{ \AA}$) at CEREGE (France). Powder samples were deposited on low background silicon plates with a drop of ethanol and scanned from 5 to 75° (2 θ) with a step size of 0.033° and a total counting time of 3 h. The sample was rotated at 15 rpm during analysis to improve the statistics. Phase identification was performed using the X'pert Highscore plus software (Malvern Panalytical) with the PDF-2 ICDD (International Center for Diffraction data, Powder Diffraction Files 2) and COD (Crystallography Open Database).

2.2.4. *Microscale observations*

Microscale observations were performed using a Quattro S Environmental Scanning Electron Microscope (ThermoFisher) coupled with a XFlash6 / 100 Energy Dispersive X-ray Spectrometer with Quantax 400 software (Bruker) (SEM/EDS) (ICSM, France). The L-BR-Gui-E and K-BR-Mar-A powder samples were embedded in resin (Araldite 2020) and then polished (using silicon carbide and diamond) with oil. The cross-sections were then coated with carbon, and copper tape was used to ensure good conduction during microscopy. Series of elemental distribution maps (12×12 and 15×15, ×500 magnification) were first recorded (30 kV, 200 keps, 20 min for each) to locate particles or grains containing Y over a large area (6-8 mm²). Once the particles were identified, EDS point analyses (15

231 kV, 100 kcps, 1 min), as well as EDS elemental maps of the selected areas (12 kV, 50 kcps, 20 min)
232 were performed. Finally, quantitative-EDS elemental maps were performed to avoid interference
233 between elements. These maps were produced by integrating 8×8 pixels from the qualitative EDS maps
234 to increase the counting statistics and reduce calculation time.

235

236 **2.2.5. Yttrium speciation by X-ray absorption spectroscopy (XAS)**

237 XAS spectra at Y K-edge (17.038 keV) were recorded at the European Synchrotron Radiation
238 Facility (ESRF, Grenoble, France) on beamline BM30 (CRG-FAME beamline) (Chaurand et al., 2025).

239 Incoming photon flux energy was modulated using a Si(220) double crystal monochromator and
240 higher harmonics were suppressed using Rh-curved mirrors. The data were collected in the step-by-step
241 mode with a beam size of 200×150 μm.

242 Samples of bauxite ore and BRs were prepared as pure pellets (~30 mg), and model compounds were
243 prepared as pellets diluted with polyvinylpyrrolidone (PVP). For the latter, the dilution ratio with PVP
244 was calculated to obtain an optimal $\Delta\mu_{theoretical}$ of 1 with ABSORBIX software (v3.02) (Michalowicz
245 et al., 2009).

246 During the experiment, incoming X-ray beam energy was calibrated and regularly checked using a
247 reference metal foil of Y. Each sample was measured in an He cryostat at 10-20 K to prevent beam
248 damage. Spectra were obtained in fluorescence mode for bauxite ore and BR samples (average of 3 to 9
249 scans depending on the signal to noise ratio), and in transmission mode for model compounds (1 to 3
250 scans), except for the Y-doped hematite model compound which was run in fluorescence mode due to
251 the relatively low concentration of Y. XAS spectra (XANES and EXAFS) were recorded from 16.85 to
252 17.58 keV ($k = 12 \text{ \AA}^{-1}$) with an energy step of 5 eV between 16.85 and 17 keV (1s counting time), of
253 0.5eV from 17 to 17.085 keV and a k step of 0.05 \AA^{-1} from 17.085 to 17.58 keV. Calibration, merging
254 and normalization were performed with XAS-Viewer software (Larch, v0.9.65) (Newville, 2013).

255

256 A library of Y reference compound spectra was used to identify Y species in bauxite ore and BRs
257 (Couturier et al., 2022). The library consisted of commercial references (purity >99.9%): yttrium oxide
258 (Y_2O_3 ; Acros Organics), yttrium carbonate ($\text{Y}_2(\text{CO}_3)_3 \cdot x\text{H}_2\text{O}$; Alfa Aesar), yttrium phosphate
259 ($\text{YPO}_4 \cdot x\text{H}_2\text{O}$ Alfa Aesar) hereafter “medium crystallized xenotime YPO_4 ” or “mcx YPO_4 ”, but also
260 synthesized references (see protocols and XRD in SI): yttrium hydroxide ($\text{Y}(\text{OH})_3$), yttrium phosphate
261 (YPO_4) with different phase and crystallinity (churchite, low and high crystallized xenotime), Y-
262 adsorbed on montmorillonite ($(\text{Na,Ca})_{0,3}(\text{Al,Mg})_2\text{Si}_4\text{O}_{10}(\text{OH})_2 \cdot x\text{H}_2\text{O}$), Y-doped Calcite (CaCO_3), Y-
263 doped hematite (Fe_2O_3), low and high crystallized Y-doped hydroxyapatite ($\text{Ca}_5(\text{PO}_4)_3(\text{OH})$).

264 Linear combination fitting (LCF) of the XANES region was performed from 17000 to 17220 eV with a
265 maximum of three components (adding a fourth component did not improve fits) using XAS Viewer
266 software (Larch, v0.9.65) (Newville, 2013). The reduced-chi-square value (χ_{red}^2), which accounts for
267 degrees of freedom in the fit, was used to compare the relative quality of two fits that use the same

268 interval but a potentially different number of variables. A change between two fits is considered
269 statistically significant when the ratio of their two reduced-chi-square is greater than two standard
270 deviations, according to the reference (Kelly et al., 2008). In our case, this criterion was used to identify
271 all fits that were significantly identical to the best fit, which were then defined as "good fits". The value
272 of the criterion was 1.185 and was obtained with the number of points in the fitting interval ($N = 237-$
273 239) and the number of variables in the fit ($V = 3-4$).

274 3. Results and discussion

275 3.1. pH and electrical conductivity

276

277

278

279

280

281

282

283

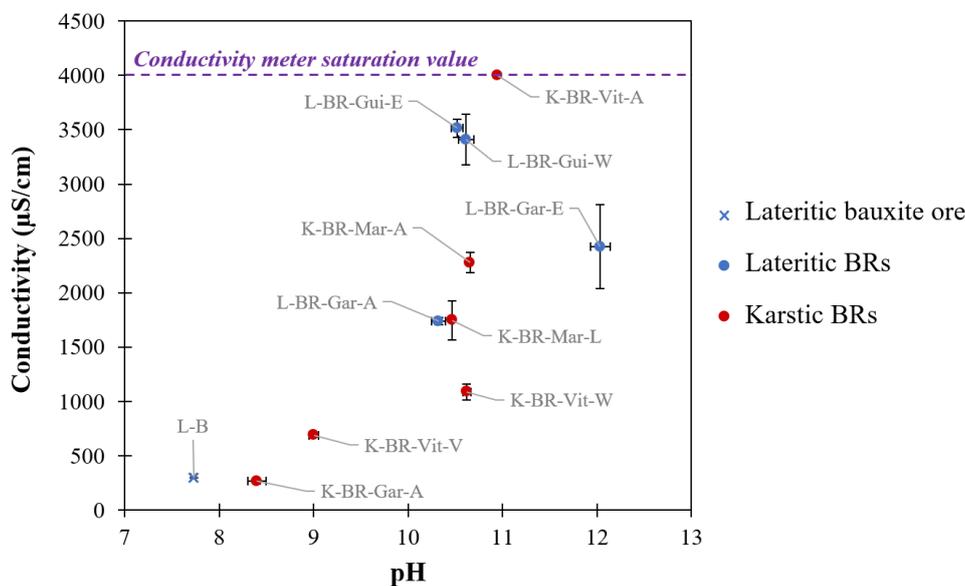
284

285

286

287

288



289 **Figure 3:** Conductivity of all the samples as a function of pH (solid/liquid ratio = 1/5, 20 °C) (blue = lateritic-type, red =
290 karstic-type).

291

292 pH and conductivity varied widely among the samples (**Figure 3, Table S1**). The bauxite ore
293 sample (L-B) had an almost neutral pH and very low conductivity (<300 µS/cm), whereas the BRs had
294 alkaline pH ranging from 8.4 to 12, and strongly varying conductivity, i.e. from 266 µS/cm to >4 mS/cm
295 (saturation value). The high variability observed is nevertheless consistent with that reported in the
296 literature (Gräfe et al., 2011; Snars & Gilkes, 2009).

297 The alkaline nature and high conductivity of BRs are due to the contact between bauxite ore and
298 concentrated soda during the Bayer process. In addition to solubilizing Al, excess OH⁻ and Na⁺ ions in
299 the residue are responsible for the high pH and conductivity (Di Carlo et al., 2019; Gräfe et al., 2011).
300 Many parameters can influence both pH and conductivity of the BRs. During the Bayer process, the
301 concentration of the NaOH solution, the quality of the washing steps or the inclusion of a filtration step
302 determine the alkalinity and salinity of the BR at the outlet of the plant, among other things (Power et
303 al., 2011). During storage, locally strong increases in pH and conductivity can occur at the surface of
304 the deposit, resulting in the formation of efflorescence (Di Carlo et al., 2019; Wu et al., 2020), mainly
305 in the form of a thin white layer composed of Na₂CO₃ and NaHCO₃. This phenomenon has already been
306 observed at the Vitrolles site (Fourrier, 2020) and may explain the high conductivity of K-BR-Vit-A.
307 However, a decrease in pH and conductivity is most often observed as a function of the storage time of
308 the deposit. The decrease is related to the leaching of alkaline soluble compounds by natural weathering
309 (mainly rainfall), to the slow carbonation of BRs by atmospheric CO₂ or even to the activity of
310 microorganisms and plants (Cusack et al., 2019; Di Carlo et al., 2019; Khaitan et al., 2010; Kong, Guo,

311 et al., 2017; Macías-Pérez et al., 2022; Zhu et al., 2016). This aging effect was particularly visible in the
312 oldest sample, K-BR-Gar-A. Organic, inorganic, acidic or seawater amendments also lead to the
313 neutralization of BRs, which is one of the most desired effects when the aim is remediation or use of
314 these wastes around the world (Fourrier et al., 2021; Jones et al., 2012; Khaitan et al., 2009, 2010;
315 Klauber et al., 2011; Kong, Li, et al., 2017; Menzies & Kopittke, 2021; Wong & Ho, 1991).
316 Neutralization of BRs is the main factor that enables the natural establishment of micro-organisms and
317 vegetation (Di Carlo et al., 2019; Santini & Fey, 2013; Xue et al., 2016), as can be seen at the K-BR-
318 Gar-A and L-BR-Vit-V sites.

319 The age or storage conditions of the BRs thus appear to have an influence on their pH and conductivity,
320 but many other parameters also come into play, making it difficult to make clear correlation, especially
321 when the history of operations at the site is difficult to trace.

322

3.2. Chemical composition

324

325 **Table 2:** Chemical composition by mass of major elements (Fe, Al, Ti, Si, Ca), Y and sum of all REEs (including Y and Sc)
 326 present in our samples, obtained by ICP-MS and ICP-OES after alkaline fusion (3 replicates).

Sample	Fe (wt%)	Al (wt %)	Ti (wt %)	Si (wt %)	Na (wt %)	Ca (wt %)	Y (mg/kg)	ΣREEs (mg/kg)
L-B	14.51 ± 0.08	23.11 ± 0.04	1.57 ± 0.01	1.00 ± 0.01	0.01 ± 0.02	0.00 ± 0.01	34 ± 2	218 ± 6
L-BR-Gui-E	31.24 ± 0.11	8.05 ± 0.14	3.26 ± 0.08	2.02*	1.94 ± 0.03	1.16 ± 0.09	102 ± 2	562 ± 15
L-BR-Gui-W	32.33 ± 1.34	8.73 ± 0.35	3.40 ± 0.18	2.31*	1.98 ± 0.12	1.46 ± 0.11	101 ± 6	563 ± 25
L-BR-Gar-E	31.48 ± 0.45	5.56 ± 0.11	4.74 ± 0.10	1.97 ± 0.02	2.23 ± 0.09	4.28 ± 0.09	118 ± 0	727 ± 4
L-BR-Gar-A	31.90 ± 0.23	6.49 ± 0.03	5.15 ± 0.04	1.92 ± 0.02	2.54 ± 0.04	2.82 ± 0.04	123 ± 2	778 ± 13
K-BR-Gar-A	28.47 ± 0.65	8.97 ± 0.06	2.37 ± 0.03	3.13 ± 0.06	1.28 ± 0.04	3.53 ± 0.05	226 ± 4	1792 ± 24
K-BR-Mar-A	29.43 ± 1.01	5.60 ± 0.17	4.08 ± 0.14	3.20 ± 0.11	3.06 ± 0.15	4.45 ± 0.02	226 ± 8	2261 ± 74
K-BR-Mar-L	39.02 ± 0.13	6.22 ± 0.03	4.52 ± 0.02	2.76 ± 0.01	2.34 ± 0.02	0.85 ± 0.01	265 ± 10	2702 ± 128
K-BR-Vit-A	25.31 ± 0.51	9.92 ± 0.15	2.70 ± 0.04	3.67 ± 0.07	5.91 ± 0.27	1.85 ± 0.04	219 ± 2	1924 ± 18
K-BR-Vit-V	21.64 ± 0.28	7.96 ± 0.05	2.47 ± 0.02	5.25 ± 0.03	3.04 ± 0.06	5.01 ± 0.04	184 ± 1	1549 ± 11
K-BR-Vit-W	20.80 ± 0.06	7.78 ± 0.03	2.47 ± 0.01	5.88 ± 0.02	3.79 ± 0.22	6.01 ± 0.02	199 ± 3	1668 ± 7

327 * Silicon was only measured in one replicate of L-BR-Gui-E and L-BR-Gui-W samples.

328

329 The chemical composition of the samples is listed in **Table 2** (additional elements are reported
 330 in **Table S2**). The bauxite ore sample (L-B) mainly contained aluminium (Al, 23.1 wt%) and iron (Fe,
 331 14.5 wt%) while BR samples mainly contained Fe (20-39 wt%), Al (5-10%), silicon (Si, 2-6 wt%) and
 332 titanium (Ti, 2-5 wt%). The main difference in composition between bauxite ore and the BR samples
 333 was due to Al extraction during the Bayer process. The Bayer process was also at the origin of the non-
 334 negligible sodium content (Na, 1.3-5.9 wt%) and calcium content (Ca, 0.8-6.0 wt%) in the BRs, whereas
 335 these elements were not present in the L-B sample. The presence of Na is due to digestion of bauxite
 336 ore with caustic soda (NaOH) and the presence of Ca to the addition of lime (CaO, Ca(OH)₂) during
 337 preliminary desilication and causticization (Borra et al., 2016; Smith, 2009).

338 Among the minor elements, the amount of total REEs (including Y and Sc) in the L-B sample
 339 was 218 mg/kg while total REE contents in BRs ranged from 562 to 2702 mg/kg. The enrichment of the
 340 REE content in BRs is specific to the Bayer process, as these elements are not released by soda during
 341 the process and are consequently concentrated in the residues. Individually, REE concentrations agree
 342 with their natural occurrence, ranked in decreasing order: Ce, followed by Y, La, Nd and Sc and the
 343 other REEs (**Table S2**).

344 Despite the significant differences between the BR samples considered in the present study, in terms of
 345 their ore origin, storage conditions, ages, as well as pH and conductivities, variations in the
 346 concentrations of the major elements remain limited compared to the variety of compositions reported
 347 in the literature (Binnemans et al., 2015; Evans, 2016; Gräfe et al., 2011; Khairul et al., 2019; Snars &

348 Gilkes, 2009; Xue et al., 2016). In particular, no correlation was found between the variations in the
349 concentration of these elements and their storage time, thereby confirming some findings reported in the
350 literature (Cusack et al., 2019). However, some slight variations in the composition of BRs can be
351 explained by the history of activities at the storage site concerned or during the implementation of the
352 Bayer process. To give an example, aerial image archives have proven the presence of construction site
353 landfills in the lower part of the Vitrolles tailing site over the last 30 years, which correspond to the areas
354 where the K-BR-Vit-V and K-BR-Vit-W were sampled (Fourrier, 2020). The addition of Si and Ca rich
355 materials is probably responsible for lower concentrations of Fe, Al and Ti and higher concentrations of
356 Si and Ca compared to the K-BR-Vit-A sample, which was collected from the upper part of the same
357 tailing site and has never been in contact with these landfills. However, the difference in Al content
358 between L-BR-Gui-E (8.0 wt%) and L-BR-Gar-E (5.6 wt%) could also be due to differences in the
359 quality of the ore and/or in the performance of the Bayer process.

360 In contrast to major elements, the origin of the bauxite ore has a strong influence on REE content in BRs
361 (657 ± 112 mg/kg ($n = 4$) for lateritic BRs and 1983 ± 429 mg/kg ($n = 6$) for karstic BRs). Indeed, karstic
362 bauxites are known to have higher concentrations of REEs than lateritic bauxites (Binnemans et al.,
363 2015; Borra et al., 2016; Vind et al., 2018), and can reach 1000 mg/kg or more (Liu et al., 2016; Mondillo
364 et al., 2019). This difference has been widely reported and is usually attributed to the "pH-barrier" of
365 the underlying alkaline carbonate rock that tends to favour REE concentration in karstic bauxites
366 (Gentzmann et al., 2021). Consequently, the difference is carried over to the BRs with concentrations
367 of up to 2702 mg/kg in the K-BR-Mar-L sample, which is more than ten times the average for the earth's
368 crust (\sum REEs ≈ 240 mg/kg) (Haynes, 2014). The high REE contents in BRs originating from karstic
369 bauxite ores make them promising secondary sources of REEs for the future. In comparison, some
370 natural deposits currently being exploited for their REEs contain less than 1 wt% REEs (Davris et al.,
371 2017; Huang et al., 2021; M. Y. H. Li et al., 2019).

372 The specific karstic/lateritic signature in terms of the chemical compositions of BRs can be also
373 observed in other elements. For example, P, Cr, V, Ga are more abundant in lateritic BRs, while Si, Mg,
374 Mn, Sr, Ni, Pb, As, Co are present at higher concentrations in karstic BRs. Finally, among the elements
375 present in the BRs (**Table S2**), we also noted the presence of significant quantities of Ti (up to >5 wt%),
376 Mg (up to >3000 mg/kg in karstic BRs), Zr (up to >2000 mg/kg), P (up to >2000 mg/kg in lateritic BRs),
377 V (up to >1500 mg/kg in lateritic BRs), Cr (up to >1500 mg/kg in lateritic BRs), Mn (up to >800 mg/kg
378 in karstic BRs), Sr (up to >400 mg/kg in karstic BRs), Ni (up to >300 mg/kg in karstic BRs), which are
379 also considered as critical elements by the European Commission or the USGS (Grohol & Veeh, 2023;
380 U.S. Geological Survey, 2022), and for which the possibility to use BRs as a secondary source remains
381 to be investigated.

382

383

3.3. Chondrite-normalized REE profiles

384

385

386

387

388

389

390

391

392

393

394

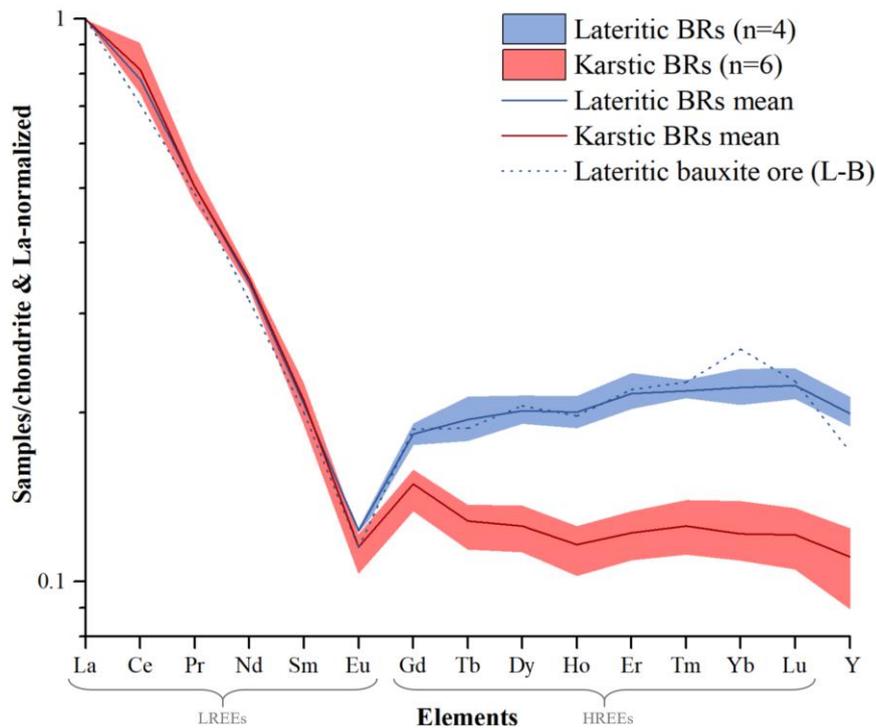
395

396

397

398

399



400

401

402

403

Figure 4: Patterns of chondrite and lanthanum-normalized rare earth elements in all the bauxite residue samples studied here, separated according to the origin of the ore. The normalized spectrum of lateritic bauxite ore sample is plotted for the purpose of comparison. The normalized values come from (Taylor & McLennan, 1985)

404

405

406

407

408

For a more in-depth analysis of the observed differences between lateritic and karstic BRs with respect to REEs, chondrite-normalized REE profiles are plotted by normalizing each REE content by the corresponding value in the chondrites (Taylor & McLennan, 1985), (**Figure 4, Table S3**). In order to compare samples independently of their total REE content, the REE profiles are also normalized by the lanthanum value for each sample.

409

410

411

412

413

414

415

416

417

418

419

All the BRs showed dominance of LREEs over HREEs, which decreased with an increase in Z, as often reported for bauxites in the literature [69], [70]. The Ce and Eu anomalies, defined as the $\frac{Ce_N}{\sqrt{(La_N * Pr_N)}}$ and $\frac{Eu_N}{\sqrt{(Sm_N * Gd_N)}}$ ratios also presented similar values (1.0 to 1.3 and 0.6 to 0.7 respectively), when we compared BR compositions (**Table S4**). Interestingly, a difference appeared in the behaviour of HREEs depending on the origin of the bauxite ore. Evidence for a relative enrichment of HREEs, also visible on Y, was found in lateritic BRs compared to in karstic BRs. This variation can be characterised by the value of the slope of the REE pattern, defined as the ratio of normalized La_N/Lu_N values, which is lower for lateritic BRs (4.2 to 4.7) than for karstic BRs (7.4 to 9.5) (**Table S4**). It is also important to note that the lateritic bauxite ore sample (L-B) followed the same pattern as the lateritic BRs despite a 2 to 4 times lower REE concentration. This supports the conclusion that the differences observed in the HREEs are characteristic of the origin of the bauxite ore, as, when we compared the

420 REE profiles of L-B and lateritic BRs, the Bayer process had no effect on the relative proportions of the
421 REEs.

422 Differences in REE patterns may be the signature of different speciation (Bea, 1996). **Figure 4** suggests
423 that HREEs bearing phases in BRs differ depending on the origin of the bauxite ore. This hypothesis
424 was reinforced by further analysis of the chemical data. For example, the scatterplot between P and
425 HREEs shows that HREEs concentration is correlated with the concentration of P in lateritic BRs,
426 whereas no correlation was apparent in karstic BRs (**Figure S2**). To identify the HREE-bearing phases
427 and the potential association of HREEs with P in the BRs, the mineralogy of the samples was next
428 examined from a macroscopic and microscopic perspective, as described in the following sections.

429

430

3.4. Mineralogy

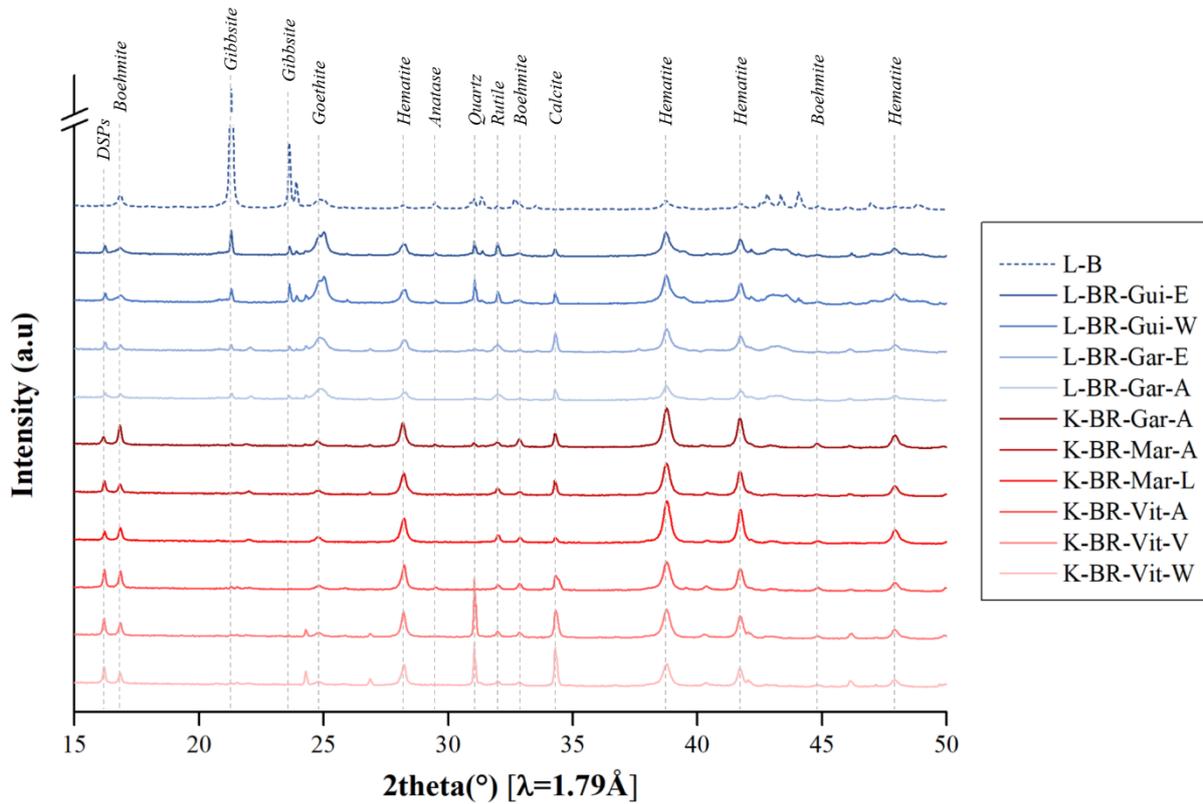


Figure 5: X-ray diffraction patterns of the studied bauxite ore (L-B) and bauxite residue samples sorted by origin of the ore (blue = lateritic-type, red = karstic-type). Identification of the main peaks of the major phases. DSPs: desilication products

The X-ray diffraction (XRD) patterns are reported in **Figure 5**. In agreement with the elemental composition, the mineralogy of the lateritic bauxite ore sample (L-B) was dominated by Al phases, mostly in the form of gibbsite ($\text{Al}(\text{OH})_3$). Gibbsite is known to be the main Al phase in lateritic bauxites characterised by weathering under a tropical climate (Baioumy, 2016; Bhukte et al., 2020; De Oliveira et al., 2016; Negrão & Costa, 2021; Sidibe & Yalcin, 2018; Vind et al., 2018), although diaspore ($\text{AlO}(\text{OH})$) may be encountered in certain cases (Gu et al., 2013). Also, karstic bauxites (not studied here) often contain boehmite ($\text{AlO}(\text{OH})$) as the main Al phase (Kloprogge et al., 2002; Mondillo et al., 2019; Radusinović & Papadopoulos, 2021; Reinhardt et al., 2018) even if gibbsite or diaspore phases are the main phases in some non-Mediterranean karstic bauxites (Z. Li et al., 2013; Torró et al., 2017). The effect of the Bayer process transforming bauxite ore into BR is clearly visible on XRD diffractograms. The majority of the Al phases contained in L-B were extracted showing the Fe phases to be predominant in BRs as hematite (Fe_2O_3) or goethite ($\text{FeO}(\text{OH})$). The decrease in the Al phase in the BRs also brought out minor Ti phases, such as anatase or rutile (TiO_2), and Si, as quartz (SiO_2) which were masked in L-B due to the limit of detection of this technique (≈ 1 wt%). Similarly, calcite (CaCO_3) and aluminosilicate phases (cancrinite, sodalite, vishnevit) corresponding to desilication products

468 (Gräfe et al., 2011; Radomirovic et al., 2013; Senaputra et al., 2012) were observed in the XRD patterns
469 of BRs. These results are consistent with data reported in the literature (Evans, 2016; Gentzmann et al.,
470 2021; Khairul et al., 2019; Klauber et al., 2011).

471 The mineralogy of all the BR samples was relatively similar, except for some slight variations that
472 mainly depended on the origin of the bauxite ore. Gibbsite (main peak at $\theta = 21.3^\circ$) was not observed
473 from the XRD pattern of karstic BRs. The intensity of the boehmite-related peak (main peak at $\theta =$
474 16.9°) was more intense in the XRD pattern of karstic BRs than in the XRD pattern of lateritic BRs,
475 confirming reports on karstic bauxites in the literature (Kloprogge et al., 2002; Mondillo et al., 2019;
476 Radusinović & Papadopoulos, 2021; Reinhardt et al., 2018). Iron-containing phases were present as a
477 mixture of hematite and goethite, but relatively speaking, the intensity of hematite peaks was far greater
478 than that of the goethite peaks in karstic BRs. The intensity of the aluminosilicate peak (main peak at θ
479 $= 16.2^\circ$) was also greater in karstic BRs.

480 In agreement with the chemical composition, the effect of construction site backfill during storage of K-
481 BR-Vit-V and K-BR-Vit-W is visible here due to more intense quartz ($\theta = 31.0^\circ$) and calcite peaks ($\theta =$
482 34.3°) on the diffraction patterns. Similarly, we attribute the higher gibbsite and quartz peaks in L-BR-
483 Gui-E and L-BR-Gui-W, compared to the other lateritic BRs on the diffractograms, to the quality of the
484 ore or to the performance of the Bayer process. Indeed, the bauxite ore used at Fria plant is reputed to
485 be of lower quality than that used at the Gardanne plant, due to its higher silica content, which hampers
486 aluminium extraction.

487 The structural analysis performed by XRD revealed differences in the mineralogy of the major phases
488 of BRs depending on the origin of the bauxite ore, but no other drastic mineralogical variation were
489 found related to the age or storage conditions of the BRs. However, other characterisation techniques
490 are needed to investigate the possible REE phase differences mentioned earlier in more detail3.3.

491

492

493

3.5. Microscopic and macroscopic evidence of speciation

494

3.5.1. SEM/EDS observations

495

496

497

498

499

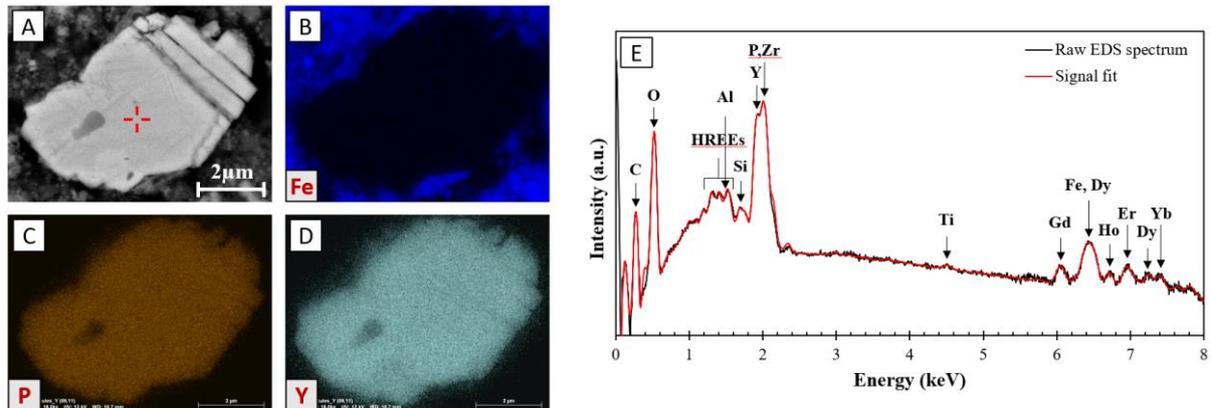
500

501

502

503

504



505

506

507

508

509

Figure 6: (A) SEM image (BSE detector) of an yttrium particle found in samples L-BR-Gui-E as an example of lateritic bauxite residue (magnification $\times 4000$) and associated quantitative EDS elemental maps showing the spatial distribution for (B) iron (C) phosphorus and (D) yttrium (12 kV, 50 kcps, 20 min). (E) EDS spectrum associated to the micro-analysis performed with the incident beam centered at the red cross position on (A) (15 kV, 100 kcps, 1 min).

510

511

512

513

514

515

516

517

518

519

520

521

522

523

524

525

526

527

528

Scanning electron microscopy (SEM) observations coupled with energy dispersive X-ray spectroscopy (EDS) were performed on L-BR-Gui-E and K-BR-Mar-A BRs, as these two samples were assumed to be representative of lateritic and karstic BRs, respectively (**Figure 6** and **Figure S3**). In order to identify the occurrence of these particles in the samples in a representative way, a series of elemental distribution maps (magnification $\times 500$) were performed on large regions of interest (6-8 mm²) for both samples. The analytical conditions chosen allowed the identification of particles with a diameter as small as 500 nm.

In both cases, Y-rich particles were found, co-localized with similar elements. Yttrium was found co-localized with other HREEs (Gd, Dy, Ho, Er, Yb), which supports the classification of Y as HREEs and validates using it as a proxy for HREEs (Borst et al., 2020; Lallemand et al., 2022; Pingitore et al., 2014). EDS elemental maps show that Y and HREEs are always associated with phosphorus (P), but not associated with major elements (Fe, Al, Ti, Ca < 3 at%) (**Figure 6** B, C and D). Moreover, the local chemical micro-analyses show P/HREEs atomic ratios close to 1 and Y/O atomic ratios between 0.15 and 0.25, suggesting the presence of xenotime (YPO₄) or churchite (YPO₄·2H₂O) phases. In rare cases, Si and Zr can also be associated (>3 at%), suggesting traces of zircon (ZrSiO₄) associated with xenotime, as well as with Fe from the surrounding matrix. These results are in good agreement with microscopic observations reported in the literature on BRs and bauxites (Lallemand et al., 2022; Z. Li et al., 2013; Mordberg et al., 2001; Radusinović & Papadopoulos, 2021; Reinhardt et al., 2018; Rivera et al., 2019; Vind et al., 2018). All these studies show that Y is found as xenotime or churchite phosphate particles

529 in BRs, as in bauxites, regardless of the origin of their geological ore, although Y has also been detected
530 in mixed phases of REEs in Greek BRs (Vind et al., 2018).

531 Based on this local probe technique, it seems that Y speciation does not differ as a function of the lateritic
532 or karstic origin of the samples and cannot confirm our hypothesis that there is a difference in HREE
533 mineralogy between lateritic and karstic BRs based on REE patterns. However, scanning large sample
534 areas (6-8 mm²) indicated approximately twice as many particles present in the L-BR-Gui-E sample
535 than in the K-BR-Mar-A sample (2.4 and 1.3 particles/mm² respectively) while the Y content was twice
536 lower in the L-BR-Gui-E sample than in the K-Mar-A sample (102 and 226 mg/kg respectively).

537 Additionally, while in both samples, most of the particle diameters were smaller than 5 µm, several large
538 particles were found in L-BR-Gui-E, including one particle with a 50 µm diameter (**Table S5** and **Table**
539 **S6**). This suggests that most of the Y in the K-BR-Mar-A sample is not detectable by SEM and,
540 according to the P vs HREE scatterplot (**Figure S2**), is probably not associated with P. X-ray absorption
541 spectroscopy (XAS) was performed at bulk scale to specifically characterise the atomic environment of
542 Y species in all the samples, including the phosphate phases and other potential Y-bearing phases not
543 detected by SEM analysis (Y-minerals and absorbed species).

3.5.2. X-Ray absorption spectroscopy measurements at Y K-edge

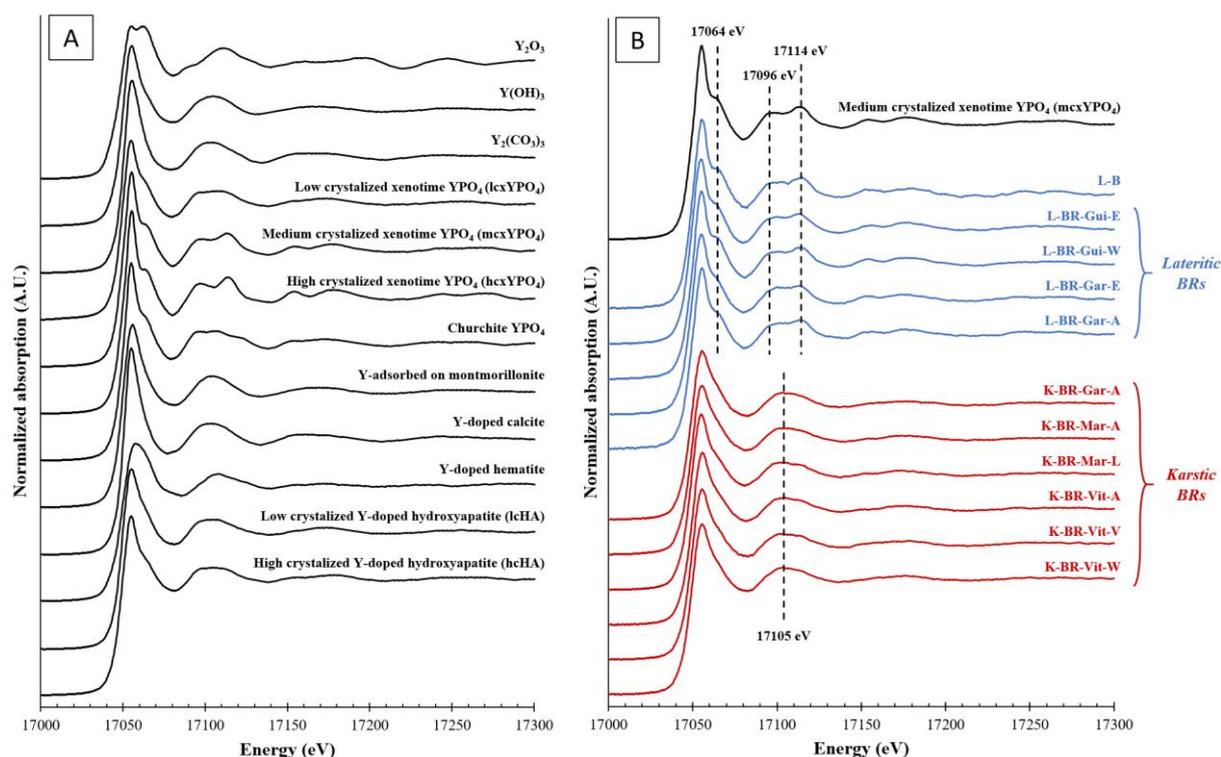


Figure 7: (A) Stacking of Y K-edge XANES spectra of the model yttrium compounds used in the study. (B) Stacking of Y K-edge XANES spectra of all the studied samples sorted by origin of the ore (blue = lateritic-type, red = karstic-type). Spectra of crystallized YPO₄ xenotime model compound is plotted for the purpose of comparison. The main features of the spectra are identified by the dashed lines.

The X-ray Absorption Near Edge Structure (XANES) spectra of the model compounds are shown in **Figure 7 A**. Among them, the xenotime YPO₄ compounds show a clearly identifiable structure consisting of a shoulder after the white line at 17064 eV and a double feature at 17096 eV and 17114 eV that is repeated at 17153 and 17178 eV, these structures being more pronounced with higher crystallization. The churchite YPO₄ spectrum shows a slightly different structure with three features instead of two between 17090 and 17130 eV, allowing the xenotime to be differentiated from churchite using XAS measurements. The spectra of Y-doped hematite and Y₂O₃ are also very specific and easily identifiable. Conversely, high-crystallized Y-doped hydroxyapatite (hcHA), which is a calcium phosphate, shows very similar characteristics to those of low crystallized xenotime YPO₄ (lcYPO₄). None of the other model compound spectra show a very specific signature but consist in a single oscillation centered around 17105 eV and little or no post-white line shoulder, making identification of the presence of these phases potentially difficult.

The Y speciation in the samples studied here can be categorised in two types of signals mainly correlated with the origin of the bauxite ore (**Figure 7 B**).

580 Visually, the speciation of Y in samples of lateritic origin is very similar to a xenotime phase. Indeed,
 581 linear combination fitting (LCF) of the results of the XANES region (17000 to 17220 eV) confirmed
 582 these observations with the strong presence (>34% in all best fits) of medium-crystallized xenotime YPO_4
 583 (mcxYPO_4) (**Table S7**). For example, the best fit for L-BR-Gui-E consisted in a mixture comprising
 584 57% medium-crystallized xenotime YPO_4 (mcxYPO_4) and 35% hcHA with a very good match ($\chi^2 = 0.02$)
 585 (**Figure 8 A**).

586

587

588

589

590

591

592

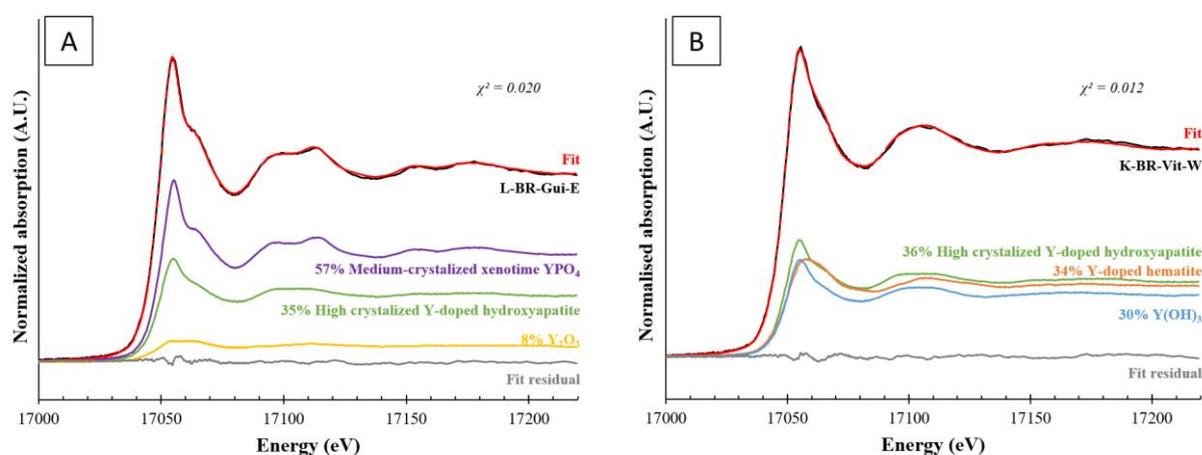
593

594

595

596

597



598

599

600

601

602

603

604

605

606

607

608

609

610

611

612

613

614

615

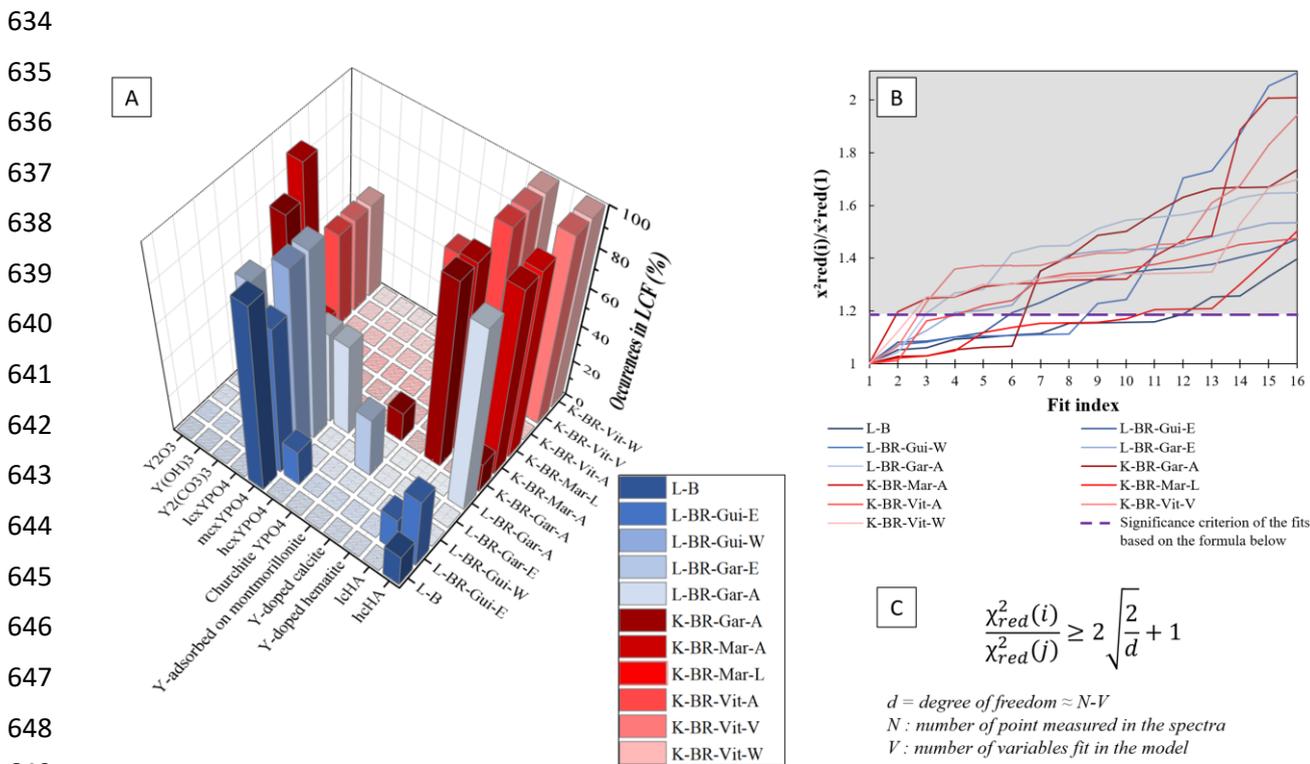
Figure 8: Best linear combination fitting (LCF) XANES analysis results for (A) L-BR-Gui-E, as an example of lateritic samples and (B) K-BR-Vit-W, as an example of karstic samples. Fits were performed with Larch software (17000-17220 eV, with a maximum of 3 components).

Figure 9 is a statistical study of the LCF results to compare samples with different noise levels and to obtain statistically relevant results. In **Figure 9 A**, the percentages of occurrence of the main model compounds (with an arbitrary threshold of 25% in the fit) in all the good fits (i.e., all fits that do not statistically differ from the best fit) are plotted for each sample. A quality criterion (**Figure 9 C**), based on reduced chi-square value (χ_{red}^2), was used to determine the number of significantly good fits for each sample (**Figure 9 B**) (see section 2.2.5). Indeed, in the case of a noisy spectrum, a large number of combinations of model compounds can correctly fit the experimental data, as is the case of L-B sample with 11 fits (fit n°1 to fit n°11 in the white area) considered to be good. Thus, it does not seem reasonable to rely only on the best fit.

Our statistical study confirmed that xenotime YPO_4 appears in 100% of good fits of all lateritic samples in the form of mcxYPO_4 or less often in the form of hcxYPO_4 . With the exception of the strong presence of hcHA in L-BR-Gar-A good fits, as well as Y(OH)_3 , which was present in the majority of L-BR-Gar-E good fits, no other model compounds appear significantly in the good fits of lateritic samples. These results confirm and complement the results of the study by (Lallemant et al., 2022) who proposed

616 speciation of Y as a mixed amorphous and crystalline xenotime phosphate based on the same lateritic
 617 material (L-BR-Gar-E).

618
 619 The speciation of Y in samples of karstic origin clearly differs from speciation in samples of lateritic
 620 origin, but is also more difficult to identify than in lateritic ones. Visually, the XANES signals do not
 621 reveal a specific structure or if they do, only tenuously. The LCF results of the XANES region showed
 622 no clear predominance (**Table S7**), as illustrated by the best fit for K-BR-Vit-W, consisting, with a very
 623 good match ($\chi^2 = 0.01$) of a mixture of 36% highly crystallized hydroxyapatite (hcHA), 34% Y-doped
 624 hematite and 30% Y(OH)₃ (**Figure 8 B**). Our statistical study nevertheless showed that only hcHA, Y-
 625 doped hematite, Y(OH)₃ and to a lesser extent, Y-adsorbed on montmorillonite, are present in the good
 626 fits of karstic BRs (**Figure 9 A**). In none of the cases, do the xenotime YPO₄ compounds stand out, in
 627 contrast to in the samples of lateritic origin. To be consistent with XAS responses, Y in karstic BRs
 628 could be adsorbed or incorporated into one or more mineral phases, as is the case for Sc in BRs
 629 (Gentzmann et al., 2021). However, Sc speciation is known to diverge from that of other REEs
 630 (Horovitz, 1975; Suss et al., 2018; Vind et al., 2018), so extrapolation to Y behaviour is not feasible.
 631 For example, in their study, Gentzmann et al. show that the geological origin of the ore implies only
 632 minor changes in the distribution of Sc in the host mineral phases, which is not the case for Y
 633 (Gentzmann et al., 2021).



650 **Figure 9:** (A) Occurrence of model compounds in all good fits (i.e. significantly identical to the best LCF) performed with
 651 Larch software in the XANES region (17000-17220 eV, maximum of 3 components), for all the samples studied. Only model
 652 compounds that contributed more than 25% are shown. (B) Changes in the goodness of fit (reduced-chi-square value)

653 normalized by the best fit for each sample and significance cut-off criterion. Fits present in the grey area differ significantly
654 from the best fit. (C) Significant criterion formula between two fits, i and j according to the reference (Kelly et al., 2008).

655

656 Yttrium speciation in the BRs probed by bulk XANES analysis is mainly influenced by the
657 origin of the bauxite ore and tend to corroborate the differences between the lateritic and karstic BRs
658 suggested by the REE patterns, contrary to the microscopic approach. In all samples of lateritic origin,
659 Y was mainly found in the form of xenotime YPO_4 , which could be distinguished from churchite YPO_4 ,
660 confirming the microscopic observations. Given that YPO_4 xenotime particles were also found in karstic
661 BRs using microscopic observation methods, but that the XANES signal indicates that the majority of
662 Y is not in xenotime or churchite phosphate form, we can assume that Y is present in several phases in
663 the karstic BRs. Pellet heterogeneity was also investigated by examining each XANES spectrum
664 collected at different locations in the sample pellet before averaging, confirming the presence of rare
665 YPO_4 particles in karstic BRs (2 out of 27 scans collected) resulting in noisier, more intense spectra and
666 exhibiting the xenotime YPO_4 features (**Figure S4**). However, the majority of Y in karstic BRs is
667 probably incorporated in small quantities in other mineral phases (iron oxyhydroxide, hydroxyapatite)
668 or adsorbed on the surface of other minerals, which would explain why they are not easily detectable by
669 SEM-EDS (below the limit of detection).

670 However, no variability in Y speciation was detected linked to the storage conditions of the
671 tailings, nor their aging time for a given origin.

672

673 **4. Perspectives**

674

675 The information obtained in this study is crucial for the use of BRs as a secondary source of REEs,
676 particularly for the design and implementation of selective recovery processes.

677 First, HREE solubility probably differs as a function of origin. Indeed, the observed difference in
678 speciation may affect HREE recovery yields depending on the origin of the bauxite ore. A comparative
679 study of the dissolution behaviour of HREEs from these different BRs is needed to validate this
680 hypothesis. The solubility of HREEs was found to be very low for lateritic BRs (Lallemant et al., 2022)
681 because of the very low solubility of xenotime. Given the higher REE content in karstic BRs than in
682 lateritic BRs and the difference in HREE speciation, it would be interesting to test and compare similar
683 recovery approaches. Second, the marked variability of BR storage conditions and durations does not
684 appear to have a significant effect on HREE speciation which should consequently facilitate the
685 treatment of tailings stored in different conditions and for different storage times at large scales.

686

687 Although origin appears to be the only parameter that affects HREE speciation, we recall that some
688 geographical disparities may also exist due to variations in the bedrock lithology of a given origin
689 (lateritic or karstic). In our case, bauxites ore from all lateritic BR samples came from the Boké region
690 in Guinea (West Africa) and bauxite ore from all the karstic BR samples came from the region of
691 Provence (South of France). Therefore, to extrapolate these results worldwide, it is crucial to study
692 potential geological differences, including HREE speciation, for a given origin in other geographical
693 regions of the world, such as China, Australia, Brazil or India, which are the main generators of BRs at
694 the present time. In addition, some alumina production sites use a mixture of lateritic and karstic bauxites
695 as ore input, e.g., at the Aluminium of Greece plant (Vind et al., 2018). In these cases, it would be
696 impossible to address the link between the origin of the ore and HREE speciation in the BRs.

697 Finally, a complete understanding of REE speciation in BR remains to be achieved for LREEs, for
698 which no clear speciation has been assigned to date.

699 **5. Conclusion**

700
701
702
703
704
705
706
707
708
709
710
711
712
713
714
715
716
717
718
719
720
721
722
723
724
725
726
727
728
729
730
731
732
733
734

The aim of this study was to perform a multi-scale characterisation of different bauxite residues (BRs) as a function of origin of the ore, of the storage conditions and storage time, with a particular focus on the speciation of Y as a proxy of the behaviour of heavy rare earth elements (HREEs). We have shown that some physico-chemical properties of BRs, such as pH, conductivity or chemical composition of major elements, vary with the storage conditions and storage time and may partially explain the marked variability of physico-chemical properties of BRs reported in the literature. More interestingly, this study has shown that other properties of the BRs, such as the mineralogy of the major phases as well as the chemical composition and speciation of the HREEs varied with the origin of the bauxite ore but were not influenced by the storage conditions or by the age of the BRs. Notably, and to our knowledge, for the first time, we were able to link the origin of the bauxite ore, lateritic or karstic, and the speciation of Y. In the case of lateritic BRs, HREEs are mostly present in the form of pure and crystallized phosphate particles (xenotime). In karstic BRs, HREEs are mainly present in a more complex speciation, probably adsorbed or incorporated in other minerals, including iron oxyhydroxide and hydroxyapatite minerals, although some xenotime phosphate particles were also detected (< 25%). Only the complementarity use of macroscopic, microscopic and spectroscopic approaches enabled us to reach a full understanding of Y speciation in these complex residues. The present study thus paves the way for a study of the potential of BRs for the selective recovery of HREEs in a circular economy context. Our results also underline the importance of considering BRs produced in different parts of the world not as a single material but as incorporating certain disparities as a function of the origin of the ore that may require a range of different extraction processes. It is true for REEs but also for other critical elements including vanadium for example for which such eventual disparities are not documented today.

735 **Declaration of Competing Interest**

736 The authors declare that they have no known competing financial interests or personal relationships that
737 could have appeared to influence the work reported in this paper.

738

739 **Data Availability**

740 Data will be made available on request.

741

742 **Acknowledgments**

743 The authors acknowledge financial support from the CNRS through the MITI interdisciplinary
744 programmes (PRIME 2020:ExtraMet project), the *Agence Nationale de la Recherche* through the
745 RECALL project (ANR-20-CE04-0007). The thesis contract of Claire Lallemand was funded by
746 CEPAC (*Caisse d'épargne Provence Alpes Corse*) through the AMIDEX foundation (Aix-Marseille
747 University). We acknowledge the European Synchrotron Radiation Facility for provision of synchrotron
748 radiation facilities on beamline BM30. Hamed Pourkhorsandi thanks F.R.S.-FNRS for funding. The
749 authors also thank the ACE Partner project that funded the work of Pierre Tamba Oulare (World Bank,
750 the Association of African Universities, the French Development Agency, the Institute of Research for
751 Development and INRIA)

752

753 **Supporting information**

754 Supplementary data associated with this article can be found in the online version at
755 [doi:10.1016/j.jhazmat.2023.132941](https://doi.org/10.1016/j.jhazmat.2023.132941).

756

757

758 **References**

- 759 Adewuyi, S. O., Ahmed, H. A. M., & Ahmed, H. M. A. (2020). Methods of Ore Pretreatment for
760 Comminution Energy Reduction. *Minerals 2020, Vol. 10, Page 423, 10(5), 423.*
761 <https://doi.org/10.3390/MIN10050423>
- 762 Arnaud, C., & Guillon, J.-M. (1989). *Les Gueules Rouges. Un siècle de bauxite dans le Var.* 1st
763 edition CDDP du Var, 1989 and augmented reedition by Association des Gueules rouges du Var,
764 Tourves, 2003.
- 765 Baioumy, H. (2016). Factors controlling the geochemical variations of lateritic bauxites formed upon
766 different parent rocks in Peninsular Malaysia. *Arabian Journal of Geosciences, 9(6), 1–15.*
767 <https://doi.org/10.1007/S12517-016-2476-9/METRICS>
- 768 Balaram, V. (2019). Rare earth elements: A review of applications, occurrence, exploration, analysis,
769 recycling, and environmental impact. *Geoscience Frontiers, 10(4), 1285–1303.*
770 <https://doi.org/10.1016/j.gsf.2018.12.005>
- 771 Bardossy, G. (1982). *Karst Bauxites: Bauxite Deposits on Carbonate Rocks* (Elsevier Science Ltd
772 (ed.); Vol. 14).
- 773 Bea, F. (1996). Residence of REE, Y, Th and U in granites and crustal protoliths; implications for the
774 chemistry of crustal melts. *Journal of Petrology, 37(3).*
775 <https://doi.org/10.1093/petrology/37.3.521>
- 776 Belfqueh, S., Seron, A., Chapron, S., Arrachart, G., & Menad, N. (2022). Evaluating organic acids as
777 alternative leaching reagents for rare earth elements recovery from NdFeB magnets. *Journal of*
778 *Rare Earths.* <https://doi.org/10.1016/J.JRE.2022.04.027>
- 779 Bhukte, P. G., Daware, G. T., Masurkar, S. P., Mahendiran, P., Janbandhu, K., Rao, K. R., Singh, U.,
780 Puttewar, S. P., & Agnihotri, A. (2020). Geochemical, Mineralogical and Petrological
781 Characteristics of Lateritic Bauxite Deposits formed on Deccan Trap Basalt with Reference to
782 High-level and Coastal (low level) Deposits of Maharashtra. *Journal of the Geological Society of*
783 *India, 95(6), 587–598.* <https://doi.org/10.1007/S12594-020-1485-1/METRICS>
- 784 Binnemans, K., Jones, P. T., Blanpain, B., Van Gerven, T., & Pontikes, Y. (2015). Towards zero-
785 waste valorisation of rare-earth-containing industrial process residues: A critical review. *Journal*
786 *of Cleaner Production, 99, 17–38.* <https://doi.org/10.1016/j.jclepro.2015.02.089>
- 787 Borra, C. R., Blanpain, B., Pontikes, Y., Binnemans, K., & Van Gerven, T. (2016). Recovery of Rare
788 Earths and Other Valuable Metals From Bauxite Residue (Red Mud): A Review. *Journal of*
789 *Sustainable Metallurgy, 2(4), 365–386.* <https://doi.org/10.1007/s40831-016-0068-2>
- 790 Borst, A. M., Smith, M. P., Finch, A. A., Estrade, G., Villanova-de-Benavent, C., Nason, P., Marquis,
791 E., Horsburgh, N. J., Goodenough, K. M., Xu, C., Kynický, J., & Geraki, K. (2020). Adsorption
792 of rare earth elements in regolith-hosted clay deposits. *Nature Communications, 11(1), 1–15.*
793 <https://doi.org/10.1038/s41467-020-17801-5>

794 British Geological Survey. (2015). *Risk list 2015: an update to the supply risk index for elements or*
795 *element groups that are of economic value.*
796 <https://www2.bgs.ac.uk/mineralsuk/statistics/risklist.html>

797 Chaurand, P., Collin, B., Couturier, J., Lallemand, C., & Levard, C. (2025). *Insights into Yttrium*
798 *speciation in bauxite residue before and after unconventional leaching experiments [Data set].*
799 <https://doi.org/doi/10.1515/ESRF-ES-806199268>

800 Chen, Y., & Zheng, B. (2019). *sustainability What Happens after the Rare Earth Crisis: A Systematic*
801 *Literature Review.* <https://doi.org/10.3390/su11051288>

802 Couturier, J., Lallemand, C., Levard, C., Chaurand, P., Rose, J., & Collin, B. (2022). Y K edge XAS
803 transmission and XAS fluorescence of Yttrium components at 20K. [Dataset/Spectral Data].
804 *SSHADE/FAME (OSUG Data Center).*
805 https://doi.org/10.26302/SSHADE/EXPERIMENT_JC_20220615_001

806 Cusack, P. B., Courtney, R., Healy, M. G., O' Donoghue, L. M. T., & Ujaczki, É. (2019). An
807 evaluation of the general composition and critical raw material content of bauxite residue in a
808 storage area over a twelve-year period. *Journal of Cleaner Production*, 208, 393–401.
809 <https://doi.org/10.1016/j.jclepro.2018.10.083>

810 Davris, P., Balomenos, E., Taxiarchou, M., Panias, D., & Paspaliaris, I. (2017). Current and
811 Alternative Routes in the Production of Rare Earth Elements Aktuelle und alternative Routen bei
812 der Herstellung von Metallen der Seltenen Erden. *BHM Berg- Und Hüttenmännische*
813 *Monatshefte*, 162(7), 245–251. <https://doi.org/10.1007/s00501-017-0610-y>

814 De Oliveira, S. B., Da Costa, M. L., & Dos Prazeres Filho, H. J. (2016). THE LATERITIC BAUXITE
815 DEPOSIT OF RONDON DO PARÁ: A NEW GIANT DEPOSIT IN THE AMAZON REGION,
816 NORTHERN BRAZIL. *Economic Geology*, 111(5), 1277–1290.
817 <https://doi.org/10.2113/ECONGEO.111.5.1277>

818 Dedy, É., Mouchos, E., Goodenough, K., Williamson, B., & Wall, F. (2014). Rare Earth Elements in
819 Karst-Bauxites: a Novel Untapped European Resource? *ERES 2014 : 1st Conference on*
820 *European Rare Earth Resources, Milos, Greece. (Unpublished)*, 364–375.
821 <https://nora.nerc.ac.uk/id/eprint/508643/>

822 Di Carlo, E., Chen, C. R., Haynes, R. J., Phillips, I. R., & Courtney, R. (2019). Soil quality and
823 vegetation performance indicators for sustainable rehabilitation of bauxite residue disposal areas:
824 A review. In *Soil Research* (Vol. 57, Issue 5, pp. 419–446). CSIRO.
825 <https://doi.org/10.1071/SR18348>

826 Dupont, D., & Binnemans, K. (2015). Recycling of rare earths from NdFeB magnets using a combined
827 leaching/extraction system based on the acidity and thermomorphism of the ionic liquid
828 [Hbet][Tf2N]. *Green Chemistry*, 17(4), 2150–2163. <https://doi.org/10.1039/c5gc00155b>

829 Eheliyagoda, D., Zeng, X., & Li, J. (2020). A method to assess national metal criticality: the
830 environment as a foremost measurement. *Humanities and Social Sciences Communications* 2020

831 7:1, 7(1), 1–12. <https://doi.org/10.1057/s41599-020-00537-4>

832 European Commission. (2020). *Critical Raw Materials for Strategic Technologies and Sectors in the*
833 *EU. A Foresight Study*. <https://doi.org/10.2873/865242>

834 Evans, K. (2016). The History, Challenges, and New Developments in the Management and Use of
835 Bauxite Residue. *Journal of Sustainable Metallurgy*, 2(4), 316–331.
836 <https://doi.org/10.1007/S40831-016-0060-X/FIGURES/14>

837 Farjana, S. H., Huda, N., Parvez Mahmud, M. A., & Saidur, R. (2019). A review on the impact of
838 mining and mineral processing industries through life cycle assessment. *Journal of Cleaner*
839 *Production*, 231, 1200–1217. <https://doi.org/10.1016/j.jclepro.2019.05.264>

840 Fourier, C. (2020). *Les résidus de bauxite de Provence : propriétés physico-chimiques et influence*
841 *sur la formation et le fonctionnement des sols [Thesis]*. Aix-Marseille university (ED 251).

842 Fourier, C., Luglia, M., Keller, C., Hennebert, P., Foulon, J., Ambrosi, J. P., Angeletti, B., & Criquet,
843 S. (2021). How Raw and Gypsum Modified Bauxite Residues Affect Seed Germination, Enzyme
844 Activities, and Root Development of *Sinapis alba*. *Water, Air, and Soil Pollution*, 232(8).
845 <https://doi.org/10.1007/s11270-021-05232-x>

846 Freyssinet, P., Butt, C. R. M., Morris, R. C., & Piantone, P. (2005). Ore-Forming Processes Related to
847 Lateritic Weathering. In *One Hundredth Anniversary Volume*. Society of Economic Geologists.
848 <https://doi.org/10.5382/AV100.21>

849 Gauß Roland, Burkhardt Carlo, Carencotte Frédéric, Gasparon Massimo, Gutfleisch Oliver, Higgins
850 Ian, Karajić Milana, Klossek Andreas, Mäkinen Maija, Schäfer Bernd, Reinhold Schindler, &
851 Badrinath Veluri. (2021). *Rare Earth Magnets and Motors: A European Call for Action. A report*
852 *by the Rare Earth Magnets and Motors Cluster of the European Raw Materials Alliance*.

853 Gentzmann, M. C., Schraut, K., Vogel, C., Gäbler, H. E., Huthwelker, T., & Adam, C. (2021).
854 Investigation of scandium in bauxite residues of different origin. *Applied Geochemistry*, 126.
855 <https://doi.org/10.1016/j.apgeochem.2021.104898>

856 Goodland, R. (2012). Responsible mining: The key to profitable resource development. *Sustainability*,
857 4(9), 2099–2126. <https://doi.org/10.3390/SU4092099>

858 Gräfe, M., Power, G., & Klauber, C. (2011). Bauxite residue issues: III. Alkalinity and associated
859 chemistry. *Hydrometallurgy*, 108(1–2). <https://doi.org/10.1016/j.hydromet.2011.02.004>

860 Grohol, M., & Veeh, C. (2023). *Study on the Critical Raw Materials for the EU 2023 Final Report*.
861 <https://doi.org/10.2873/725585>

862 Gschneidner, K. A. (1990). Physical properties of the rare earth metals. *Bulletin of Alloy Phase*
863 *Diagrams*, 11(3), 216–224. <https://doi.org/10.1007/BF03029283>

864 Gu, J., Huang, Z., Fan, H., Jin, Z., Yan, Z., & Zhang, J. (2013). *Mineralogy, geochemistry, and*
865 *genesis of lateritic bauxite deposits in the Wuchuan-Zheng'an-Daozhen area, Northern Guizhou*
866 *Province, China*. <https://doi.org/10.1016/j.gexplo.2013.03.003>

867 Hatayama, H., & Tahara, K. (2014). *Criticality Assessment of Metals for Japan's Resource Strategy*.

868 <https://doi.org/10.2320/matertrans.M2014380>

869 Haynes, W. M. (2014). Section 14 - Geophysics, Astronomy, and Acoustics. In *CRC Handbook of*
870 *Chemistry and Physics*. <https://doi.org/10.1201/b17118-19>

871 Hermassi, M., Granados, M., Valderrama, C., Ayora, C., & Cortina, J. L. (2022). Recovery of rare
872 earth elements from acidic mine waters: An unknown secondary resource. *Science of the Total*
873 *Environment*, 810. <https://doi.org/10.1016/j.scitotenv.2021.152258>

874 Horovitz, C. T. (1975). *Scandium : its occurrence, chemistry, physics, metallurgy, biology, and*
875 *technology*. Academic Press. <https://doi.org/10.1016/B978-0-12-355850-3.X5001-1>

876 Huang, Y., He, H., Liang, X., Bao, Z., Tan, W., Ma, L., Zhu, J., Huang, J., & Wang, H. (2021).
877 Characteristics and genesis of ion adsorption type REE deposits in the weathering crusts of
878 metamorphic rocks in Ningdu, Ganzhou, China. *Ore Geology Reviews*, 135, 104173.
879 <https://doi.org/10.1016/J.OREGEOREV.2021.104173>

880 International Aluminium Institute. (2023, January 26). *Alumina Production*. [https://international-](https://international-aluminium.org/statistics/alumina-production/)
881 [aluminium.org/statistics/alumina-production/](https://international-aluminium.org/statistics/alumina-production/)

882 International Energy Agency. (2021). *The Role of Critical World Energy Outlook Special Report*
883 *Minerals in Clean Energy Transitions*. [https://www.iea.org/reports/the-role-of-critical-minerals-](https://www.iea.org/reports/the-role-of-critical-minerals-in-clean-energy-transitions)
884 [in-clean-energy-transitions](https://www.iea.org/reports/the-role-of-critical-minerals-in-clean-energy-transitions)

885 Jones, B. E. H., Haynes, R. J., & Phillips, I. R. (2012). Cation and anion leaching and growth of
886 *Acacia saligna* in bauxite residue sand amended with residue mud, poultry manure and
887 phosphogypsum. *Environmental Science and Pollution Research*, 19(3).
888 <https://doi.org/10.1007/s11356-011-0630-1>

889 Kelly, S. D., Hesterberg, D., & Ravel, B. (2008). Analysis of Soils and Minerals Using X-ray
890 Absorption Spectroscopy. *Methods of Soil Analysis, Part 5: Mineralogical Methods*, 5, 387–463.
891 <https://doi.org/10.2136/SSSABOOKSER5.5.C14>

892 Khairul, M. A., Zanganeh, J., & Moghtaderi, B. (2019). The composition, recycling and utilisation of
893 Bayer red mud. *Resources, Conservation and Recycling*, 141, 483–498.
894 <https://doi.org/10.1016/j.resconrec.2018.11.006>

895 Khaitan, S., Dzombak, D. A., & Lowry, G. V. (2009). Neutralization of Bauxite Residue with Acidic
896 Fly Ash. *Environmental Engineering Science*, 26(2). <https://doi.org/10.1089/ees.2007.0232>

897 Khaitan, S., Dzombak, D. A., Swallow, P., Schmidt, K., Fu, J., & Lowry, G. V. (2010). Field
898 Evaluation of Bauxite Residue Neutralization by Carbon Dioxide, Vegetation, and Organic
899 Amendments. *Journal of Environmental Engineering*, 136(10).
900 [https://doi.org/10.1061/\(asce\)ee.1943-7870.0000230](https://doi.org/10.1061/(asce)ee.1943-7870.0000230)

901 Klauber, C., Gräfe, M., & Power, G. (2011). Bauxite residue issues: II. options for residue utilization.
902 *Hydrometallurgy*, 108(1–2). <https://doi.org/10.1016/j.hydromet.2011.02.007>

903 Klopogge, J. T., Ruan, H. D., & Frost, R. L. (2002). Thermal decomposition of bauxite minerals:
904 Infrared emission spectroscopy of gibbsite, boehmite and diaspore. *Journal of Materials Science*,

905 37(6), 1121–1129. <https://doi.org/10.1023/A:1014303119055/METRICS>

906 Kong, X., Guo, Y., Xue, S., Hartley, W., Wu, C., Ye, Y., & Cheng, Q. (2017). Natural evolution of
907 alkaline characteristics in bauxite residue. *Journal of Cleaner Production*, *143*, 224–230.
908 <https://doi.org/10.1016/J.JCLEPRO.2016.12.125>

909 Kong, X., Li, M., Xue, S., Hartley, W., Chen, C., Wu, C., Li, X., & Li, Y. (2017). Acid transformation
910 of bauxite residue: Conversion of its alkaline characteristics. *Journal of Hazardous Materials*,
911 *324*(Pt B), 382–390. <https://doi.org/10.1016/J.JHAZMAT.2016.10.073>

912 Lallemand, C., Ambrosi, J. P., Borschneck, D., Angeletti, B., Chaurand, P., Campos, A., Desmau, M.,
913 Fehlauer, T., Auffan, M., Labille, J., Roche, N., Poizat, L., Collin, B., Rose, J., & Levard, C.
914 (2022). Potential of Ligand-Promoted Dissolution at Mild pH for the Selective Recovery of Rare
915 Earth Elements in Bauxite Residues. *ACS Sustainable Chemistry & Engineering*, *10*(21), 6942–
916 6951. <https://doi.org/10.1021/acssuschemeng.1c08081>

917 Li, M. Y. H., Zhou, M. F., & Williams-Jones, A. E. (2019). The Genesis of Regolith-Hosted Heavy
918 Rare Earth Element Deposits: Insights from the World-Class Zudong Deposit in Jiangxi
919 Province, South China. *Economic Geology*, *114*(3), 541–568.
920 <https://doi.org/10.5382/ECONGEO.4642>

921 Li, Z., Din, J., Xu, J., Liao, C., Yin, F., Lü, T., Cheng, L., & Li, J. (2013). *Discovery of the REE*
922 *minerals in the Wulong-Nanchuan bauxite deposits, Chongqing, China: Insights on conditions of*
923 *formation and processes*. <https://doi.org/10.1016/j.gexplo.2013.06.016>

924 Liu, X., Wang, Q., Zhang, Q., Zhang, Y., & Li, Y. (2016). Genesis of REE minerals in the karstic
925 bauxite in western Guangxi, China, and its constraints on the deposit formation conditions. *Ore*
926 *Geology Reviews*, *75*, 100–115. <https://doi.org/10.1016/J.OREGEOREV.2015.12.015>

927 Ma, Y., Preveniou, A., Kladis, A., & Pettersen, J. B. (2022). Circular economy and life cycle
928 assessment of alumina production: Simulation-based comparison of Pedersen and Bayer
929 processes. *Journal of Cleaner Production*, *366*. <https://doi.org/10.1016/J.JCLEPRO.2022.132807>

930 Macías-Pérez, L. A., Levard, C., Barakat, M., Angeletti, B., Borschneck, D., Poizat, L., Achouak, W.,
931 & Auffan, M. (2022). Contrasted microbial community colonization of a bauxite residue deposit
932 marked by a complex geochemical context. *Journal of Hazardous Materials*, *424*.
933 <https://doi.org/10.1016/j.jhazmat.2021.127470>

934 Menzies, N. W., & Kopittke, P. M. (2021). Seawater neutralization and gypsum amelioration of
935 bauxite refining residue to produce a plant growth medium. *Science of the Total Environment*,
936 *763*. <https://doi.org/10.1016/j.scitotenv.2020.143046>

937 Michalowicz, A., Moscovici, J., Muller Bouvet, D., & Provost, K. (2009). MAX: Multiplatform
938 Applications for XAFS. *Journal of Physics: Conference Series*, *190*(1), 012034.
939 <https://doi.org/10.1088/1742-6596/190/1/012034>

940 Mondillo, N., Balassone, G., Boni, M., Chelle-Michou, C., Cretella, S., Mormone, A., Putzolu, F.,
941 Santoro, L., Scognamiglio, G., & Tarallo, M. (2019). Rare Earth Elements (REE) in Al- and Fe-

942 (Oxy)-Hydroxides in Bauxites of Provence and Languedoc (Southern France): Implications for
943 the Potential Recovery of REEs as By-Products of Bauxite Mining. *Minerals* 2019, Vol. 9, Page
944 504, 9(9), 504. <https://doi.org/10.3390/MIN9090504>

945 Mordberg, L. E., Stanley, C. J., & Germann, K. (2001). Mineralogy and geochemistry of trace
946 elements in bauxites: the Devonian Schugorsk deposit, Russia. *Mineralogical Magazine*, 65(1).
947 <https://doi.org/10.1180/002646101550145>

948 Negrão, L. B. A., & Costa, M. L. da. (2021). Mineralogy and geochemistry of a bauxite-bearing
949 lateritic profile supporting the identification of its parent rocks in the domain of the huge Carajás
950 iron deposits, Brazil. *Journal of South American Earth Sciences*, 108, 103164.
951 <https://doi.org/10.1016/J.JSAMES.2021.103164>

952 Newville, M. (2013). Larch: An Analysis Package for XAFS and Related Spectroscopies. *Journal of*
953 *Physics: Conference Series*, 430(1), 012007. <https://doi.org/10.1088/1742-6596/430/1/012007>

954 Ochsenkiihn-Petropulu, M., Lyberopulu, T., Ochsenkiihn ', K. M., & Parissakis, G. (1996). Recovery
955 of lanthanides and yttrium from red mud leaching by selective. *Analytica Chimica Acta*, 319,
956 249–254.

957 OECD. (2019). *Global Material Resources Outlook to 2060 Economic drivers and environmental*
958 *consequences*.

959 Peiravi, M., Dehghani, F., Ackah, L., Baharlouei, A., Godbold, J., Liu, J., Mohanty, M., & Ghosh, T.
960 (2021). A Review of Rare-Earth Elements Extraction with Emphasis on Non-conventional
961 Sources: Coal and Coal Byproducts, Iron Ore Tailings, Apatite, and Phosphate Byproducts. In
962 *Mining, Metallurgy and Exploration* (Vol. 38, Issue 1). [https://doi.org/10.1007/s42461-020-](https://doi.org/10.1007/s42461-020-00307-5)
963 [00307-5](https://doi.org/10.1007/s42461-020-00307-5)

964 Pingitore, N., Clague, J., & Gorski, D. (2014). Round Top Mountain rhyolite (Texas, USA), a
965 massive, unique Y-bearing-fluorite-hosted heavy rare earth element (HREE) deposit. *JOURNAL*
966 *OF RARE EARTHS*, 32(1). [https://doi.org/10.1016/S1002-0721\(14\)60037-5](https://doi.org/10.1016/S1002-0721(14)60037-5)

967 Power, G., Gräfe, M., & Klauber, C. (2011). Bauxite residue issues: I. Current management, disposal
968 and storage practices. *Hydrometallurgy*, 108(1–2), 33–45.
969 <https://doi.org/10.1016/J.HYDROMET.2011.02.006>

970 Prior, T., Giurco, D., Mudd, G., Mason, L., & Behrisch, J. (2012). Resource depletion, peak minerals
971 and the implications for sustainable resource management. *Global Environmental Change*, 22(3),
972 577–587. <https://doi.org/10.1016/J.GLOENVCHA.2011.08.009>

973 Qu, Y., & Lian, B. (2013). Bioleaching of rare earth and radioactive elements from red mud using
974 *Penicillium tricolor* RM-10. *Bioresource Technology*, 136, 16–23.
975 <https://doi.org/10.1016/j.biortech.2013.03.070>

976 Radomirovic, T., Smith, P., Southam, D., Tashi, S., & Jones, F. (2013). Crystallization of sodalite
977 particles under Bayer-type conditions. *Hydrometallurgy*, 137, 84–91.
978 <https://doi.org/10.1016/J.HYDROMET.2013.05.006>

- 979 Radusinović, S., & Papadopoulos, A. (2021). The potential for REE and associated critical metals in
980 karstic bauxites and bauxite residue of Montenegro. *Minerals*, 11(9).
981 <https://doi.org/10.3390/min11090975>
- 982 Ramprasad, C., Gwenzi, W., Chaukura, N., Izyan, N., Azelee, W., Rajapaksha, A. U., Naushad, M., &
983 Rangabhashiyam, S. (2022). Strategies and options for the sustainable recovery of rare earth
984 elements from electrical and electronic waste. *Chemical Engineering Journal*, 442, 1385–8947.
985 <https://doi.org/10.1016/j.cej.2022.135992>
- 986 Rayzman, V. L. (1998). Red mud revisited - Special paper on scandium potential. *Aluminium Today*,
987 10(5), 64–68. <https://www.proquest.com/openview/40883cf8bf5b1dae72ffc50c5a8ec9a7/1?pq-origsite=gscholar&cbl=1056345>
- 989 Reinhardt, N., Proenza, J. A., Villanova-De-benavent, C., Aiglsperger, T., Bover-Arnal, T., Torró, L.,
990 Salas, R., & Dziggel, A. (2018). Geochemistry and mineralogy of rare earth elements (REE) in
991 bauxitic ores of the catalan coastal range, NE Spain. *Minerals*, 8(12).
992 <https://doi.org/10.3390/min8120562>
- 993 Rivera, R. M., Ounoughene, G., Malfliet, A., Vind, J., Panias, D., Vassiliadou, V., Binnemans, K., &
994 Van Gerven, T. (2019). A Study of the Occurrence of Selected Rare-Earth Elements in
995 Neutralized–Leached Bauxite Residue and Comparison with Untreated Bauxite Residue. *Journal*
996 *of Sustainable Metallurgy 2019 5:1*, 5(1), 57–68. <https://doi.org/10.1007/S40831-018-0206-0>
- 997 Santini, T. C., & Fey, M. V. (2013). Spontaneous vegetation encroachment upon bauxite residue (red
998 mud) as an indicator and facilitator of in situ remediation processes. *Environmental Science and*
999 *Technology*, 47(21). <https://doi.org/10.1021/es402924g>
- 1000 Scheidel, A., Del Bene, D., Liu, J., Navas, G., Mingorría, S., Demaria, F., Avila, S., Roy, B., Ertör, I.,
1001 Temper, L., & Martínez-Alier, J. (2020). Environmental conflicts and defenders: A global
1002 overview. *Global Environmental Change*, 63.
1003 <https://doi.org/10.1016/J.GLOENVCHA.2020.102104>
- 1004 Senaputra, A., Fawell, P., Jones, F., & Smith, P. (2012). The impact of desilication product on bauxite
1005 residue flocculation. *9th Alumina Quality Workshop*, 186–192.
1006 https://espace.curtin.edu.au/bitstream/20.500.11937/39817/2/191263_191263.pdf
- 1007 Sidibe, M., & Yalcin, M. G. (2018). *Petrography, mineralogy, geochemistry and genesis of the Balaya*
1008 *bauxite deposits in Kindia region, Maritime Guinea, West Africa*.
1009 <https://doi.org/10.1016/j.jafrearsci.2018.08.017>
- 1010 Smith, P. (2009). The processing of high silica bauxites — Review of existing and potential processes.
1011 *Hydrometallurgy*, 98(1–2), 162–176. <https://doi.org/10.1016/J.HYDROMET.2009.04.015>
- 1012 Snars, K., & Gilkes, R. J. (2009). Evaluation of bauxite residues (red muds) of different origins for
1013 environmental applications. *Applied Clay Science*, 46(1).
1014 <https://doi.org/10.1016/j.clay.2009.06.014>
- 1015 Suss, A., Panov, A., Kozyrev, A., Kuznetsova, N., & Gorbachev, S. (2018). Specific features of

1016 scandium behavior during sodium bicarbonate digestion of red mud. *Minerals, Metals and*
1017 *Materials Series, Part F4*, 165–173. https://doi.org/10.1007/978-3-319-72284-9_22/COVER

1018 Taylor, S. R., & McLennan, S. M. (1985). The Continental Crust: Its Composition and Evolution.
1019 *Geological Magazine*, 122(6), 673–674. <https://doi.org/10.1017/S0016756800032167>

1020 Torró, L., Proenza, J. A., Aiglsperger, T., Bover-Arnal, T., Villanova-de-Benavent, C., Rodríguez-
1021 García, D., Ramírez, A., Rodríguez, J., Mosquea, L. A., & Salas, R. (2017). Geological,
1022 geochemical and mineralogical characteristics of REE-bearing Las Mercedes bauxite deposit,
1023 Dominican Republic. *Ore Geology Reviews*, 89. <https://doi.org/10.1016/j.oregeorev.2017.06.017>

1024 U.S. Geological Survey, D. of the interior. (2022). 2022 Final List of Critical Minerals. In *Federal*
1025 *Register, Vol. 87, No. 37* (pp. 10381–10382). American Association for the Advancement of
1026 Science.

1027 Vind, J., Malfliet, A., Blanpain, B., Tsakiridis, P. E., Tkaczyk, A. H., Vassiliadou, V., & Panias, D.
1028 (2018). Rare earth element phases in bauxite residue. *Minerals*, 8(2).
1029 <https://doi.org/10.3390/min8020077>

1030 Wagh, A. S., & Pinnock, W. R. (1987). Occurrence of scandium and rare earth elements in Jamaican
1031 bauxite waste. *Economic Geology*, 82(3), 757–761. <https://doi.org/10.2113/gsecongeo.82.3.757>

1032 Wong, J. W. C., & Ho, G. E. (1991). Effects of gypsum and sewage sludge amendment on physical
1033 properties of fine bauxite refining residue. *Soil Science*, 152(5).
1034 <https://doi.org/10.1097/00010694-199111000-00003>

1035 Wu, Y., Li, M., Fu, D., Santini, T. C., Jiang, J., Hartley, W., & Xue, S. (2020). Simulation study for
1036 the formation of alkaline efflorescence on bauxite residue disposal areas following the
1037 phosphogypsum addition. *Journal of Cleaner Production*, 262.
1038 <https://doi.org/10.1016/j.jclepro.2020.121266>

1039 Xue, S., Zhu, F., Kong, X., Wu, C., Huang, L., Huang, N., & Hartley, W. (2016). A review of the
1040 characterization and revegetation of bauxite residues (Red mud). *Environmental Science and*
1041 *Pollution Research*, 23(2). <https://doi.org/10.1007/s11356-015-4558-8>

1042 Yang, F., Kubota, F., Baba, Y., Kamiya, N., & Goto, M. (2013). Selective extraction and recovery of
1043 rare earth metals from phosphor powders in waste fluorescent lamps using an ionic liquid
1044 system. *Journal of Hazardous Materials*, 254–255(1), 79–88.
1045 <https://doi.org/10.1016/J.JHAZMAT.2013.03.026>

1046 Zepf, V., Simmons, J., Reller, A., Ashfield, M., & Rennie, C. (2014). *Materials critical to the energy*
1047 *industry. An introduction. 2nd edition.*

1048 Zhu, F., Xue, S., Hartley, W., Huang, L., Wu, C., & Li, X. (2016). Novel predictors of soil genesis
1049 following natural weathering processes of bauxite residues. *Environmental Science and Pollution*
1050 *Research*, 23(3). <https://doi.org/10.1007/s11356-015-5537-9>

1051