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(54) Benævnelse: **ELEKTROLYTPERKOLERINGSCELLER MED GASDIFFUSIONSELEKTRODE**

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DESCRIPTION

BACKGROUND OF THE INVENTION

[0001] The invention relates to the field of electrolytic cells, with particular reference to electrolyte-percolating electrolysis cells. In the following, reference will be made to the particular case of cells for depolarised chlor-alkali electrolysis making use of oxygen-fed gas-diffusion cathodes, since they largely represent the most relevant industrial application for such class of devices; however, those skilled in the art will appreciate the applicability of the same invention to other percolation-type cells, wherein the gas diffusion electrode may be applied as the anode or as the cathode, or optionally for both uses (as occurs for instance in the known case of alkaline fuel cells with percolating electrolyte).

[0002] Advanced chlor-alkali electrolysis is carried out with cells separated into a cathodic compartment and an anodic compartment by means of an ion-exchange membrane; the depolarised process with oxygen cathode provides the suppression of the hydrogen evolution cathodic reaction, typical of the chlor-alkali process of the previous generation, by means of the reduction of a flow of oxygen taking place on the surface of a gas-diffusion cathode, with consequent cell voltage lowering of about 30% in the common operative conditions. Making reference to the most typical case of an electrolysis of sodium chloride brine, as a replacement for the reaction typical of the traditional process:

$$2\ NaCl + 2\ H_2O \rightarrow 2\ NaOH + Cl_2 + H_2$$

the following overall reaction is accomplished:

$$4\ NaCl + 2\ H_2O + O_2 \rightarrow 4\ NaOH + 2\ Cl_2$$

[0003] The gas-diffusion cathode whereon the oxygen reduction is carried out is a porous structure usually consisting of a reticulated metallic material (normally silver or nickel optionally coated with a silver thin film, in order to withstand the highly corrosive conditions) acting as current collector and as mechanical support for a porous material displaying diffusive properties, in its turn usually comprising a metal catalyst to promote the oxygen reduction reaction, a polymer binder and optionally a filling material based on carbon or other preferably conductive inert.

[0004] Besides the reduction of oxygen, the production of a caustic solution in the liquid phase takes place at the cathode of this type of cell; the cathode is therefore on one hand supplied with an oxygen gas flow, and on the other hand put in contact with a solution consisting of a caustic product that has to be efficiently extracted from the electrode porosity. In cells of

industrial size, the hydraulic head established between gas and solution side must be adequately compensated to make the electrodic structure capable of withstanding the same without being flooded by the caustic product (or conversely, in case of negative pressure differential with respect to the solution, of preventing sensible oxygen losses). Several solutions were proposed in the past to overcome this problem, the most effective of which consists of allowing the caustic product to percolate across a suitable porous element interposed between the cathode surface opposite the gas side and the ion-exchange membrane, as disclosed for instance in the international patent application WO 01/57290. In this way, the pressure of caustic hydraulic head is efficiently released along the whole electrode height.

[0005] As a further advantage, the presence of a porous percolator allows transmitting a mechanical pressure from the anodic surface to the cathodic one across the membrane, the percolator itself and the gas-diffusion cathode. In such a way the electric current may be transferred from the cathodic current collector - suitably provided with an elastic structure - to the gas-diffusion cathode by contacting its back surface in a distributed fashion (and not in a localised one, for example by welds, as is the case for other cell configurations). It follows that with this arrangement, the gas-diffusion cathode can forgo the presence of an internal current collecting structure.

[0006] In the document cited herein, there is disclosed in particular the use of metallic percolators, such as nickel foams; however, to prevent the corrosion phenomena which take place in such an aggressive environment from giving rise to the dangerous release of metal ions into the caustic solution, it is preferable to employ a corrosion-resistant plastic material, for instance a perfluorinated material, as the percolator, as disclosed in the international patent application WO 03/042430. The solution proposed in the latter document however does not entirely solve the corrosion and metal ion contamination problems, since the same gas-diffusion cathode, as previously mentioned, normally consists of a metallic backbone, usually a silver or silver-plated nickel structure: in fact, the only constructive alternative to the metal mesh of the prior art consists of using carbonaceous substrates (for instance carbon cloths), also prone to the corrosive action of the caustic solution which, in combination with the electrical potential level established by the oxygen flow, spoils their mechanical properties after a certain time. Besides being subject, to a certain extent, to dissolution phenomena, the metal meshes of the prior art involve heavy problems of cost limiting the commercial success of these technologies: indicatively, the meshes employed in the more widespread chloralkali applications consist of pure silver at an overall loading of about 500 g/m^2, while in the case of silver-plated nickel the higher costs of production strongly limit the projected savings, besides providing a product of overall lesser quality in terms of corrosion resistance.

SCOPE OF THE INVENTION

[0007] It is an object of the present invention to provide an electrochemical electrolyte percolation cell overcoming the limitations of the prior art. In particular, it is an object of the

present invention to provide an electrochemical electrolyte percolation cell suitable for use with aggressive electrolytes, especially alkaline ones. It is also an object of the present invention to provide a design of electrolyte percolation cell equipped with gas-diffusion electrode characterised by a peculiar structural simplicity and by a reduced cost.

[0008] It is a further object of the invention to provide a novel method for manufacturing an electrochemical electrolyte percolation cell. The objects of the invention are achieved by means of the electrochemical electrolyte percolation cell as defined in the appended claims.

DESCRIPTION OF THE INVENTION

[0009] The invention consists of an electrochemical electrolyte percolation cell comprising a gas-diffusion electrode obtained by application of a catalytic composition on one face of a hydrophobic porous substrate suitable for supporting the percolation of an electrolyte flow; the application of the catalytic composition is effected so as to obtain only a partial penetration of the substrate, which can thereby act as percolator in the unoccupied volume fraction. The integration of the electrode within the structure of the percolator itself is thereby obtained, combining the two functions in a single piece, substantially decreasing the costs and enhancing the facility of assemblage of the relative cell. The thus-obtained electrode in particular does not require any metal mesh or other reticulated material interposed between catalytic activation and percolator. In one preferred embodiment of the invention, the catalytic composition is a mixture of metal catalysts with a suitable polymer binder, and is preferably free of carbonaceous materials, which is especially important when oxygen is present in combination with a strongly basic electrolyte. In the case of gas-diffusion cathodes for chlor-alkali electrolysis, the metal catalyst is preferably selected among silver, nickel and relevant oxides, optionally in admixture; the polymer binder is preferably a perfluorinated polymer, for instance PTFE or the like. According to one preferred embodiment, the metal catalyst and binder are mixed in an optionally aqueous solution, dispersion or suspension, until obtaining a paste which can be pressed, for instance by calendering, directly against the porous substrate suitable to act as percolator: to obtain a sufficient mechanical stabilisation, a thermal treatment Is then carried out optionally comprising a preliminary drying step at low temperature followed by a subsequent step at higher temperature.

[0010] According to one alternative embodiment, the catalytic composition is applied by decal transfer and subsequent pressure melting of a catalytic sheet on the porous substrate, also in this case followed by a final thermal treatment.

[0011] As regards the thermal treatment, the best results are obtained with a final maximum temperature comprised between 200 and 380°C, depending on the type of selected binder and its rheological characteristics as a function of temperature, as one skilled in the art can easily determine.

[0012] The choice of the hydrophobic porous structure must take into account the need of

having a sufficient volume available for liquid percolation after applying the catalytic composition on the active face: in one preferred embodiment, the porous structure is a mesh or cloth of polymeric material, for instance PTFE, with a sufficient thickness, preferably not lower than 0.7 mm. One skilled in the art can easily identify preferred thicknesses and geometries of the mesh or cloth depending on the electrolyte density, the height of the hydraulic head to be discharged and the required fluid dynamic conditions.

[0013] A cell according to the invention will therefore be provided with an integrated element acting both as the gas-diffusion electrode and as the percolator, with consequent assembly simplification and cost reduction. In some cases (for instance in the case of alkaline fuel cells), a cell may be constructed comprising two of the said electrodes, for instance a hydrogen-fed anode and an oxygen-fed cathode, typically crossed by a downward caustic potash flow.

[0014] The invention will be better understood by aid of the following examples, which are not intended to limit the extent thereof, solely defined by the appended claims.

EXAMPLE 1

[0015] 20 g of a commercial PTFE aqueous suspension (Hostaflon TF 5033, 40% by weight) and 136 ml of a 35% formaldehyde solution (Fluka) were added slowly and under stirring to 800 ml of deionised water, keeping the mixture refrigerated at a temperature between 0 and 10°C. After one hour under continuous stirring, a solution containing 80 g $AgNO_3$ (Aldrich, 63.6% Ag by weight expressed as metal) and 800 ml of a 10% by weight solution of caustic potash were added dropwise, always keeping the pH between 7.5 and 10 and the temperature below 15°C. The operation required a little less than 2 hours and the solution was kept under vigorous stirring for two additional hours. Upon completion of the reaction, the precipitate obtained was decanted eliminating the supernatant liquid. The solid, filtered under vacuum, was rinsed with 2 litres of deionised water and 600 ml of petroleum ether. The product was dried in air at 120°C overnight. A catalytic material with about 87% Ag by weight was so obtained, more than sufficient for the preparation of 200 cm^2 of gas-diffusion electrode.

COMPARATIVE EXAMPLE 1

[0016] 30 g of the catalytic material prepared in Example 1 were suspended in 90 ml of 2-propanol. The suspension was poured on a medium porosity filtering membrane, removing the alcohol excess under vacuum. The resulting cake was then pressed with a calender in several passages on a 40 mesh silver net (0.3 mm thick), up to complete coverage of the surface. After a drying step at 100°C, the electrode was treated in air at 250°C for 15 minutes in a muffle.

[0017] The cathode was assembled on a single cell lab electrolyser of 0.1 m^2 active area as

disclosed in WO 03/042430, coupled to a 1 mm thick PTFE percolator. A Nafion® ion-exchange membrane commercialised by DuPont/USA was employed as the separator between the cell compartments.

[0018] The anodic compartment was fed with sodium chloride brine, while the percolator, inserted in the cathodic compartment, was fed with a 25 l/h caustic soda downward flow. The gas-diffusion cathode was fed with an excess of oxygen.

At a temperature of 85°C and at a current density of 4 kA/m^2, a cell voltage of 2.10 V was measured after three days of stabilisation from the start-up, which remained stable for more than 30 days.

EXAMPLE 2

[0019] 30 g of the catalytic material prepared in Example 1 were suspended in 90 ml of 2-propanol. The suspension was poured on a medium porosity filtering membrane, removing the alcohol excess under vacuum. The resulting cake was then pressed with a calender in several passages on a PTFE percolator (1.5 mm nominal thickness), up to complete coverage of the surface but penetrating its volume only partially, leaving an unoccupied portion at least 1 mm thick. After a drying step at 100°C, the electrode was treated in air at 250°C for 15 minutes in a muffle.

[0020] The cathode with integrated percolator so-obtained was assembled on a single cell lab electrolyser of 0.1 m^2 active area as disclosed in WO 03/042430, in direct contact with a Nafion® ion-exchange membrane commercialised by DuPont/USA which acted as the separator between the cell compartments.

[0021] The anodic compartment was fed with sodium chloride brine, while the non activated face of the cathode employed as percolator was fed with a 25 l/h caustic soda downward flow. The gas-diffusion cathode was fed with excess oxygen.

[0022] At a temperature of 85°C and at a current density of 4 kA/m^2, a cell voltage of 2.07 V was recorded after three days of stabilisation from the start-up, which remained stable for more than 30 days.

[0023] It was thus demonstrated that the electrode with percolator, easier to assemble, less expensive and less prone to deterioration phenomena than the gas-diffusion electrodes of the prior art, has an equivalent or even superior performance in terms of current efficiency in a largely representative industrial application.

[0024] The previous description is not intended to limit the invention, which may be used according to different embodiments without departing from the scopes thereof, and whose

extent is univocally defined by the appended claims.

[0025] Throughout the description and claims of the present application, the term "comprise" and variations thereof such as "comprising" and "comprises" are not intended to exclude the presence of other elements or additives.

REFERENCES CITED IN THE DESCRIPTION

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Patent documents cited in the description

- WO0157290A **[0004]**
- WO03042430A **[0006]** **[0017]** **[0020]**

Patentkrav

1. Elektrokemisk elektrolytperkoleringscelle udstyret med mindst én gasdiffusionselektrode omfattende et hydrofobt porøst substrat fremstillet af et enkelt stykke og en katalytisk sammensætning påført på en flade deraf, idet en volumenbrøk af det porøse substrat er gennemtrængt af den katalytiske sammensætning, hvor der etableres en nedadgående elektrolytstrøm i den tilsvarende frie volumenbrøk af det porøse substrat.

2. Celle ifølge krav 1, hvor den katalytiske sammensætning omfatter mindst ét metalpulver og mindst ét polymerbindemiddel.

3. Celle ifølge krav 2, hvor det mindst ene metalpulver omfatter sølv, nikkel eller oxider deraf.

4. Celle ifølge krav 2 eller 3, hvor det mindst ene polymerbindemiddel omfatter en perfluoreret polymer, eventuelt PTFE.

5. Celle ifølge et hvilket som helst af de foregående krav, hvor det porøse substrat har en tykkelse, der ikke er mindre end 0,7 mm.

6. Celle ifølge et hvilket som helst af de foregående krav, hvor det hydrofobe porøse substrat er et net eller stof af polymermateriale.

7. Celle ifølge krav 6, hvor polymermaterialet er en perfluoreret polymer, eventuelt PTFE.

8. Celle ifølge et hvilket som helst af de foregående krav, hvor den katalytiske sammensætning er påført direkte på en flade af det hydrofobe substrat uden derimellem anbragt netagtigt metallisk materiale.

9. Celle ifølge et hvilket som helst af de foregående krav, hvor elektrolytten er en kaustisk opløsning.

10. Proces til fremstilling af en elektrokemisk elektrolytperkoleringscelle ifølge et hvilket som helst af kravene 1 til 9, omfattende trinnet at anbringe mindst

én gasdiffusionselektrode i cellen, hvilken gasdiffusionselektrode fremstilles ved hjælp af en fremgangsmåde, der omfatter trinnene:
- fremstilling af en pasta indeholdende bestanddelene af den katalytiske sammensætning med udgangspunkt i en eventuelt vandig opløsning, dispersion eller suspension
- trykning af pastaen på en flade af det hydrofobe porøse substrat til opnåelse af en delvis indtrængning af pastaen i det hydrofobe porøse substrat,
- udførelse af en varmebehandling op til en maksimal temperatur på 200 til 380 °C.

11. Proces ifølge krav 10, hvor trykningstrinnet udføres ved kalendrering.

12. Proces til fremstilling af en elektrokemisk elektrolytperkoleringscelle ifølge et hvilket som helst af kravene 1 til 9, omfattende trinnet at anbringe mindst én gasdiffusionselektrode i cellen, hvilken gasdiffusionselektrode fremstilles ved hjælp af en fremgangsmåde, der omfatter trinnene:
- påføring af den katalytiske sammensætning på en decal-bærer, indtil der opnås et katalytisk lag
- tryksmeltning af det katalytiske lag på en flade af det hydrofobe porøse substrat
- udførelse af en varmebehandling op til en maksimal temperatur på 200 til 380 °C.

13. Anvendelse af cellen ifølge et hvilket som helst af kravene 1 til 9 i en chlor-alkali-proces, hvor gasdiffusionselektroden er en oxygenforsynet gasdiffusionskatode.

14. Anvendelse af cellen ifølge et hvilket som helst af kravene 1 til 9 i en alkalisk brændselscelle af elektrolytperkoleringstypen, hvor gasdiffusionselektroden er en oxygenforsynet gasdiffusionskatode eller en hydrogenforsynet gasdiffusionsanode.