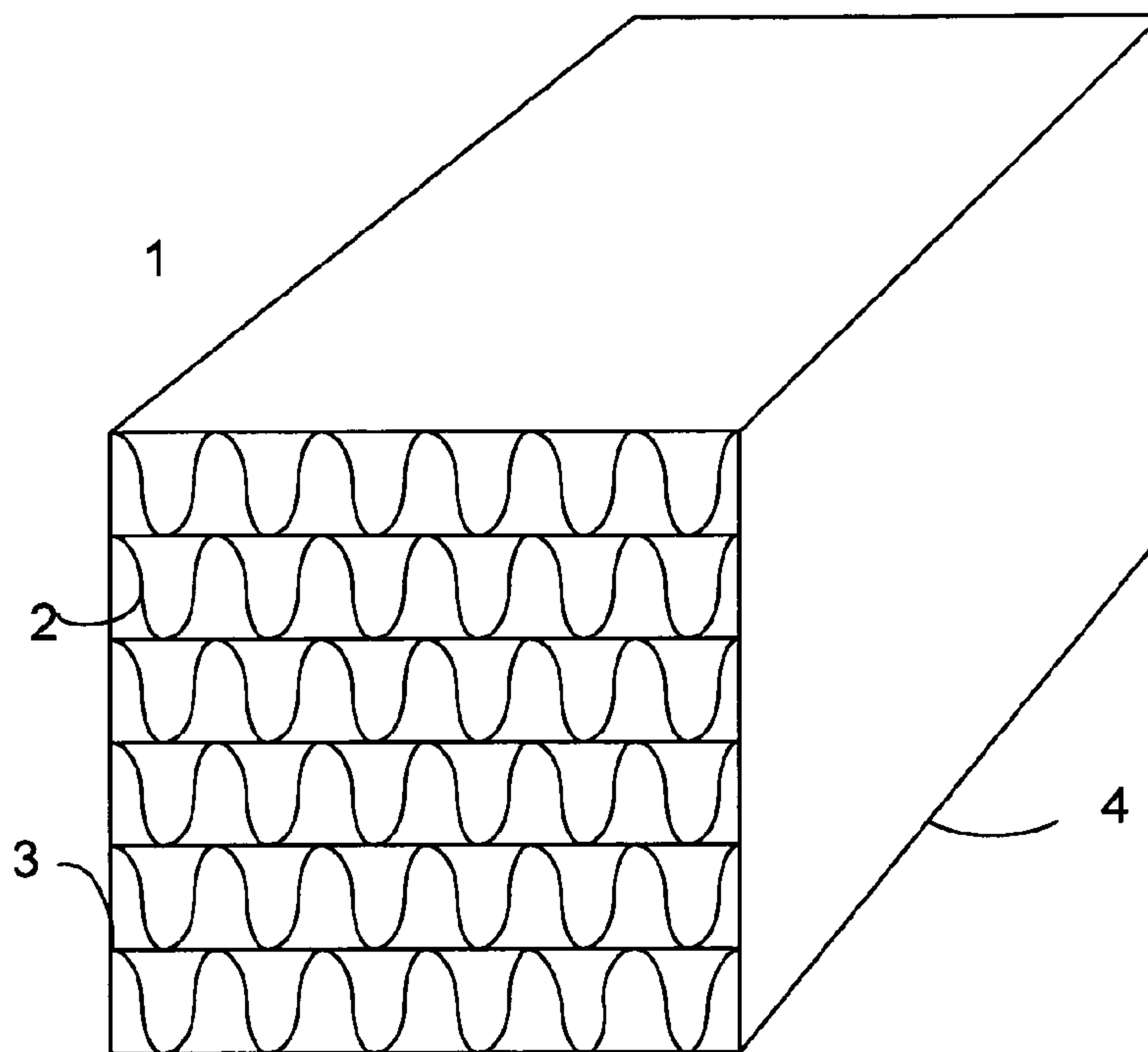




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(54) Titre : PROCÉDE ET CATALYSEUR POUR EXTRACTION D'OXYDES D'AZOTE DANS UN GAZ DE COMBUSTION
 (54) Title: METHOD AND CATALYST FOR REMOVAL OF NITROGEN OXIDES IN A FLUE GAS



(57) **Abrégé/Abstract:**

The invention relates to a method and a catalyst for removal of nitrogen oxides in a flue gas from a combustion engine or gas turbine by injecting a reducing agent and reducing the ni-trogen oxides in the presence of a catalyst. The catalyst is a zeolite based catalyst on a corrugated monolithic substrate, the substrate has a density of 50- 300g/l and a porosity of at least 50%. The monolithic substrate is a paper of high silica con-tent glass or a paper of E-glass fibre with a layer of diatomaceous earth or a layer of titania, and the catalyst is a Fe-β zeolite.

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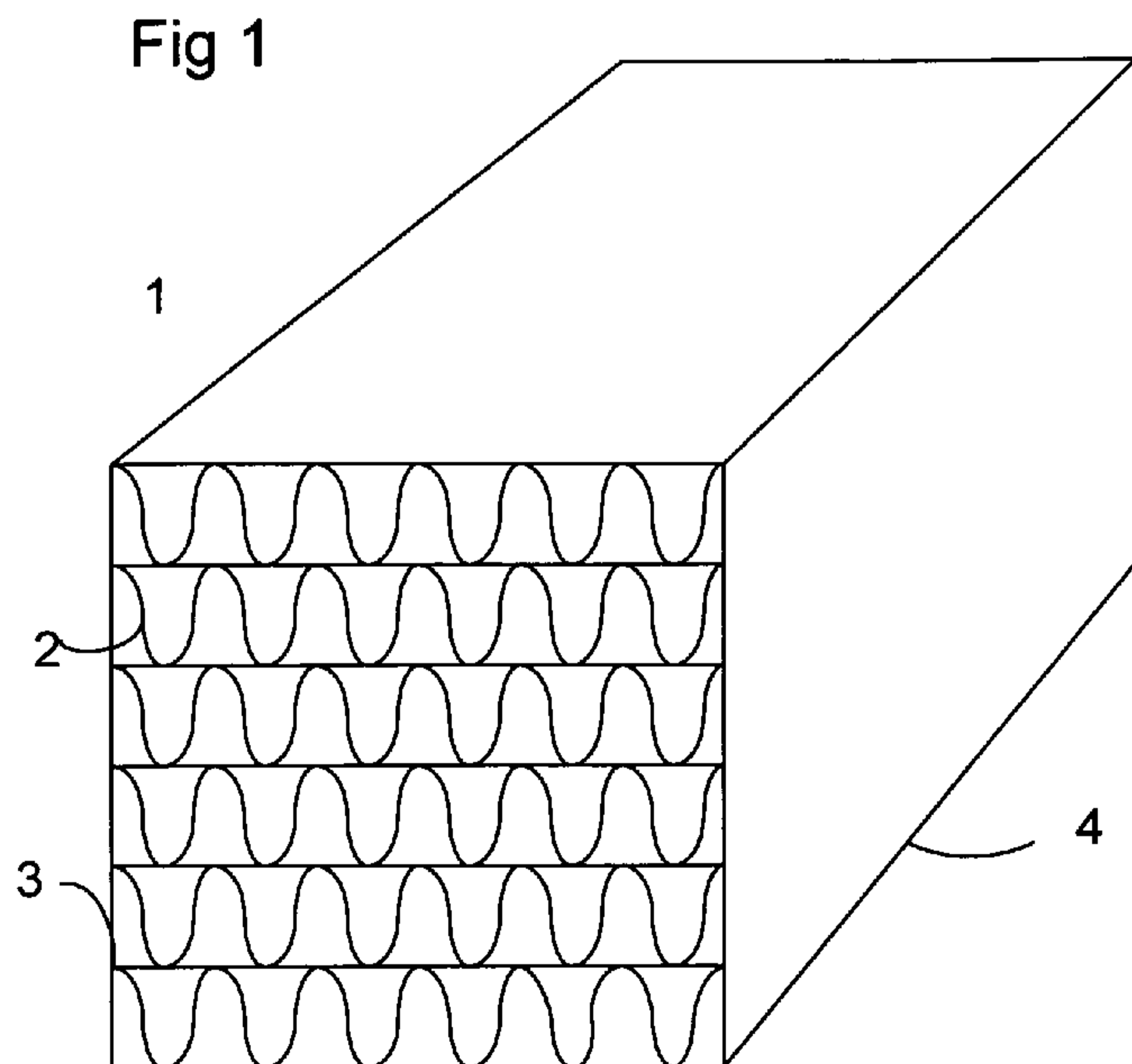
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**Title: METHOD AND CATALYST FOR
REMOVAL OF NITROGEN OXIDES IN A FLUE GAS**

5 The invention relates to removal of nitrogen oxides, NO_x,
from exhaust gases and flue gases from combustion engines
and gas turbines.

10 The invention is specifically directed to a catalytic process
for NO_x removal with a catalyst comprising zeolite on a
monolithic substrate.

Methods for removing nitrogen oxides from combustion engines
exhaust gases are known in the art.

15 JP 2000/246111 discloses a zeolite catalyst on a porous
substrate. The substrate is prepared by forming a gel of
alumina silica on an oxide support. The gel is then dried,
baked and the zeolite can then be applied without peeling.

20 US patent No. 7,431,904 B2 discloses a process for catalytic
reduction of nitrogen oxides in a flue gas by reduction
with ammonia. The catalyst is supported by a monolithic
structure comprising titania in the form of anatase
and diatomaceous earth. The catalyst comprises a layer of
25 oxides or sulphates of V, W, Mn, Nb, Mo, Ni, Fe or Cu, or
of Pt or Pd. These compounds are expensive, and the catalyst
is expected to operate below 500°C, but none of the
components are ideal for operation at high temperature due
to ammonia oxidation activity.

30

Another method for purifying exhaust gas by NO_x removal is
described by European Patent Number EP 0 667 181 B1. By

this method, nitrogen oxides are catalytically reduced by injection of ammonia acetate. The catalyst is a synthetically produced zeolite (mordenite) containing iron. The catalyst may also comprise Pt, Rh or Pd to obtain that CO is oxidized. The zeolite may be applied on a monolithic catalyst carrier, which is either ceramic or metallic or transformed into a monolithic body. The catalyst has been shown to possess improved activity only up to 350°C compared to vanadium/titania based catalysts.

10

In US patent No. 4,961,917 a catalyst is described, which promotes NO_x reduction by ammonia in a gaseous stream. The catalyst is a zeolite having a silica/alumina ratio of at least 10 and a pore structure interconnected in all three dimensions, and comprising an iron or copper promoter. However, there is no mention of a carrier, matrix or substrate, which is needed for use in bigger installations.

15

A catalyst for exhaust gas clean-up is disclosed in US 2001/0048971 (JP 11171668 A2), where a zeolite catalyst is formed on a mullite substrate in the shape as a honeycomb. The catalytic layer is formed during a heat treatment from the substrate and from a layer on it, such as an aqueous alkali solution. The heat treatment lasts up to 30 days, and the formed catalytic layer is typically 300-350 µm.

20

25

Also JP 10156181 discloses a catalyst for exhaust gas purification. A thin layer of active catalytic Pt, Rh, Ir and/or Pd supported by an oxide is applied on a porous ceramic material, typically cordierite. The ceramic material may be reinforced by inorganic fibres, and the whole cata-

30

lyst is preferably in a shape of a honeycomb. Still, the metals from the platinum group are expensive.

5 It is an object of the invention to provide a method and a catalyst for efficient removal of NO_x from exhaust gases at temperatures above 400°C, and where the catalyst shows improved strength and catalytic activity during quick heating or cooling.

10 Pursuant to the above object, the invention provides a method and a catalyst for removal of nitrogen oxides in a flue gas from a combustion engine or gas turbine by injecting a reducing agent and reducing the nitrogen oxides in the presence of a catalyst. The catalyst is a zeolite based
15 catalyst on a corrugated monolithic substrate, the substrate having a wall density of at least 50g/l but not more than 300g/l and a porosity of at least 50%. The monolithic substrate is a paper of high silica content glass or a paper of E-glass fibre. The paper has a layer of diatomaceous
20 earth or a layer of titania, and the catalyst is a Fe-β zeolite.

This catalyst has the advantage that the catalytic zeolite layer does not peel off from the monolithic substrate during
25 start and stop of a combustion engine or a gas turbine. Simultaneously, the catalyst has shown to possess improved catalytic activity.

The invention provides a method and catalyst for high conversion of NO_x and high resistance against frequent changes
30 in temperature between cold and hot.

The catalytic material is applied on a monolithic substrate, which has the form of plane or corrugated plates. The substrate is made from sheets of E-glass fibres or from sheets of a glass with high silicon content and with a layer of TiO₂ or diatomaceous earth.

The high silicon content glass contains 94-95% by weight SiO₂, 4-5% by weight Al₂O₃ and some Na₂O, these fibres have a density of 2000-2200 g/l with a fibre diameter is 8-10 μm. An example is the commercially available SILEX staple fiber.

The E-glass contains 52-56% by weight SiO₂, 12-16% by weight Al₂O₃, 5-10% by weight B₂O₃, 0-1.5 % by weight TiO₂, 0-5% by weight MgO, 16-25% by weight CaO, 0-2% by weight K₂O/Na₂O and 0-0.8% by weight Fe₂O₃.

The material of the substrate is chosen, so the density of the substrate is at least 50g/l, but not higher than 300g/l material, and the porosity of the substrate wall is at least 50% by volume of the material.

The porosity of the monolithic substrate is obtained by the pores, which have a depth between 50 μm and 200 μm and a diameter between 1 μm and 30 μm.

The catalytic material is applied on the substrate as a layer with a thickness of 10-150 μm. The catalyst is a Fe-β zeolite.

The catalyst is applied by dipping the monolithic substrate into aqueous slurry of fine particles of zeolite, a binder

and an anti-foam agent. The size of the particles is not more than 50 μm . The binder is preferably a silica sol binder, and the antifoam agent is a silicone antifoam agent.

5 The coated substrate is dried and subsequently calcinated at 400-650°C, preferably 540-560°C, most preferably at 550°C.

10 A catalyst element comprises layers of corrugated plates, which are separated from each other by plane plates. Catalyst elements can be in the form of boxes or cylinders.

15 One or more elements are installed in the flue gas duct from a combustion engine or gas turbine. A reducing agent is injected upstream of the catalyst, the agent can be ammonia, an aqueous solution of ammonia or of urea or other fluids, which will disintegrate into ammonia in the hot flue gas upstream of the catalyst.

20 Void of a catalyst element is 65-85%, preferably 70-80%, typically 75%.

25 The catalyst of the invention has proved to withstand the severe conditions, when an engine or a gas turbine is started or stopped and the flue gas temperature quickly increases or decreases. When the engine is heated up, the temperature will be from 400°C to at least 620°C.

30 Fig. 1 is a schematic drawing showing a cross-sectional view of the catalyst to be used in the method of present invention.

Fig. 2 is a schematic drawing showing a cross-sectional view of the wall of the catalyst to be used in the method of present invention.

5 Fig. 3 is a diagram showing NO_x conversion and NH₃ slip during purification according to the method of the invention.

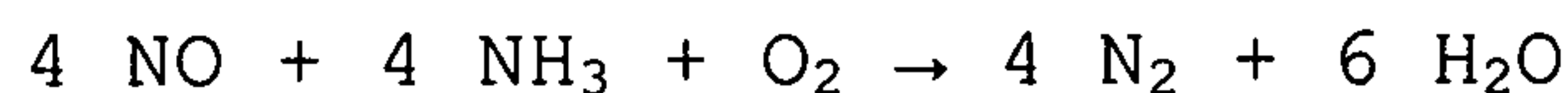
10 Fig. 4 is a diagram showing NH₃ slip during purification according to the method of the invention.

Fig. 5 is a schematic drawing showing a more detailed cross-sectional view of the wall of the catalyst of present invention.

15

Self-igniting combustion engines operate with excess air, and thus the combustion creates poisonous nitrogen oxides, NO_x. The NO_x can be removed from the flue gas by converting it to free nitrogen with a reducing agent often ammonia in the presence of a catalyst by selective, catalytic reduction:

20



Catalysts, where zeolite is the active substance, are most often applied as a catalytic layer on a substrate. Such a layer is sensitive against thermal influence, as it may crack and peel-off. The thermal influence can be severe, as the temperature of a flue gas from a simple cycle peaker

30

unit gas turbine may often increase from ambient to 400-620°C in few minutes, when a cold gas turbine is started.

A specific embodiment of the invention is shown by Fig. 1 and Fig. 2. Fig. 1 shows a catalyst 1 in shape of a box. It consists of corrugated plates 2, which are supported and separated from each other by plates 3, and the plates are mounted in a shell 4. Typical dimensions for a catalyst element are 466mm x 466mm x 322mm or 466mm x 466mm x 560mm, where 322mm and 560mm are the height (when the gas flows in a vertical direction).

Fig. 2 shows a part of a corrugated plate. The monolithic substrate 10 is a paper made from glass fibres with high silicon content. Alternatively, it is an E-glass fibre monolithic paper. The paper is coated with a layer of diatomaceous earth or with a layer of titania. The substrate 10 has a low density and a high porosity. The substrate plate has a thickness of 0.4mm.

The separating plates, liners, have the same composition and thickness as the corrugated plates.

The zeolite based catalyst 11 is applied on the substrate 10 as a 10-150 µm thick layer.

The structure of the catalyst is shown in more detailed by Fig. 5. The substrate 10 covered by diatomaceous earth or titania is provided with a layer 11 of the zeolite based catalyst. The catalytic layer penetrates into the pores 12. These pores are between 50µm and 200µm deep, most of the

pores are about 100 μ m. The diameter of the pores is between 1 μ m and 30 μ m, where the size of 10 μ m is the typical size.

The present invention is especially useful for NO_x removal
5 from flue gas from gas turbines, combustion engines, where
some examples are diesel engines, larger diesel driven
ships, two stroke engines, diesel engine power generators
often used as back-up, from incineration plants and from
10 other flue gasses with high content of nitrogen oxides and
having quick alterations of the temperature.

EXAMPLES

A number of catalyst elements were produced from a cata-
15 lytic zeolite, Zeolyst CP-1724, which is a Fe- β zeolite,
from a binder Levasil 200E/20%, which is a silica sol
binder and from a silicone antifoam agent AT-47.
8000 g Levasil 200E/20%, 10 000 g Zeolyst CP-1724 and 80 g
SE-47 were milled in a 50 l bucket together with 5 l glass
20 beads \emptyset 3mm for one hour. The obtained size of the parti-
cles was 50 μ m. 7 300 g demineralised water was added re-
sulting in slurry with 43% by weight solid particles. Then
8 500 g demineralised water was added to obtain a 33% by
weight solid slurry.

25

The monolithic substrate was E-glass fibre paper with a
layer of titania on it and formed as plane and corrugated
plates with a thickness of 0.4mm and a density of 200 g/l
and a porosity of 70%.

30

The E-glass contained 54.3% by weight SiO₂, 15.2% by weight
Al₂O₃, 6.48% by weight B₂O₃, 0.59% by weight TiO₂, 0.67% by

weight MgO, 21.91% by weight CaO, 0.3% by weight K₂O, 0.5% by weight Na₂O.

The monolithic substrates were dipped in the slurry for 10 seconds, while they were totally covered by the slurry. Then they were lifted and the surplus slurry dripped off. The monoliths were simultaneously blown with air.

Between the dipping of monoliths, the content of solid particles in the slurry was checked and maintained at 33%.

After drying for two days the monoliths were calcinated 10 hours at 60°C, 2 hours at 100°C and 2 hours at 550°C. The resulting catalytic layer was 60µm thick.

The resulting catalyst monolith had a void of 75%.

Finally, the catalyst elements were encased in steel cassettes.

The catalyst, which was prepared as described above, was tested. Three of the prepared catalyst elements were tested at 550°C in a flue gas stream containing 65ppm NO_x. The obtained NO_x conversion and corresponding NH₃ slip are given in Table 1.

Table 1

Element	NO _x conversion	NH ₃ slip
1	98.0 %	5 ppm
2	94.5 %	5 ppm
3	94.7 %	5 ppm

A second test was performed in a flue gas containing 30 ppm NO_x and ammonia was injected into the flue gas.

5

The contents of NO_x and NH₃ were measured outlet of the catalyst at 200°C, 300°C, 350°C, 400°C, 500°C and 550°C, and the NO_x conversion and NH₃ slip were determined.

10 The second test was conducted twice, and the results were plotted as shown in Fig. 3, where □ depict the NO_x conversion, while and ♦ depicts the NH₃ slip at the six test temperatures.

15 It can be seen that 90-100% conversion was obtained and was highest between 350-550°C.

Further, a third test was run at 550°C. The necessary amount of ammonia was injected to obtain 25%, 70%, 95% and 97% conversion and the corresponding amounts of ammonia
20 slip were measured.

The results are shown in Fig. 4, where it is seen that it is only at above 90% conversion that ammonia slip can be detected. The slip is 2 ppm at 92% conversion and up to
25 10ppm at 95% conversion, which is an excellent result. At these ammonia slips known technology only offers conversion at the order of 50%.

CLAIMS:

1. A method for removal of nitrogen oxides in a combustion flue gas by injecting a reducing agent and reducing the nitrogen oxides in the presence of a catalyst being a zeolite based catalytic layer on a corrugated monolithic substrate, the substrate having a density between 50 g/l and 300 g/l and a porosity of at least 50% characterized in that the porosity of the monolithic substrate is formed by pores having a depth between 50 μm and 200 μm and a diameter between 1 μm and 30 μm .
2. The method according to claim 1, wherein the monolithic substrate is a paper of high silica content glass or a paper of E-glass fiber, the paper is coated with a layer of diatomaceous earth or with a layer of titania, and wherein the catalytic layer is a Fe- β zeolite.
3. The method according to claim 1 or 2, wherein the reducing agent is a liquid, which disintegrates into ammonia in the flue gas.
4. The method according to claim 1 or 2, wherein the reducing agent is ammonia, an aqueous solution of ammonia, or an aqueous solution of urea.
5. The method according to any one of claims 1 to 4, wherein the removal takes place between 400-620°C.
6. The method according to any one of claims 1 to 5, wherein the flue gas is formed by combustion of hydrocarbons.

7. The method according to claim 6, wherein the combustion takes place in a combustion engine or a gas turbine.
8. A catalyst for use in the method for removal of nitrogen oxides from the combustion flue gas according to the method of claim 1.
9. The catalyst according to claim 8, wherein the monolithic substrate is a paper of high silica content glass or a paper of E-glass fiber, the paper is coated with a layer of diatomaceous earth or with a layer of titania, and the catalyst is a Fe- β zeolite, the high silica content glass contains 94-95 wt % SiO₂, 4-5 wt % Al₂O₃, some Na₂O, the fibers have a density of 2000-2200 g/l and diameter of 8-10 μ m, and the E-glass contains 52-56% by weight SiO₂, 12-16% by weight Al₂O₃, 5-10% by weight B₂O₃, 0-1.5% by weight TiO₂, 0-5% by weight MgO, 16-25% by weight CaO, 0-2% by weight K₂O/Na₂O, and 0-0.8% by weight Fe₂O₃.
10. The catalyst according to claim 8 or 9, wherein the catalytic layer is applied on the monolithic substrate as a layer with a thickness of 10-150 μ m.
11. The catalyst according to any one of claims 8 to 10, wherein the catalytic layer is applied on the monolithic substrate by dipping the substrate into an aqueous slurry of milled zeolite particles, binder and antifoam agent by drying and subsequently by calcination.

12. The catalyst according to claim 11, wherein the binder is a silica sol binder, the anti foam agent is a silicone antifoam agent and the particles in the slurry have a size of not more than 50 μm .

13. The catalyst according to claim 11, wherein the catalyst is calcinated at 400-650°C.

14. The catalyst according to claim 13, wherein the catalyst is calcined at 540-560°C.

15. The catalyst according to any one of claims 8 to 14, wherein the catalyst has a void of 65%-85%.

16. The catalyst according to claim 15, wherein the catalyst has a void of 70%-80%.

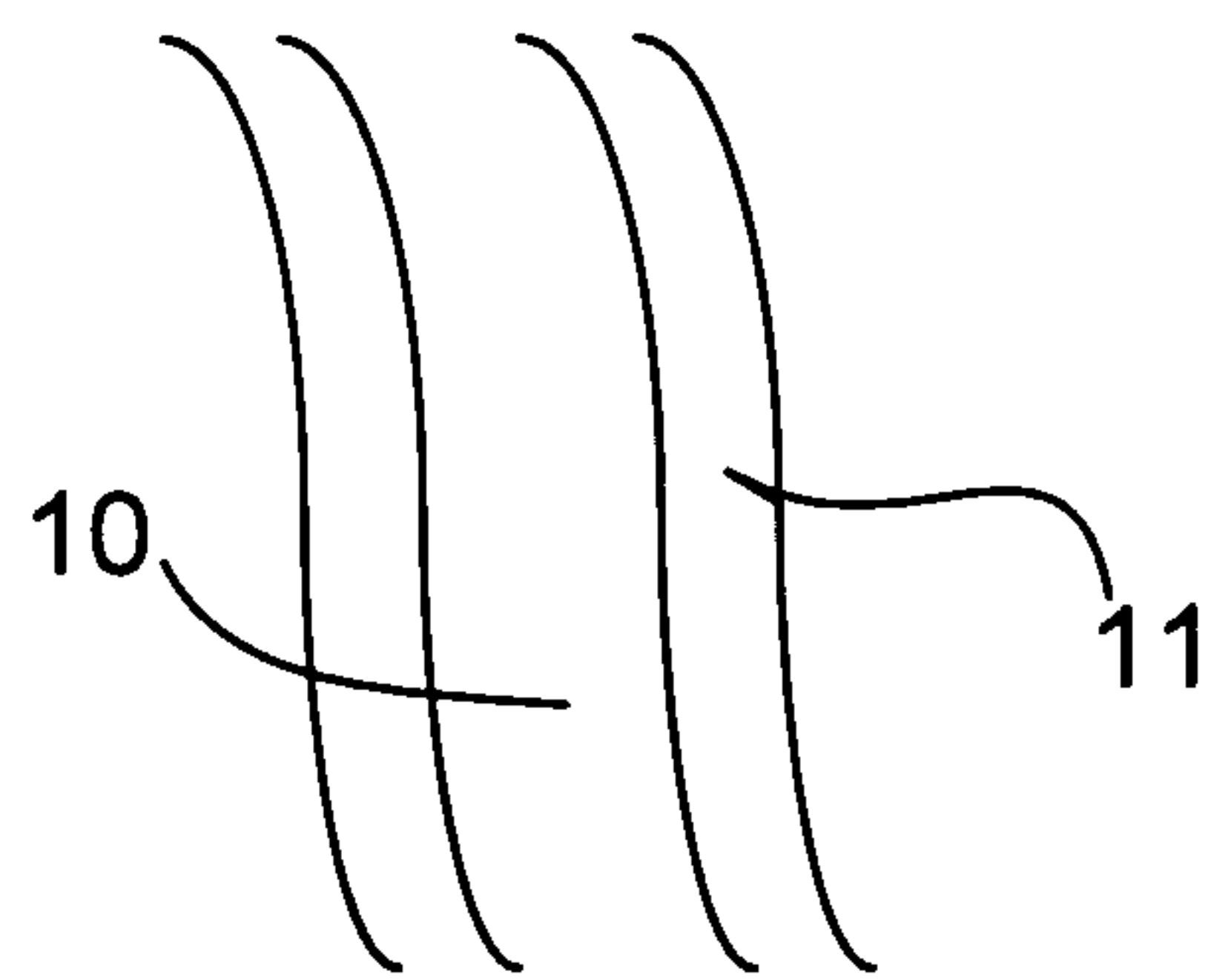
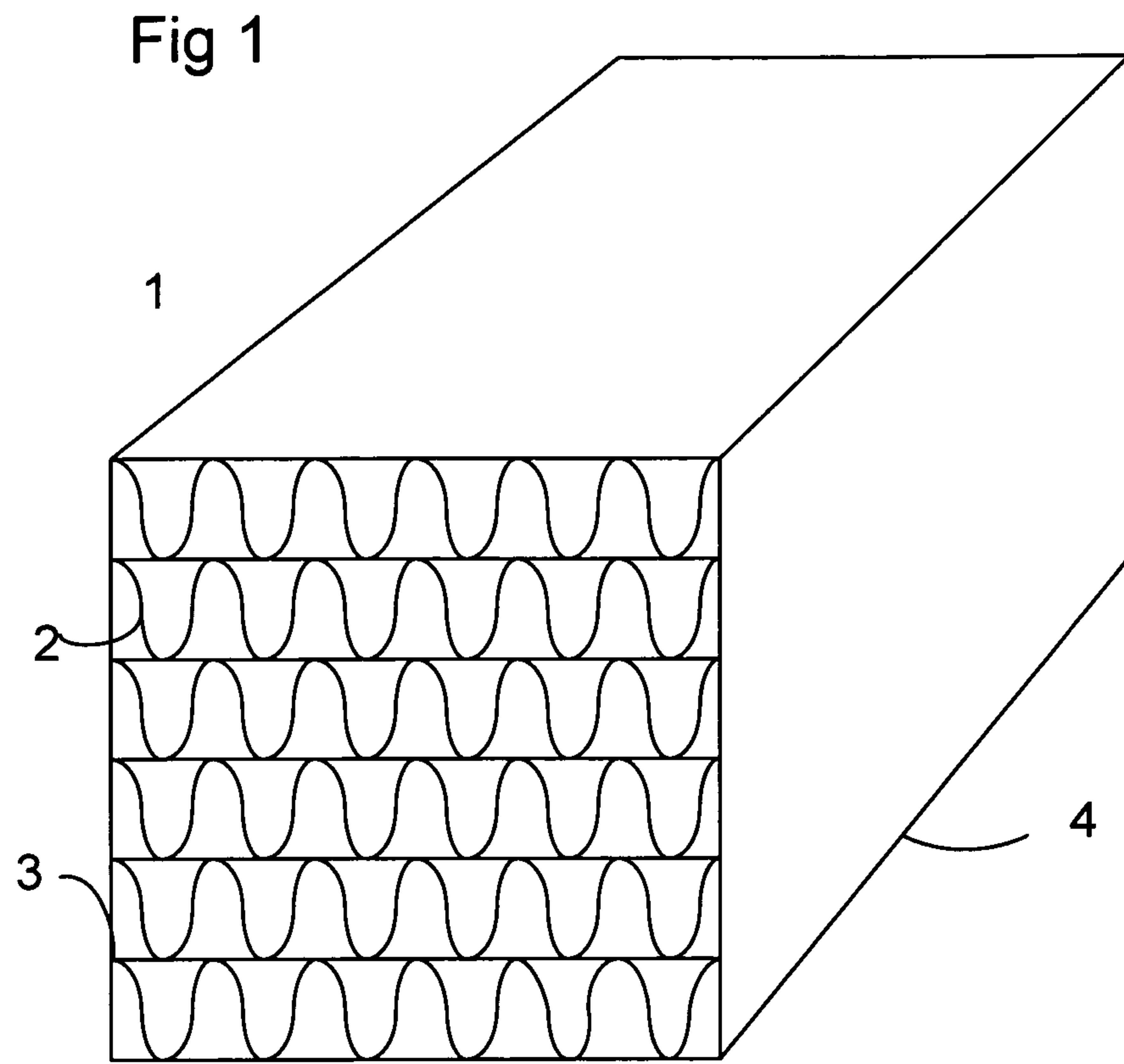


Fig 2

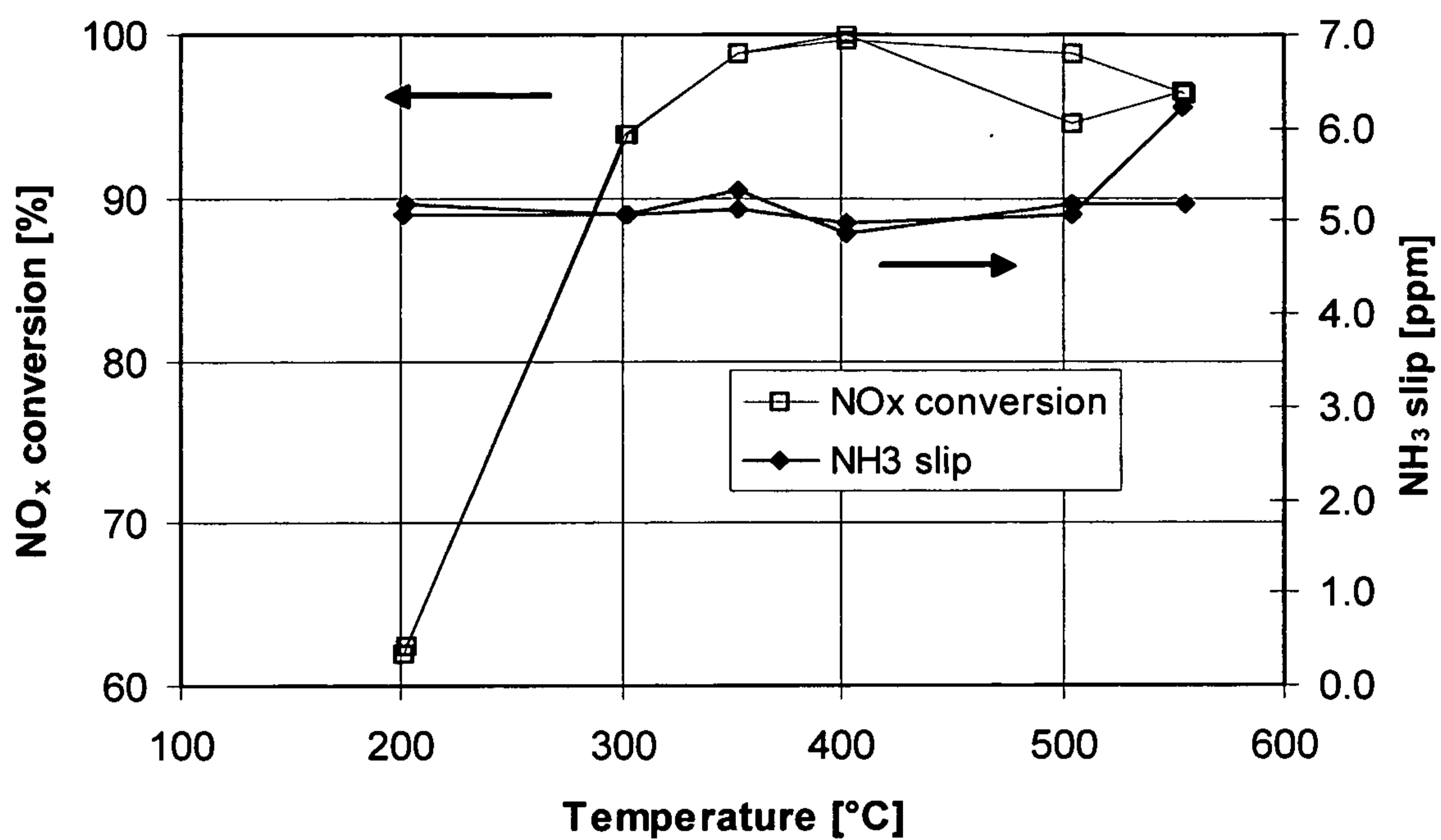


FIG 3

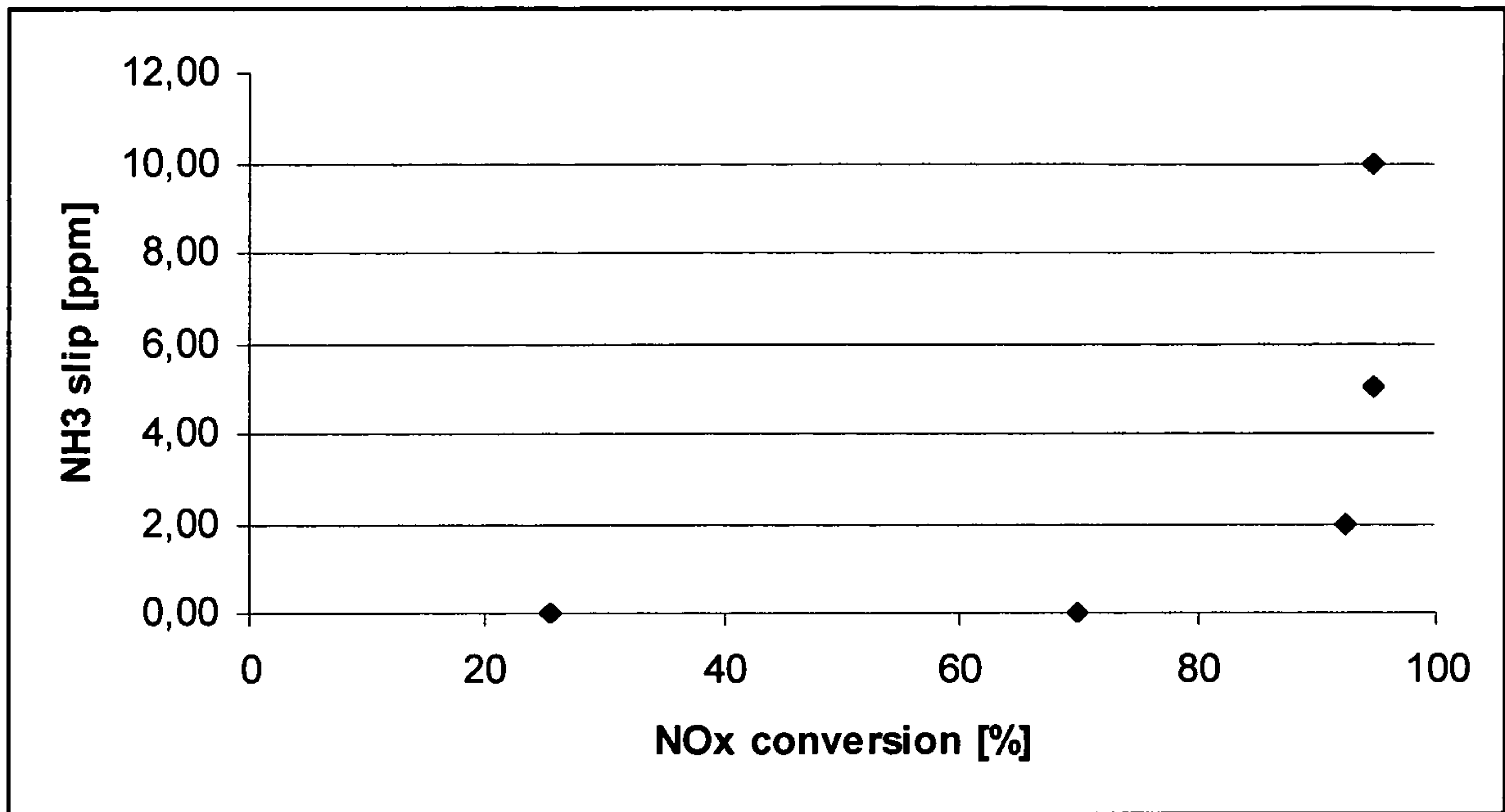


FIG 4

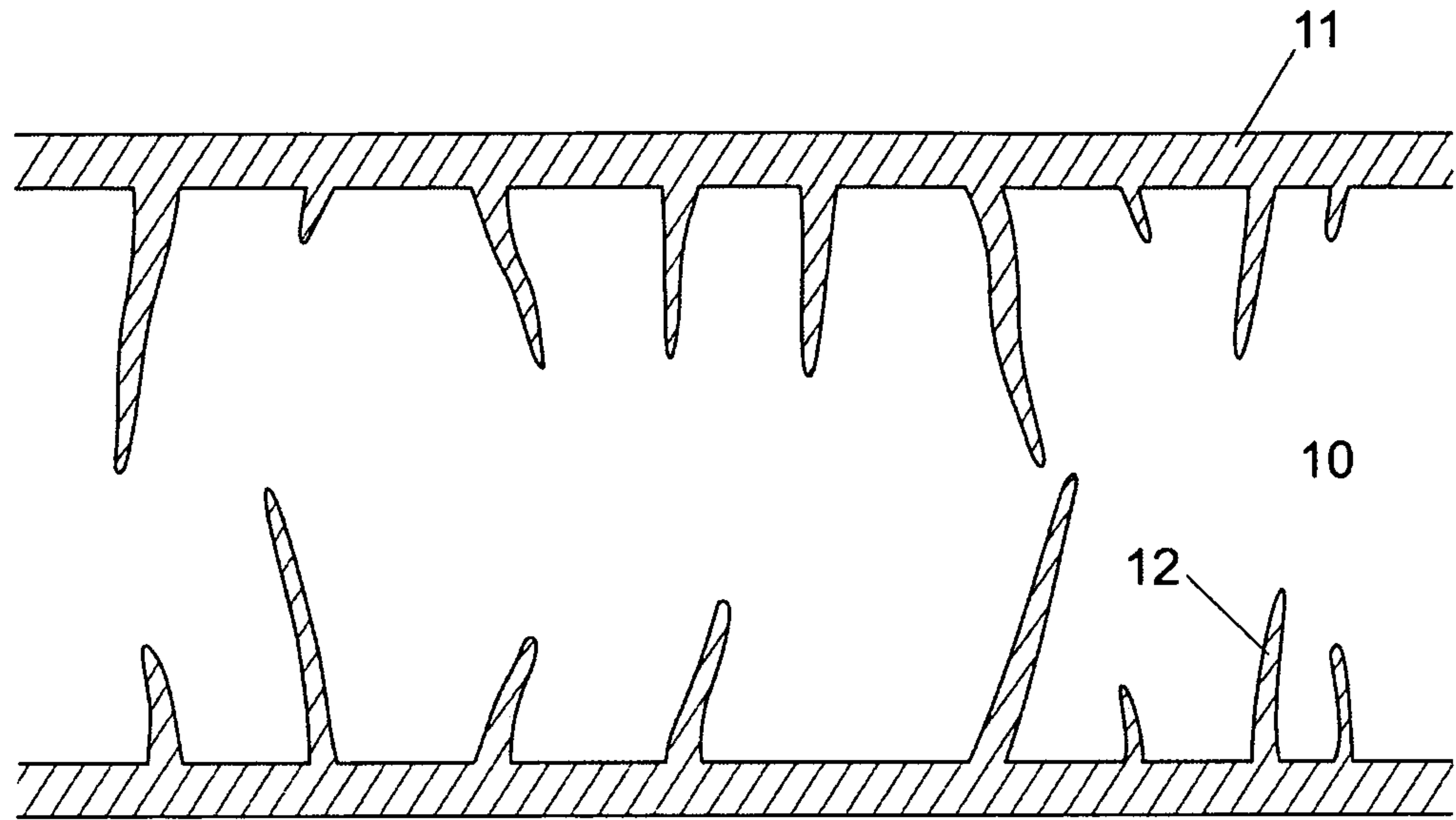


FIG 5

