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Declarations under Rule 4.17:

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(54) Title: PROCESS FOR SEPARATION OF HYDROGEN AND OXYGEN PRODUCED FROM PHOTOCATALYTIC WATER SPLITTING BY ABSORPTION

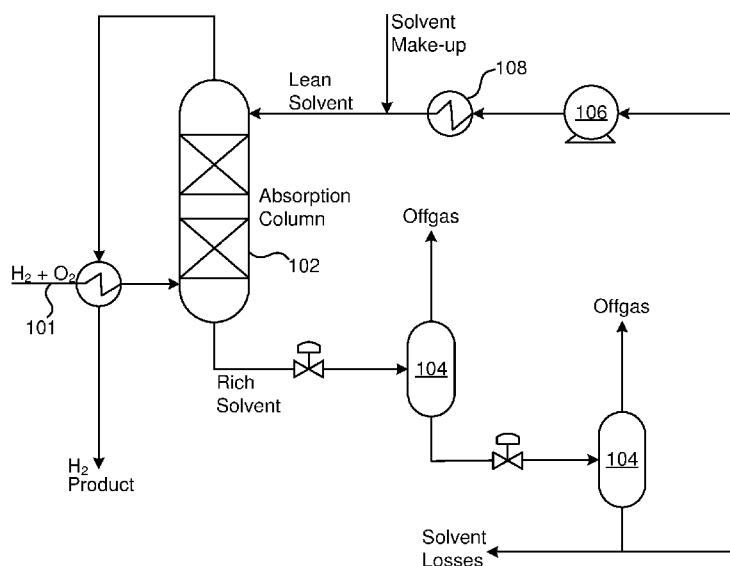


FIG. 1

(57) Abstract: Embodiments of the invention are directed to methods, processes, and systems for safely and reliably purifying hydrogen from a gas mixture containing hydrogen and oxygen.

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CROSS-REFERENCE TO RELATED APPLICATIONS

[0001] This application claims the benefit of priority of U.S. Provisional Patent Application No. 62/335,382 filed May 12, 2016, which is hereby incorporated by reference in its entirety.

BACKGROUND

[0002] Hydrogen fuel production has gained increased attention as oil and other nonrenewable fuels become increasingly depleted and expensive. Methods such as photocatalytic water-splitting are being investigated to produce hydrogen fuel, which burns cleanly, and can also be used in a hydrogen fuel cell. Water-splitting holds particular interest since it utilizes water, an inexpensive renewable resource.

[0003] Technologies are currently under development for producing energy from renewable and sustainable resources such as water. Water can be used as a feedstock for photocatalytic splitting using sun light to split water molecules into hydrogen and oxygen. The process produces a highly explosive gas mixture, which requires using as yet defined techniques and/or systems to separate and purify hydrogen from oxygen.

[0004] Various attempts to separate hydrogen from a product stream generated from a water-splitting reaction have been described. By way of example, U.S. Patent No. 4,233,127 to Monahan describes collecting dissociated hydrogen and oxygen from a hot water splitting reaction (*e.g.*, 2760 °C to 4150 °C), and separating the collected gases using a permeable membrane or a separator tank positioned as close to the reaction zone as possible to separate the gases at temperatures as high as possible to inhibit recombination of the gases.

[0005] While various methods to separate a gases mixture of hydrogen and water from a water-splitting reaction have been described, there remains a need for additional methods, processes, and systems for separating hydrogen from a highly flammable gaseous mixture containing hydrogen and oxygen.

SUMMARY

[0006] Embodiments of the current disclosure relate to methods, processes, and systems that provide solutions to the problems associated with purifying a gaseous mixture of hydrogen and oxygen produced by a photocatalytic water-splitting process. The solution provides safe and reliable methods for separating hydrogen from a highly flammable and

explosive gas containing hydrogen and oxygen using solvent adsorption at atmospheric pressure.

[0007] Certain embodiments are directed to processes for separating hydrogen and oxygen from a gas mixture produced from photocatalytic splitting of water or other methods. A process can include: (a) compressing a feed source gas that includes oxygen and hydrogen to at least 1 MPa (10 bar) at ambient temperature; (b) pressurizing a solvent to at least 1 MPa at ambient temperature, wherein the solvent is capable of selectively adsorbing oxygen when under a pressure of at least 1 MPa (10 bar); (c) separating hydrogen and oxygen present in the feed source by solvent adsorption comprising, (i) passing the compressed solvent through an adsorption column at a pressure of at least 1 MPa; and (ii) passing the compressed feed source through an adsorption column at a pressure of at least 1 MPa counter to the pressurized solvent, the pressurized solvent selectively adsorbing oxygen from the feed source producing an enriched hydrogen product gas and an oxygen enriched solvent; and (iii) separating the hydrogen product gas and the oxygen enriched solvent; and (d) collecting, storing, or utilizing the hydrogen product gas. The process can further include (e) depressurizing the oxygen enriched solvent and desorbing the adsorbed oxygen from the solvent forming an oxygen off gas and regenerating the adsorption solvent; and (f) collecting, storing, or utilizing the oxygen off gas. In a further aspect, the process can also further include obtaining the feed source from a photocatalytic water-splitting reaction. In certain aspects, the feed source is approximately 70 mol.% hydrogen, 25 mol.% oxygen, and 5 mol.% carbon dioxide. In certain aspects, the solvent can be methanol, dimethyl ether of polyethylene glycol (DEPG), N-methyl-2-pyrrolidone (NMP), or propylene carbonate. The ambient temperature can be between 15, 20, 25, 30, 35 and 40, 45, 50, or 60 °C, including all values and ranges there between. In a further aspect, the ambient temperature is between 15 and 60 °C. The adsorption process can be performed at 0, 10, 20, 30 to 40, 50, 60, or 70 °C, or any value or range there between. In certain aspects, the adsorption process can be performed at 0 to 60 °C. In a further aspect, the adsorption process can be performed at about 20 to 40 °C. The feed source gas can be compressed to about, at least, or at most 1.0, 2.0, 3.0 to 3.0, 4.0, 5.0 MPa. In certain aspects, the feed source gas can be compressed to about 2.0 MPa. In a further aspect, the feed source gas is compressed to about 3.0 MPa. The solvent can be compressed to about, at least, or at most 1.0, 2.0, 3.0 to 3.0, 4.0, 5.0 MPa. In certain aspects, the solvent is pressurized to about 2.0 MPa. In a further aspect, the solvent can be pressurized to about 3.0 MPa. The adsorption process can be performed at a pressure of

about 1.0, 2.0, 3.0, to 3.0, 4.0, 5.0 MPa. In certain aspects, the adsorption process can be performed at a pressure of about 1.0 to 5.0 MPa. In a further aspect, the adsorption process is performed at a pressure of about 3.0 MPa. The desorption process can be performed at a pressure of about 0.05, 0.1, 0.2, or 0.4 MPa. In certain aspects, the desorption process can be performed at a pressure of about 0.1 MPa. The process can further include filtering and dehydrating the feed source prior to feeding the feed source gas to the adsorption column. In certain aspects, the process can be performed under conditions and using equipment to minimize spark generation. In a further aspect, the adsorption column is a packed column type adsorption column.

10 **[0008]** In certain aspects, the enriched hydrogen product gas can include at least 90, 95, 98, or up to 99 mol.% hydrogen.

[0009] Other embodiments are directed to a purified hydrogen stream produced by a process as described herein. In certain aspects, the purified hydrogen stream can include at least 90, 95, 98, or 99 mol.% hydrogen.

15 **[0010]** Still other embodiments are directed to a purified oxygen stream produced by a process as described herein. In certain aspects, the purified oxygen stream can include at least 30, 40, 50, or 60 mol. % oxygen.

[0011] Certain embodiments are directed to a gas purification system that can include: (a) an adsorption column configured to (i) receive a feed source gas in the lower half of the column so that the feed gas travels up the column, and (ii) receive a solvent in the upper half of the column so that the solvent travels down the column, wherein the solvent selectively adsorbs oxygen and exits the column as an oxygen enriched solvent and the feed source gas is processed while traversing the column and exits the top of the column as a hydrogen product gas; (b) a solvent reservoir or source configured to provide lean solvent to the adsorption column; and (c) a feed gas source configured to provide a feed source gas to the adsorption column. The system can further include a solvent regeneration unit configured to depressurize and deoxygenate a rich solvent exiting the adsorption column forming an oxygen off gas. The system can further include a hydrogen storage device to collect and store at least a portion of the enriched hydrogen stream. In certain aspects, the system further includes an oxygen storage device to collect and store at least a portion of the oxygen off gas.

30 **[0012]** The following includes definitions of various terms and phrases used throughout this specification.

[0013] The use of the words “a” or “an” when used in conjunction with any of the terms “comprising,” “including,” “containing,” or “having” in the claims, or the specification, may mean “one,” but it is also consistent with the meaning of “one or more,” “at least one,” and “one or more than one.”

5 [0014] The terms “about” or “approximately” are defined as being close to as understood by one of ordinary skill in the art. In one non-limiting embodiment, the terms are defined to be within 10%, preferably within 5%, more preferably within 1%, and most preferably within 0.5%.

10 [0015] The use of the term “or” in the claims is used to mean “and/or” unless explicitly indicated to refer to alternatives only or the alternatives are mutually exclusive, although the disclosure supports a definition that refers to only alternatives and “and/or.”

[0016] The terms “wt.%”, “vol.%”, or “mol.%” refers to a weight, volume, or molar percentage of a component, respectively, based on the total weight, the total volume of material, or total moles, that includes the component. In a non-limiting example, 10 grams of
15 component in 100 grams of the material is 10 wt.% of component.

[0017] The term “substantially” and its variations are defined to include ranges within 10%, within 5%, within 1%, or within 0.5%.

[0018] The terms “inhibiting” or “reducing” or “preventing” or “avoiding” or any variation of these terms, when used in the claims and/or the specification includes any
20 measurable decrease or complete inhibition to achieve a desired result.

[0019] The term “effective,” as that term is used in the specification and/or claims, means adequate to accomplish a desired, expected, or intended result.

[0020] The words “comprising” (and any form of comprising, such as “comprise” and “comprises”), “having” (and any form of having, such as “have” and “has”), “including” (and
25 any form of including, such as “includes” and “include”) or “containing” (and any form of containing, such as “contains” and “contain”) are inclusive or open-ended and do not exclude additional, unrecited elements or method steps.

[0021] The processes, methods, and systems of the present invention can “comprise,” “consist essentially of,” or “consist of” particular ingredients, components, compositions, etc.
30 disclosed throughout the specification. With respect to the transitional phase “consisting essentially of,” in one non-limiting aspect, a basic and novel characteristic of the processes,

methods, and systems of the present invention are their ability to separate hydrogen from a highly flammability mixture of hydrogen and oxygen.

[0022] Other objects, features and advantages of the present invention will become apparent from the following figures, detailed description, and examples. It should be understood, however, that the figures, detailed description, and examples, while indicating specific embodiments of the invention, are given by way of illustration only and are not meant to be limiting. Additionally, it is contemplated that changes and modifications within the spirit and scope of the invention will become apparent to those skilled in the art from this detailed description. In further embodiments, features from specific embodiments may be combined with features from other embodiments. For example, features from one embodiment may be combined with features from any of the other embodiments. In further embodiments, additional features may be added to the specific embodiments described herein.

DESCRIPTION OF THE DRAWINGS

[0023] The following drawings form part of the present specification and are included to further demonstrate certain aspects of the present invention. The invention may be better understood by reference to one or more of these drawings in combination with the detailed description of the specification embodiments presented herein.

[0024] **FIG. 1.** A block diagram of one embodiment of a hydrogen purification system disclosed herein of the present invention.

DESCRIPTION

[0025] A discovery has been found that provides a solution to handling highly flammable mixtures produced from water-splitting processes. The solution is premised on using a solvent adsorption process or system to separate hydrogen from a highly flammable and explosive gaseous mixture containing hydrogen and oxygen at ambient temperatures. The solution can provide a hydrogen stream that includes at least 95 mol % hydrogen. The combination of a solvent adsorption system with a photocatalytic water-splitting system provides the advantage of being able to separate a highly flammable mixture of oxygen and hydrogen generated from a photocatalytic water-splitting system.

[0026] These and other non-limiting aspects of the present invention are discussed in further detail in the following sections with reference to the FIG. 1. The systems and methods of described in FIG. 1 can also include various equipment that is not shown and is

known to one of skill in the art of chemical processing. For example, some controllers, piping, computers, valves, pumps, heaters, thermocouples, pressure indicators may not be shown.

A. Photocatalytic Water-splitting

5 [0027] Photocatalytic water-splitting is the light-induced conversion reaction of water to hydrogen and oxygen. This reaction has attracted attention as one of the most promising hydrogen production processes. Photocatalytic water-splitting is an artificial process for the dissociation of water into its constituent parts, hydrogen (H_2) and oxygen (O_2), using either artificial or natural light without producing greenhouse gases or having many adverse effects
10 on the atmosphere. When H_2O is split into O_2 and H_2 , the stoichiometric ratio of its products is 2:1. The process of water-splitting is a highly endothermic process ($\Delta H > 0$). Production of hydrogen from water requires large amounts of input energy, making it incompatible with existing energy generation.

[0028] There are several requirements for a photocatalyst to be useful for water-splitting.
15 The minimum potential difference (voltage) needed to split water is 1.23 eV at 0 pH. Since the minimum band gap for successful water-splitting at pH=0 is 1.23 eV the electrochemical requirements can theoretically reach down into infrared light, albeit with negligible catalytic activity. These values are true only for a completely reversible reaction at standard temperature and pressure (1 bar and 25 °C). Theoretically, infrared light has enough energy
20 to split water into hydrogen and oxygen; however, this reaction is kinetically very slow because the wavelength is greater than 380 nm. The potential must be less than 3.0 eV to make efficient use of the energy present across the full spectrum of sunlight. Water-splitting can transfer charges, but not be able to avoid corrosion for long term stability. Defects within crystalline photocatalysts can act as recombination sites, ultimately lowering efficiency.

25 [0029] Materials used in photocatalytic water-splitting fulfill the band requirements and typically have dopants and/or co-catalysts added to optimize their performance. A sample semiconductor with the proper band structure is titanium dioxide (TiO_2). However, due to the relatively positive conduction band of TiO_2 , there is little driving force for H_2 production, so TiO_2 is typically used with a co-catalyst such as platinum (Pt) to increase the rate of H_2
30 production. It is routine to add co-catalysts to spur H_2 evolution in most photocatalysts due to the conduction band placement. Most semiconductors with suitable band structures to split

water absorb mostly UV light; in order to absorb visible light, it is necessary to narrow the band gap.

[0030] Photocatalysts can suffer from catalyst decay and recombination under operating conditions. In certain aspects catalyst decay becomes a problem when using a sulfide-based photocatalyst such as cadmium sulfide (CdS), as the sulfide in the catalyst is oxidized to elemental sulfur at the same potentials used to split water. Thus, sulfide-based photocatalysts are not viable without sacrificial reagents such as sodium sulfide to replenish any sulfur lost, which effectively changes the main reaction to one of hydrogen evolution as opposed to water-splitting. Recombination of the electron-hole pairs needed for photocatalysis can occur with any catalyst and is dependent on the defects and surface area of the catalyst; thus, a high degree of crystallinity is required to avoid recombination at the defects. Non-limiting Examples of photocatalyst $\text{NaTaO}_3\text{:La}$ - $\text{NaTaO}_3\text{:La}$, $\text{K}_3\text{Ta}_3\text{B}_2\text{O}_{12}$ - $\text{K}_3\text{Ta}_3\text{B}_2\text{O}_{12}$, $(\text{Ga}_{.82}\text{Zn}_{.18})(\text{N}_{.82}\text{O}_{.18})$ - $(\text{Ga}_{.82}\text{Zn}_{.18})(\text{N}_{.82}\text{O}_{.18})$, and TiO_2 -based systems.

[0031] $\text{NaTaO}_3\text{:La}$ - $\text{NaTaO}_3\text{:La}$ yields the highest water-splitting rate of photocatalysts without using sacrificial reagents. This UV-based photocatalyst was shown to be highly effective with water-splitting rates of 9.7 mmol/h and a quantum yield of 56%. The nanostep structure of the material promotes water-splitting as edges functioned as H_2 production sites and the grooves functioned as O_2 production sites. Addition of NiO particles as co-catalysts assisted in H_2 production; this step can be done by using an impregnation method with an aqueous solution of $\text{Ni}(\text{NO}_3)_2 \cdot 6\text{H}_2\text{O}$ and evaporating the solution in the presence of the photocatalyst.

[0032] $\text{K}_3\text{Ta}_3\text{B}_2\text{O}_{12}$ - $\text{K}_3\text{Ta}_3\text{B}_2\text{O}_{12}$ is activated by solely UV light and above, does not have the performance or quantum yield of $\text{NaTaO}_3\text{:La}$. However, it does have the ability to split water without the assistance of co-catalysts and gives a quantum yield of 6.5% along with a water-splitting rate of 1.21 mmol/h. This ability is due to the pillared structure of the photocatalyst, which involves TaO_6 pillars connected by BO_3 triangle units.

[0033] $(\text{Ga}_{.82}\text{Zn}_{.18})(\text{N}_{.82}\text{O}_{.18})$ - $(\text{Ga}_{.82}\text{Zn}_{.18})(\text{N}_{.82}\text{O}_{.18})$ has one of the highest quantum yield in visible light for visible light-based photocatalysts that do not utilize sacrificial reagents. The photocatalyst gives a quantum yield of 5.9% along with a water-splitting rate of 0.4 mmol/h. Tuning the catalyst is done by increasing calcination temperatures for the final step in synthesizing the catalyst. Temperatures up to 600 °C helped to reduce the number of

defects, though temperatures above 700 °C destroyed the local structure around zinc atoms and was thus undesirable.

[0034] Pt/TiO₂ - TiO₂ is a very efficient photocatalyst, as it yields both a high quantum number and a high rate of H₂ gas evolution. For example, Pt/TiO₂ (anatase phase) is a catalyst used in water-splitting. These photocatalysts combine with a thin NaOH aqueous layer to make a solution that can split water into H₂ and O₂. TiO₂ absorbs only ultraviolet light due to its large band gap (>3.0 eV), but outperforms most visible light photocatalysts because it does not photocorrode as easily. Most ceramic materials have large band gaps and thus have stronger covalent bonds than other semiconductors with lower band gaps.

[0035] Cobalt based systems - Photocatalysts based on cobalt have been reported. Members are tris(bipyridine) cobalt(II), compounds of cobalt ligated to certain cyclic polyamines, and certain cobaloximes. Chromophores have reportedly been connected to part of a larger organic ring that surrounded a cobalt atom. The process is less efficient than using a platinum catalyst, cobalt is less expensive, potentially reducing total costs. The process uses one of two supramolecular assemblies based on Co(II)-templated coordination as photosensitizers and electron donors to a cobaloxime macrocycle.

B. Hydrogen Purification Using Solvent Adsorption

[0036] The gas produced from the photocatalytic water-splitting process is at near atmospheric pressure and it can contain about 70 % mol H₂, 25 % mol O₂ and 5 % mol CO₂. This gas, is compressed to increase the pressure of the gas to the desired delivery pressure. The compressor, for example, is a piston compressor, a diaphragm compressor, a scroll compressor, or other type of compressor. In certain aspects, the gas is compressed using a piston compressor. In certain aspects, the gas is compressed to approximately 1 to 3 MPa (10 to 30 bar) and sent to a solvent adsorption separation unit for gas separation. For safety, the compressor should be a spark-free or spark-suppressed compressor.

[0037] Compressed gas can be used as a medium in numerous applications. Among various known techniques for compression of gas, piston compressors constitute a specific example of compression devices. A gas compressor is a mechanical device that increases the pressure of a gas by reducing its volume. In certain aspects, the compressor has an inlet and an outlet that are controlled by valves. At intake of gas into the cylinder, the inlet valve is opened and the outlet valve is closed. When the cylinder is filled with gas, the inlet is closed, while the outlet remains closed. The gas is then compressed to achieve an appropriate

pressure and the outlet valve is opened through which the compressed gas is led. The compression cycle is repeated. Various compressor types can be used, such as diaphragm type compressors, which can be obtained through PDC Machines (Warminster, PA) or Howden & Sundyne (Arvada, CO) for example; or an ionic liquid filled compressor, which can be obtained from Linde (Pittston, PA) for example; or a labyrinth seal piston compressor, which can be obtained from Burckhardt Compression (Houston, TX) for example.

[0038] For the process described herein, the gas exiting the photochemical reactor is compressed to approximately 1.0 to 3.0 MPa before being passed through a feed/product exchanger and entering the bottom of the adsorption column.

[0039] The absorption column can be configured as a tray column, packed column, spray tower, bubble column, or a centrifugal contactor. In certain aspects, the gas mixture flows upward through a section of packing, contacting the solvent counter current, which enables the oxygen in the gas stream to dissolve into the solvent. The hydrogen rich gas stream exits the top. The solvent exits the column at the bottom, rich in oxygen, *i.e.*, a rich solvent. The solvent can be depressurized regenerating the solvent and releasing a gaseous oxygen (O₂) stream (off gas). The oxygen dissolved in the solvent can be recovered. In order to maximize this recovery, recycling of the off gas may be needed.

[0040] After safely compressing the gas and producing the feed source, the feed source can be sent to a solvent adsorption separation unit. The processing chamber or column in the solvent adsorption separation unit can be designed to allow hydrogen gas to selectively pass through the chamber or column, exiting on the product gas side. The oxygen or other impurities are absorbed in the solvent, exiting as a rich solvent. The off gas produced by the solvent absorption separation unit contains mainly oxygen. In certain aspects, a small amount of inert gas can be added to reduce processing hazards.

[0041] In certain aspects, the hydrogen gas isolated by the solvent absorption separation unit can be further purified, if needed, by combustion. The hydrogen rich gas (product gas) can be compressed (*e.g.*, to 3.0 MPa) and transmitted to a hydrogen purification unit. The hydrogen purification unit processes the hydrogen rich gas by combustion, which removes residual oxygen from the stream forming a purified stream. The purified stream is hot and can be used to raise medium pressure steam, while cooling the gas stream down to remove water.

[0042] Hydrogen has a wide flammability range in comparison with other fuels. As a result, hydrogen can be combusted over a wide range of gas mixtures. Thus, hydrogen can combust in a mixture in which the gas content is less than the theoretical, stoichiometric or chemically ideal amount needed for combustion. Hydrogen has very low ignition energy.

5 The amount of energy needed to ignite hydrogen is about one order of magnitude less than that required for gasoline.

[0043] The potential for an explosive atmosphere during the processes disclosed herein will require the whole separation process to have zone 0 classification (minimizing spark generation). Pipework and membranes are made of a good electrical conducting polymer for
10 the prevention of sparks.

[0044] FIG. 1 illustrates a flow diagram for one embodiment of the system. The solvent absorption column 102 separates and removes selected gases, particularly oxygen, using a solvent absorption process. FIG. 1 illustrates a scheme where reactants (*e.g.*, water and sacrificial agent) and catalyst are processed in a reactor to produce a feed source stream 101
15 that includes a mixture of hydrogen and oxygen. The feed source 101 is compressed and transferred to bottom portion of absorption column 102. In absorption column 102, the feed source is exposed to a counter current solvent under pressure such that hydrogen passes without significant absorption by the pressurized solvent forming a hydrogen rich permeate gas, or product gas. The lean solvent is supplied into the absorption column 102, and absorbs
20 oxygen from the feed source containing hydrogen. The processed feed source from which selected gases have been removed, is collected from the top of absorption column 102. After gas absorption, the rich solvent is discharged from the bottom portion of absorption column 102, and is regenerated by one or more depressurization units 104. The lean solvent can be pressurized by compressor 106, pass through heat exchanger 108, and be reintroduced to
25 absorption column 102. The off gas, oxygen can be capture, stored, and utilized, or exhausted as needed.

[0045] Solvents found to be useful in the present invention are solvents that dissolve oxygen at increased pressures or under specific conditions and have a low hydrogen solubility at those same pressures or conditions. Examples of useful solvents include
30 methanol, dimethyl ether of polyethylene glycol (DEPG), N-methyl-2-pyrrolidone (NMP), or propylene carbonate.

[0046] The figure is included to demonstrate preferred embodiments of the invention. It should be appreciated by those of skill in the art that the techniques disclosed in the examples or figures represent techniques discovered by the inventors to function well in the practice of the invention, and thus can be considered to constitute preferred modes for its practice.

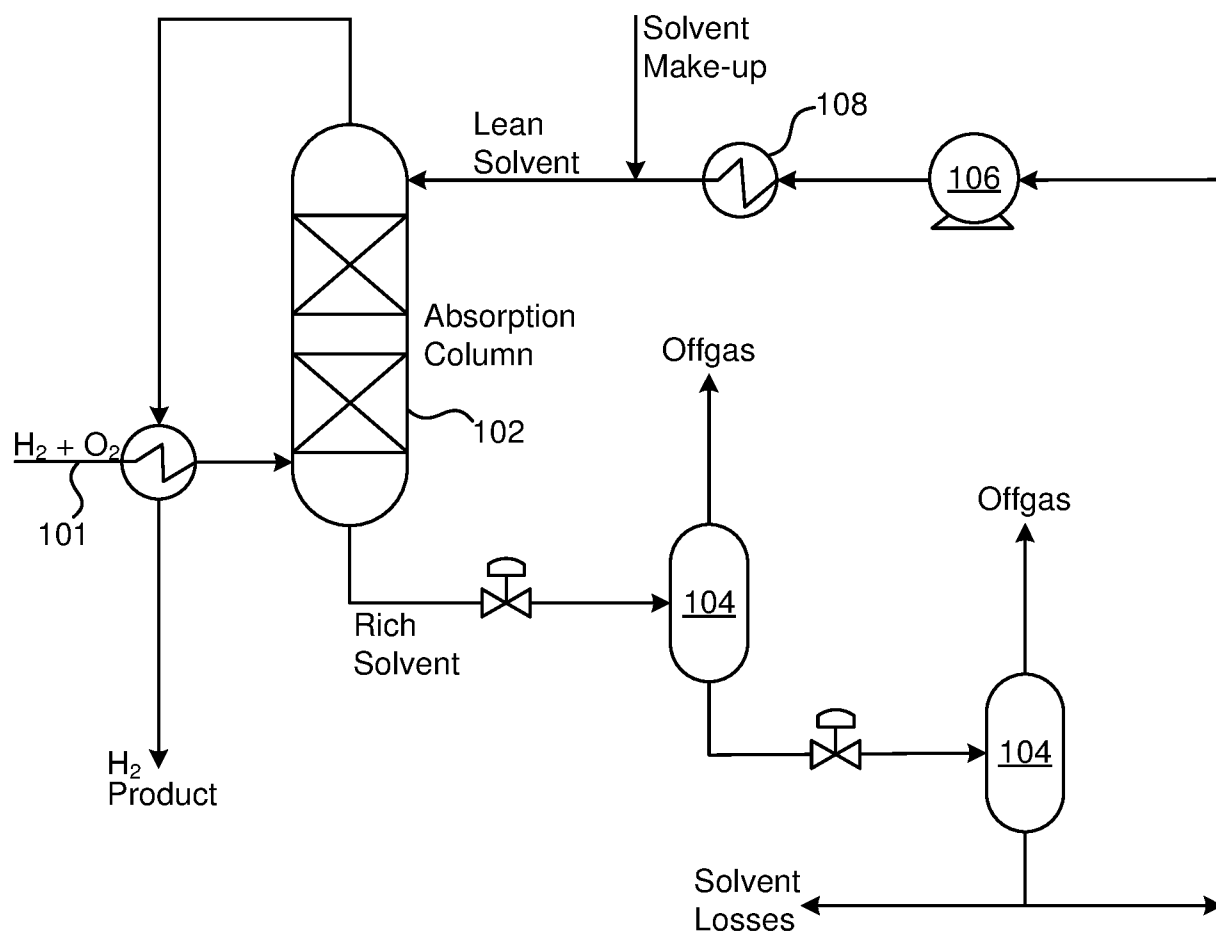
- 5 However, those of skill in the art should, in light of the present disclosure, appreciate that many changes can be made in the specific embodiments which are disclosed and still obtain a like or similar result without departing from the spirit and scope of the invention.

CLAIMS

1. A process for separating hydrogen and oxygen from a gas mixture produced from photocatalytic splitting of water comprising:
 - (a) compressing a feed source gas comprising oxygen and hydrogen to at least 1.0 MPa at ambient temperature;
 - (b) pressurizing a solvent to at least 1.0 MPa at ambient temperature, wherein the solvent is capable of selectively adsorbing oxygen when under a pressure of at least 1.0 MPa;
 - (c) separating hydrogen and oxygen present in the feed source by solvent adsorption comprising,
 - (i) passing the compressed solvent through an adsorption column at a pressure of at least 1.0 MPa; and
 - (ii) passing the compressed feed source gas through an adsorption column at a pressure of at least 1.0 MPa counter to the pressurized solvent, the pressurized solvent selectively adsorbing oxygen from the feed source gas producing an enriched hydrogen product gas and an oxygen enriched solvent; and
 - (iii) separating the hydrogen product gas and the oxygen enriched solvent; and
 - (d) collecting, storing, or utilizing the hydrogen product gas.
2. The process of claim 1, further comprising:
 - (e) depressurizing the oxygen enriched solvent and desorbing the adsorbed oxygen from the solvent, forming an oxygen off gas and regenerating the adsorption solvent; and
 - (f) collecting, storing, or utilizing the oxygen off gas.
3. The process of claim 1, further comprising obtaining the feed source gas from a photocatalytic water-splitting reaction.
4. The process of claim 1, wherein the feed source gas is approximately 70 mol % hydrogen, 25 mol % oxygen, and 5 mol % carbon dioxide.

5. The process of claim 1, wherein the solvent is methanol, dimethyl ether of polyethylene glycol (DEPG), N-methyl-2-pyrrolidone (NMP), or propylene carbonate.
6. The process of claim 1, wherein ambient temperature is between 15 and 60 °C.
7. The process of claim 1, wherein the adsorption in step (c)(ii) is performed at about 20 to 40 °C.
8. The process of claim 1, wherein the feed source gas is compressed to about 2.0 to 3.0 MPa.
9. The process of claim 1, wherein the solvent is pressurized to about 2.0 to 3.0 MPa.
10. The process of claim 1, wherein the adsorption process of step (c)(ii) is performed at a pressure of about 1.0 to 5.0 MPa.
11. The process of claim 1, wherein the adsorption process of step (c)(ii) is performed at a pressure of about 3.0 MPa.
12. The process of claim 2, wherein the desorption process is performed at a pressure of about 1 bar.
13. The process of claim 1, further comprising filtering and dehydrating the feed source gas prior to feeding the feed source gas to the adsorption column.
14. The process of claim 1, wherein the enriched hydrogen product gas comprises at least 95 mol % hydrogen.
15. The process of claim 1, wherein the process is performed under conditions and using equipment to minimize spark generation.
16. The process of claim 1, wherein the adsorption column is a packed column type adsorption column.

17. A purified hydrogen stream produced by the process of claim 1.
18. The purified hydrogen stream of claim 17, wherein the hydrogen stream comprises at least 95% hydrogen.
19. The purified hydrogen stream of claim 17, wherein the hydrogen stream comprises at least 99% hydrogen.
20. A gas purification system comprising:
 - (a) an adsorption column configured to (i) receive a feed source gas in the lower half of the column so that the feed gas travels up the column, and (ii) receive a solvent in the upper half of the column so that the solvent travels down the column, wherein the solvent selectively adsorbs oxygen and exits the column as an oxygen enriched solvent and the feed source gas is processed while traversing the column and exits the top of the column as a hydrogen product gas; and
 - (b) a solvent reservoir or source configured to provide lean solvent to the adsorption column; and
 - (c) a feed gas source configured to provide a feed source gas to the adsorption column.

**FIG. 1**

INTERNATIONAL SEARCH REPORT

International application No
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A. CLASSIFICATION OF SUBJECT MATTER
INV. B01D53/14 C01B3/52 C01B13/02
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
B01D C01B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2012/267234 A1 (REECE STEVEN Y [US] ET AL) 25 October 2012 (2012-10-25) paragraphs [0006], [0031], [0133], [0172] - [0174], [0192], [0193] -----	1-20
X	JP 2015 067478 A (STANLEY ELECTRIC CO LTD) 13 April 2015 (2015-04-13)	17-19
Y	paragraphs [0059], [0060]; figures 1,4 -----	1
A	DATABASE WPI Week 201527 Thomson Scientific, London, GB; AN 2015-24280A XP002771951, & JP 2015 067478 A (STANLEY ELECTRIC CO LTD) 13 April 2015 (2015-04-13) abstract ----- -/-	1-20



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

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"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

13 July 2017

Date of mailing of the international search report

18/08/2017

Name and mailing address of the ISA/

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Authorized officer

Burkhardt, Thorsten

INTERNATIONAL SEARCH REPORT

International application No

PCT/IB2017/052641

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 2 047 550 A (DELY JOSEF G)	20
Y	14 July 1936 (1936-07-14) figure 1 page 1, column 1, line 1 - line 4 page 2, column 1, line 17 - line 35 page 2, column 2, line 39 - line 74 -----	1

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/IB2017/052641

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US 2012267234 A1	25-10-2012	US 2012267234 A1	25-10-2012
		WO 2012145622 A1	26-10-2012

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		DK 49760 C	14-01-1935
		GB 429522 A	31-05-1935
		US 2047550 A	14-07-1936
