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(54) Title: PROCESS AND APPARATUS FOR TREATING A GAS STREAM

(57) **Abrégé/Abstract:**

A process of treating hydrogen gas liberated from the acid or alkaline dissolution of a metal is provided. The process comprises a step of passing the liberated hydrogen gas through a reactor containing an oxidising agent for oxidation of the hydrogen gas into water, followed by a step of regenerating the oxidising agent. Also provided is an apparatus for carrying out the process, the apparatus comprising a reactor containing the oxidising agent, wherein the reactor is at least partially immersed in an alumina bath.

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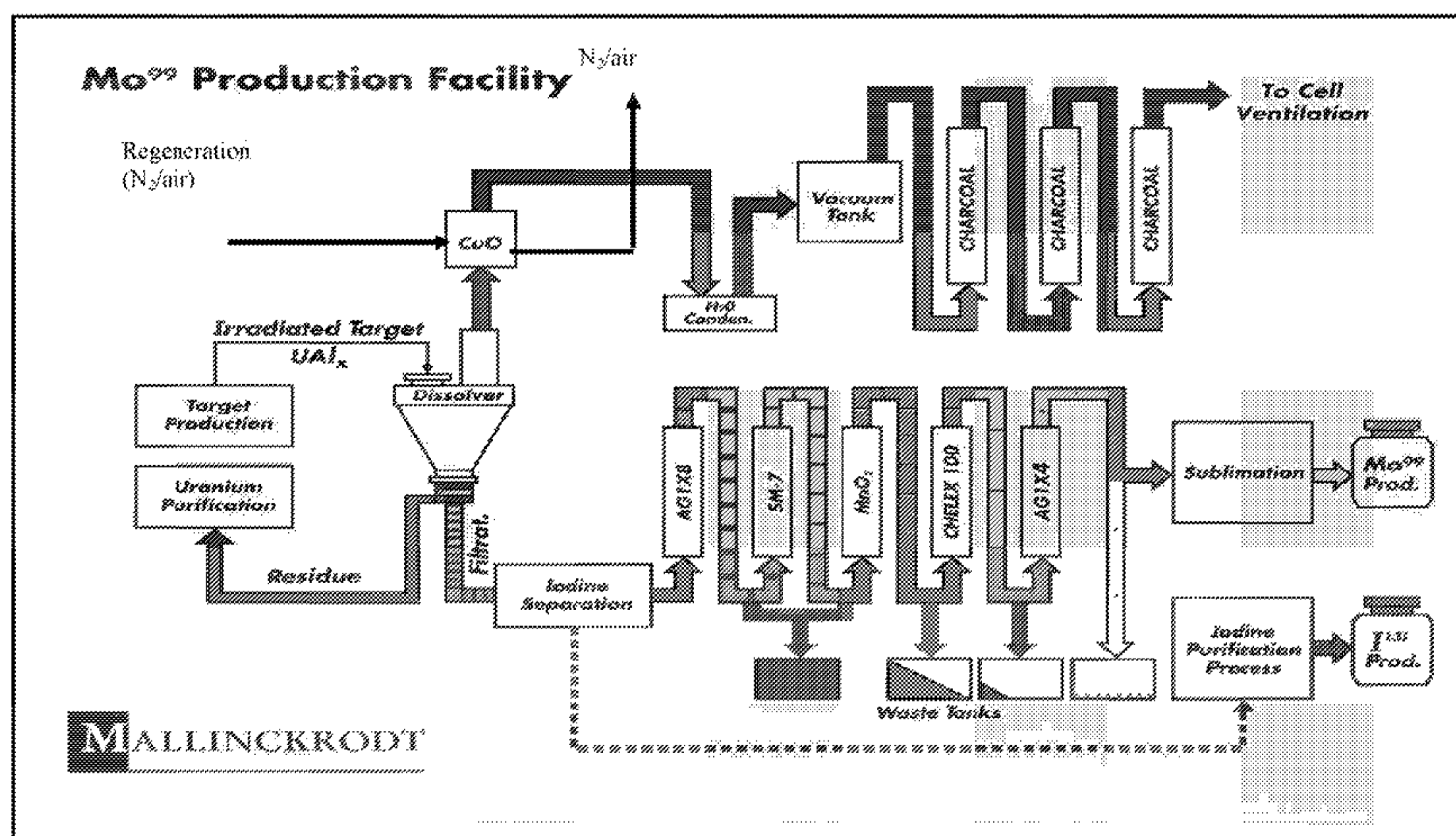
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Figure 1



(57) Abstract: A process of treating hydrogen gas liberated from the acid or alkaline dissolution of a metal is provided. The process comprises a step of passing the liberated hydrogen gas through a reactor containing an oxidising agent for oxidation of the hydrogen gas into water, followed by a step of regenerating the oxidising agent. Also provided is an apparatus for carrying out the process, the apparatus comprising a reactor containing the oxidising agent, wherein the reactor is at least partially immersed in an alumina bath.

Process and apparatus for treating a gas stream

5 This invention relates to a process. In particular, it relates to a process for treating hydrogen gas liberated from the acid or alkaline dissolution of a metal. It also relates to a heating apparatus.

10 Acid or alkaline dissolution of a metal liberates hydrogen gas. At standard temperature and pressure, hydrogen gas is a colourless, odourless, tasteless and highly combustible diatomic gas. It reacts with any oxidizing agent. Hydrogen gas reacts vigorously with oxygen to produce water in a highly exothermic reaction. It also reacts spontaneously and violently at room temperature with chlorine and fluorine to form the corresponding hydrogen halides, which are potentially dangerous acids. The
15 highly flammable and explosive properties of hydrogen gas make it a hazardous by-product in many processes.

20 Technetium-99m is the most widely used radiometal for medical diagnostic and therapeutic applications. Tc-99m is prepared by decay of Mo-99 in so-called Tc-99m generators. Such a generator typically comprises an aqueous solution of Mo-99 loaded onto an adsorbent (usually alumina). Following decay of the Mo-99 to Tc-99m, which has a lower affinity for the alumina, the Tc-99m may be eluted, typically using a saline solution. For the preparation of Tc-99m generators, a high purity source of Mo-99 is therefore essential.

25 In order to obtain Mo-99 of high specific activity, it is commonly prepared by the neutron-induced fission of a U-235 target. U-235 is typically present in a target form of U-metal foil, or constructs of U and Al (e.g., a uranium-aluminium alloy). The fission reaction leads to a proportion of the U-235 being converted to Mo-99, but also
30 leads to a number of impurities in the reactor output. Most known processes for Mo-99 production employ acid or alkaline dissolution of the irradiated target, followed by purification of the Mo-99 product. Apart from the solid and liquid impurities, which include Cs, Sr, Ru, Zr, Te, Ba, Al and alkaline and alkaline earth metals, the reaction

also produces hydrogen gas. Due to the highly inflammable and explosive properties of hydrogen gas, one of the most important off-gas treatments in the Mo-99 production process is the oxidation of hydrogen gas to form water.



In most known Mo-99 production processes, the oxidation of hydrogen gas is carried out in the presence of copper (II) oxide (CuO) in the following irreversible reaction:



This process, first developed by Sameh and Ache in 1987 (Sameh and Ache, 1987 *Radiochim. Acta* 41,65), is performed in a so-called "CuO oven", which is a fixed-bed chemical reactor. After the dissolution of the irradiated targets, the evolved hydrogen
15 is passed over hot CuO in the CuO oven to oxidise the hydrogen to water. The water vapour is then condensed. This reaction is a typical gas/solid reaction, during which the reaction front moves through the reactor until all CuO is consumed.

A typical CuO reactor bed weighs significantly more than 10kg and runs at a
20 temperature range of 360-400 °C (targeting a reaction temperature of 385 °C). The heating of the CuO bed is conventionally done by means of a heating plate, located beneath the CuO oven. It is not optimal, taking 24 hours to reach steady state conditions.

25 The CuO reactor bed is projected to be completely spent after the dissolution of a certain number of targets (or number of production runs). In a larger Mo-99 production facility, e.g., which enables the processing of more than 6 targets per run, the life time of this CuO reactor is reduced to a smaller number of runs, for example 8 runs.

30

Therefore, there is a need for the development of a reactor with a prolonged life time for the treatment of hydrogen gas.

US2005/0220689 A1 discloses a method of purifying helium gas by extracting hydrogen and other impurities from a helium gas stream. The method comprises 1) passing the gas stream over a first catalytic adsorber module containing a Cu-CuO mixture, in which hydrogen and carbon monoxide are oxidised into water and carbon dioxide, respectively, and CuO is reduced to Cu, 2) passing the gas stream resulting from step 1), along with oxygen gas, into an oxidation catalyst to convert methane and/or tritium into carbon dioxide and/or water, respectively, and 3) passing the gas stream resulting from step 2), which contains excess oxygen, into a second catalytic adsorber module containing a Cu-CuO mixture, in which the oxygen gas is used to oxidise Cu into CuO. Once the CuO in the first catalytic adsorber is consumed, the order in which the first and the second catalytic adsorbers are connected in the flow path of the gas stream is switched round such that the CuO generated in the second adsorber is used for the oxidation of hydrogen and carbon monoxide, and the Cu in the first adsorber is used to remove the excess oxygen from the purified helium gas stream.

However, this process relates to extraction of hydrogen from a gas stream comprising a number of other components and requires the use of two separate reactors containing Cu-CuO mixtures, which adds to the cost of the process. In addition, similar to hydrogen (i.e., ^1H) gas, tritium is a highly explosive gas. The addition of oxygen to a gas stream containing tritium can potentially be hazardous. Therefore, there is a need for the development of a simple method for the treatment of hydrogen using an oxidising agent, during which the oxidising agent is regenerated so as to prolong the use thereof.

In accordance with a first aspect of the present invention, there is provided a process of treating hydrogen gas liberated from the acid or alkaline dissolution of a metal, the process comprising a step of passing the liberated hydrogen gas through a reactor containing an oxidising agent for oxidation of the hydrogen gas into water, followed by a step of regenerating the oxidising agent.

In a preferred embodiment, a step of regenerating the oxidising agent is carried out after each oxidation step. By carrying out a step of regenerating the oxidising agent frequently, such as after each oxidation step, the amount of the oxidising agent initially contained in the reactor can be reduced. Accordingly, the reactor can be scaled down, for example, to around 11 or 12 kg for oxidising the same amount of hydrogen gas. The reduction in the size of the reactor not only allows an easier handling charge/discharge operation but also reduces the time for the reactor to heat up or reach steady state conditions from presently 24 hours to about 3 hours, thereby reducing the cost of the process.

10

A further advantage of the process according to the present invention is that the oxidation reaction of hydrogen gas can potentially be conducted at lower temperatures, such as at around 200 °C, with regeneration also at around 200 °C. This is particularly the case when a finely dispersed oxidising agent, such as the BASF catalyst materials mentioned herein, is used. Such finely dispersed systems are more active than those used in known processes. The oxidation reaction used for the regeneration of the oxidising agent is, in certain embodiments, highly exothermic. Therefore, the heat given off from the regeneration reaction can be used to heat or maintain the temperature of the reactor. This further reduces the cost of the process.

20

In some embodiments, the oxidising agent is a metal oxide, such as copper oxide, such as copper (II) oxide, which is converted to copper metal during the process.

The copper oxide, such as copper (II) oxide, is present either in a bulk form or finely dispersed on the surface of an inert support, such as in the Puristar® R3-11G and R3-17 catalysts from BASF (BASF SE, Ludwigshafen, Germany). In addition, the oxidising agent, such as copper oxide, may be diluted (either in bulk form or in a finely dispersed form) with an inert, thermally-conductive diluent, such as stainless steel pellets. The diluent helps to prevent uncontrolled heating of the bed of oxidising agent as a result of the heat given out by the exothermic reaction.

30

A further advantage of using the finely dispersed oxidising agents, such as the BASF materials mentioned above, is that higher yields are achieved during the regeneration process than with bulk metal oxide (e.g., CuO) material.

- 5 In certain embodiments, the step of regenerating the oxidising agent comprises passing a gas containing oxygen through the reactor containing the oxidising agent to be regenerated. For example, air or air in combination with nitrogen gas can be used.

10 Since the gas containing oxygen used for the regeneration step is not mixed with the hydrogen gas, the present invention ensures that potential hazards caused by the highly explosive nature of the hydrogen gas are kept to a minimum.

15 In some embodiments, the metal, the dissolution of which liberates the hydrogen gas, comprises uranium, optionally in combination with one or more other metals, for example a uranium-aluminium alloy.

20 In some embodiments, the reactor containing the oxidising agent is at least partially immersed in an alumina bath. Optionally, the reactor is completely immersed in an alumina bath.

25 The term "alumina bath" refers to a vessel containing a quantity of alumina (Al_2O_3), which may be used as a means for regulating the temperature of a reactor immersed therein. The bath may take the form of a substantially cylindrical or cuboidal container. The outer walls of the bath are preferably formed of metal, e.g., stainless steel or aluminium. The alumina may form a lining within the container and define a cavity into which a reactor may be placed.

30 In a particular embodiment, the alumina bath is supplied with one or more optionally external heating elements. The relatively high thermal conductivity of alumina allows heat from the heating elements to be efficiently passed to a reactor immersed in the bath. Equally, during the highly exothermic process of the H_2 conversion and reactor regeneration steps, the alumina helps to conduct heat away from the reactor, thereby preventing it from overheating.

Whether or not an alumina bath is employed as described above, the reactor may also (or alternatively) be heated by means of one or more heating elements positioned in contact with the reactor. The heating elements (those in contact with the reactor, or those associated with the alumina bath) may conveniently be electrical heating elements.

In accordance with a second aspect of the present invention, there is provided an apparatus for carrying out a process according to the first aspect, the apparatus comprising a reactor containing an oxidising agent for the oxidation of hydrogen gas into water, wherein the reactor is at least partially immersed in an alumina bath.

In a preferred embodiment, the alumina bath is supplied with one or more heating elements. The heating elements are preferably external to the alumina bath.

In some embodiments, the oxidising agent is copper oxide, such as copper (II) oxide, either in a bulk form or finely dispersed on the surface of an inert support, such as in the Puristar® R3-11G and R3-17 catalysts from BASF. The oxidising agent may be diluted (either in bulk form or in a finely dispersed form) with an inert, thermally-conductive diluent, such as stainless steel pellets.

In accordance with a third aspect of the present invention, there is provided a heating apparatus comprising an alumina bath supplied with one or more optionally external heating elements, wherein the alumina bath defines a cavity into which a vessel to be heated may be placed in use.

In accordance with a fourth aspect of the present invention, there is provided a process of treating hydrogen gas liberated from the acid or alkaline dissolution of a metal, the process comprising a step of passing the liberated hydrogen gas through a reactor containing an oxidising agent for oxidation of the hydrogen gas into water, the oxidising agent comprising a metal oxide finely dispersed on an inert carrier and/or diluted with an inert, thermally-conductive diluent.

In a preferred embodiment, the metal oxide comprises copper oxide, such as copper (II) oxide. More preferably, the copper oxide finely dispersed on an inert carrier comprises the Puristar® R3-11G and/or R3-17 catalysts from BASF. The inert diluent may comprise stainless steel pellets.

5

As mentioned above, the use of a finely dispersed oxidising agent, such as the specified BASF materials, gives the advantage that a lower temperature (around 200 °C) can be used for the oxidation reaction. While R3-11 is known to be usable at temperatures of 200 °C or more, R3-17 is indicated by the manufacturer for use (in
10 different applications) at temperatures not exceeding 100 °C. It has been found that R3-17 is capable of use in the processes of the present invention at around 200 °C with no deleterious effects to the material.

In some embodiments, the process further comprises a step of regenerating the
15 oxidising agent in accordance with the first aspect of the present invention.

A further advantage of using the finely dispersed oxidising agents is that higher yields are achieved during the regeneration process than with bulk metal oxide (e.g., CuO) material.

20

The invention will now be described in more detail by way of example only, and with reference to the following figures:

Figure 1 shows a schematic diagram of an exemplary process of the invention,
25 employed during Mo-99 production;

Figure 2 shows a schematic diagram of the heat transfer between an alumina bath heating apparatus and a reactor containing an oxidising agent for the oxidation of hydrogen gas into water; and

30

Figure 3 shows a schematic, cross-sectional diagram of an apparatus for carrying out a process according to the invention, in which the reactor vessel containing the

oxidising agent (in this case, CuO) is heated directly by means of electrically-heated clamps/bands.

As shown in Figure 1, following the dissolution of an irradiated uranium-aluminium target, the hydrogen gas liberated in the dissolver is passed into a CuO reactor, in which the hydrogen gas is oxidised into water while the CuO is converted into Cu. After each oxidation step (and before the next round of oxidation begins), a stream of air-containing nitrogen gas (N₂/air) is fed into the CuO reactor to oxidise Cu in order to regenerate CuO.

10

The CuO reactor can be heated using a heating apparatus of the present invention as shown in Figure 2. Such a heating apparatus can improve heat transfer during the operation of the reactor. The CuO reactor can be immersed in an alumina bath fitted with one or more external heating elements (see Figure 2). The heating elements may be present as one or more collars or jackets around the bath, or as a heating coil. The heating elements are preferably electrically heated. The alumina bath works as a heat exchanger. Firstly, the bath heats up the reactor to the desired reaction temperature (see "Start-up" in Figure 2). Since the H₂ conversion and Cu oxidation reactions are highly exothermic, however, the bath also works as a cooler during these processes (charge exhaustion and regeneration), preventing the reactor from overheating (see "Process" in Figure 2). When the H₂ conversion reaction is still taking place, but not sufficiently to heat up the reactor to its optimal working temperature, the bath resumes its heating function to keep the temperature of the reactor in the desired range (see "Start-up" in Figure 2).

25

As an alternative to the use of an alumina bath as shown in Figure 2, it is possible to heat the reactor directly using one or more heated clamps or bands positioned in contact with the reactor. Figure 3 shows such an arrangement, with three heating bands displayed for illustrative purposes. It will be appreciated that the bands may be in the form of a single helical band which runs along at least part of the length of the reactor. In the left part of Figure 3 (H₂ oxidation), H₂ gas from the dissolution of a metal is introduced via a first conduit which passes the gas to the bottom of the reactor (as shown). The gas passes through the bed of CuO, and reacts therewith leading to

30

the production of gaseous water. The gaseous water exits through a venting conduit positioned towards the top of the reactor (as shown). In the right part of the Figure (Cu oxidation), a mixture of air and nitrogen is introduced through the first conduit. The oxygen in the air reacts with the partially- or fully-spent CuO bed, so as to reoxidise the Cu present therein. The waste nitrogen gas exits the reactor through the venting conduit.

A number of cycles of H₂ conversion and oxidant regeneration were performed using a process according to the invention. The cycles were performed using solid aluminium 'targets' as the metal for dissolution. Twenty cycles were performed, with the dissolution of a total amount of Al equivalent to more than 200 U-Al targets. The experimental set-up mimicked the current process line in a Mo-99 production facility. In each cycle, the number of Al 'targets' dissolved was equivalent to the maximum amount of targets allowed in the production facility employed.

15

The initial temperature of the CuO reactor was 200°C. The maximum temperature in the CuO reactor during the conversion and regeneration reactions was within limits which are considered acceptable in current processes for H₂ removal. The reactor was heated directly using heating elements in the form of bands surrounding the reactor. The amount of CuO material was around 11 kg. In addition, the lower 1.5 kg part of the CuO bed was diluted 50% by weight with stainless steel pellets

20

The average H₂ conversion during the 20 cycles was > 95%. During the regeneration phase of the cycles, the average CuO bed regeneration was > 90%.

25

The embodiments of the present invention for which an exclusive property or privilege is claimed are defined as follows:

1. A process of treating hydrogen gas liberated from acid or alkaline dissolution of a metal, the process comprising a step of passing the liberated hydrogen gas through a reactor containing an oxidising agent for oxidation of the hydrogen gas into water, followed by a step of regenerating the oxidising agent, wherein the oxidising agent is diluted with an inert, thermally-conductive diluent.

2. The process according to claim 1, wherein the step of regenerating the oxidising agent is carried out after each oxidation step.

3. The process according to claim 1 or claim 2, wherein the oxidising agent comprises a metal oxide in bulk form or finely dispersed on a surface of an inert support.

4. The process according to any one of claims 1 to 3, wherein the inert, thermally-conductive diluent comprises stainless steel pellets.

5. The process according to any one of claims 1 to 4, wherein the oxidising agent comprises copper oxide.

6. The process according to any one of claims 1 to 5, wherein the step of regenerating the oxidising agent comprises passing a gas containing oxygen through the reactor containing the oxidising agent to be regenerated.

7. The process according to any one of claims 1 to 6, wherein the metal, the dissolution of which liberates hydrogen gas, comprises uranium.

8. The process according to claim 7, wherein the metal is a uranium-aluminum alloy.

9. The process according to any one of claims 1 to 8, wherein the reactor is at least partially immersed in a bath comprising alumina.

10. The process according to claim 9, wherein the bath is supplied with one or more heating elements.

11. An apparatus for treating hydrogen gas liberated from acid or alkaline dissolution of a metal, the apparatus comprising a reactor containing an oxidising agent for the oxidation of hydrogen gas into water, wherein the reactor is at least partially immersed in a bath comprising alumina, and wherein the oxidising agent comprises a metal oxide in bulk form or a metal oxide finely dispersed on a surface of an inert support.

12. The apparatus according to claim 11, wherein the bath is supplied with one or more external heating elements.

13. The apparatus according to claim 11 or claim 12, wherein the oxidising agent is diluted with an inert, thermally-conductive diluent.

14. The apparatus according to claim 13, wherein the inert, thermally-conductive diluent comprises stainless steel pellets.

15. The apparatus according to any one of claims 11 to 14, wherein the oxidising agent comprises copper oxide.

16. A process of treating hydrogen gas liberated from acid or alkaline dissolution of a metal, the process comprising a step of passing the liberated hydrogen gas through a reactor containing an oxidising agent for oxidation of the hydrogen gas into water, wherein the oxidising agent comprises a metal oxide finely dispersed on an inert support and/or diluted with an inert, thermally-conductive diluent.

17. The process of claim 16, wherein the inert, thermally-conductive diluent comprises stainless steel pellets.

18. The process according to claim 16 or claim 17, further comprising a step of regenerating the oxidising agent.

19. The process according to any one of claims 16 to 18, wherein the metal oxide comprises copper oxide.

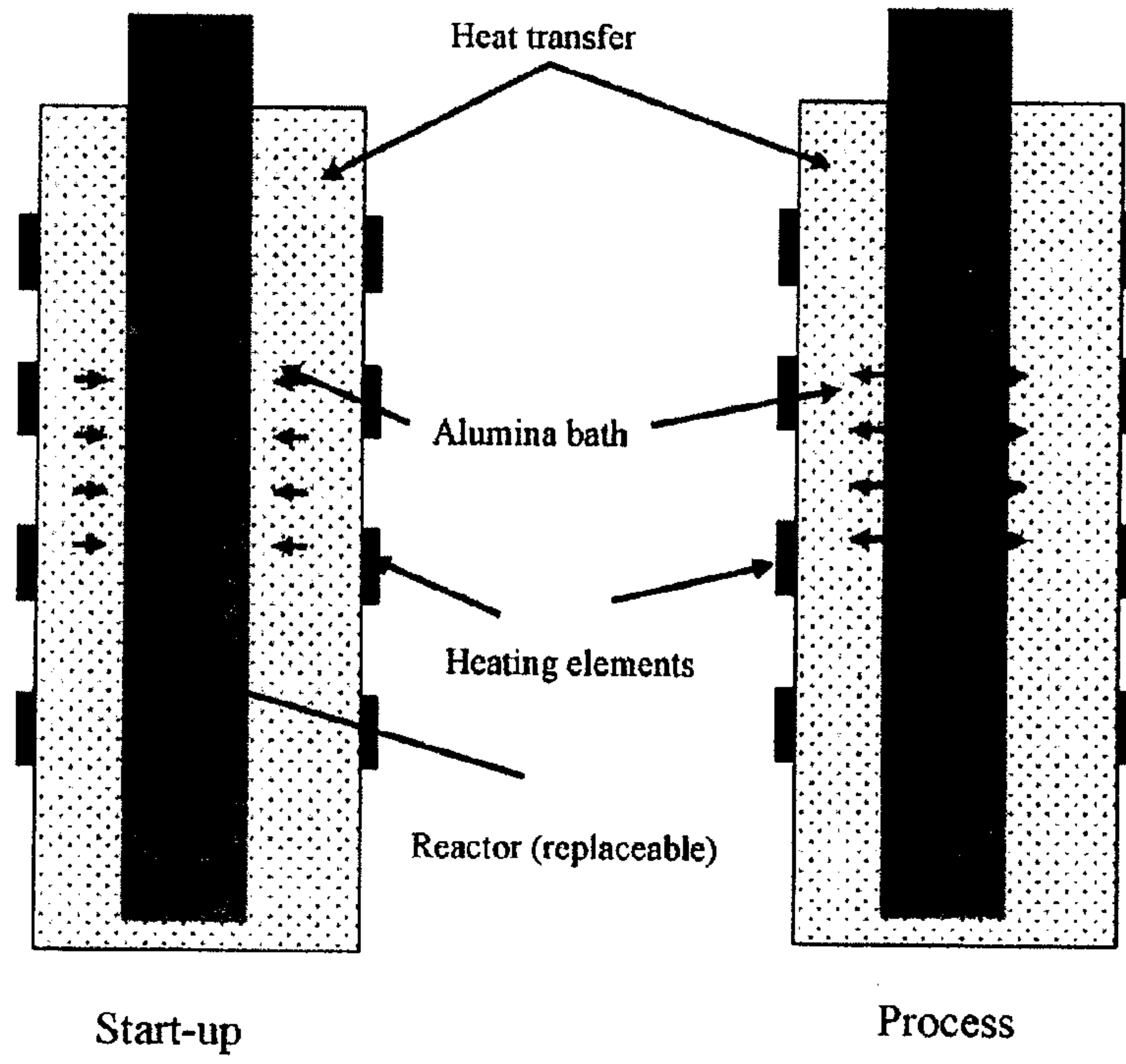


Figure 2

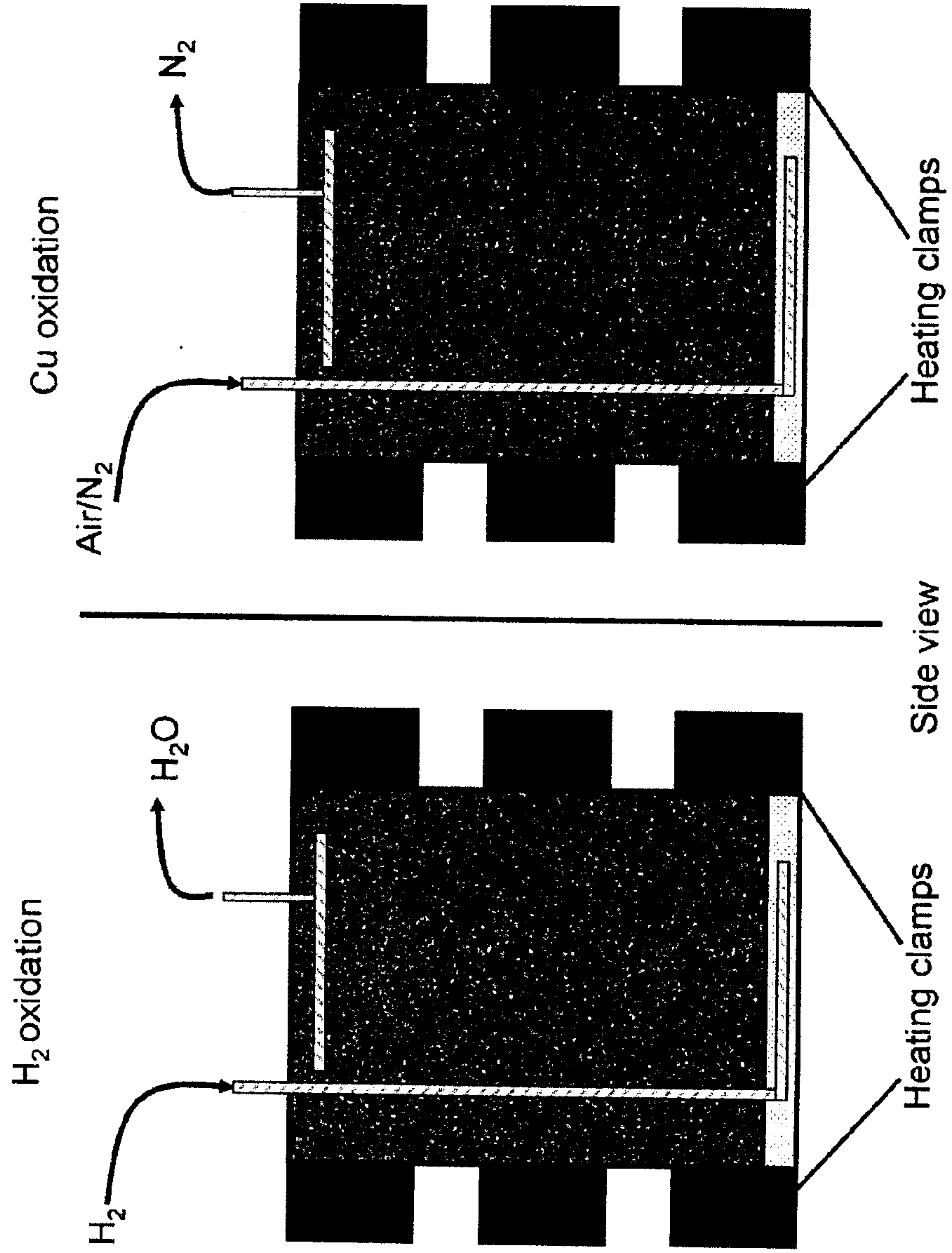


Figure 3